

# MTSB MINI SOLID CARBIDE THREAD MILL

# PROMO

BUY ONLY **2** PIECES OF  
MINI SOLID CARBIDE THREAD MILLS  
TYPE MTSB  
AND GET  
**25 % ADDITIONAL  
DISCOUNT**



MTSB with coolant bore,  
more flutes for high performance

Choose between 2 different MTSB Mini Solid Carbide Thread Mills.

When ordering 2 pieces (free combinable) you get 25 % additional discount.

The Promotion is **only** valid for MTSB Mini Solid Carbide Thread Mills.

Supervised by:



Please specify in your order  
the article numbers of the chosen  
Mini Solid Carbide Thread Mills  
and the promotion code: **MTSB-26**

# MTSB

Solid carbide thread mills with internal coolant bore and increased number of flutes for high performance, shorter cycle time and improved tool life

## Advantages

Enables machining in deep holes  
 Same tool can produce a wide range of threads and pitches  
 Spiral flutes allow smooth cutting action  
 Coolant through the flutes is very effective for deep holes

Shorter machining time due to multi (3 to 5) flutes  
 Longer tool life due to special triple coating

## Cutting Data

ISO Standard	Materials	Cutting speed Vc [m/min]	Feed Fz [mm/tooth]					
			Cutting Diameter=D					
			Ø1	Ø1.5	Ø2	Ø3	Ø4	Ø5
<b>P</b>	Low and Medium Carbon Steels < 0.55%C	60-120	0.04	0.05	0.05	0.07	0.09	0.11
	High Carbon Steels ≥ 0.55%C	90 60-	0.03	0.04	0.05	0.06	0.08	0.09
	Alloy Steels, Treated Steels	80 50-	0.03	0.04	0.04	0.05	0.05	0.06
<b>M</b>	Stainless Steel - Free Cutting	70-100	0.02	0.03	0.03	0.04	0.05	0.06
	Stainless Steel - Austenitic	90 60-	0.02	0.03	0.03	0.04	0.05	0.06
	Cast Steels	90 70-	0.03	0.04	0.04	0.05	0.05	0.06
<b>K</b>	Cast Iron	80 40-	0.04	0.05	0.05	0.07	0.09	0.11
<b>N</b>	Aluminum ≤ 12%Si, Copper	100-200	0.04	0.05	0.05	0.07	0.09	0.11
	Aluminum > 12%Si	60-140	0.03	0.03	0.03	0.04	0.05	0.06
	Synthetics, Duroplastics, Thermoplastics	50-200	0.09	0.10	0.11	0.12	0.14	0.16
<b>S</b>	Nickel Alloys, Titanium Alloys	40 20-	0.03	0.03	0.03	0.04	0.04	0.05
<b>H</b>	Hardened Steel, 45-50HRc	70 60-	0.03	0.04	0.04	0.05	0.05	0.06