

**MTS/MTSB MINI SOLID CARBIDE THREAD MILL**

**PROMO**

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



Choose between 2 different MTS/MTSB Mini Solid Carbide Thread Mills.

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

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

## MTS

- Threading from ISO M1 x 0.25 and 0-80UN.
- Working in high cutting speed.
- Short machining time.
- Low cutting forces thanks to the short profile.
- No broken taps.
- Machining of hardened materials up to 45 HRc.

## 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.
- Same tool can produce both External and Internal threads.
- 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<br>m/min | Feed mm/tooth        |      |      |      |      |      |      |      |      |      |      |      |      |      |
|--------------|--|------------------------|----------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|
|              |  |                        | Cutting Diameter = D |      |      |      |      |      |      |      |      |      |      |      |      |      |
|              |  |                        | Ø1                   | Ø1.5 | Ø2   | Ø3   | Ø4   | Ø5   | Ø6   | Ø7   | Ø8   | Ø9   | Ø10  | Ø12  | Ø14  | Ø16  |
| <b>P</b>     | Low and Medium Carbon Steels<br>0.55%C       | 60-120                 | 0.04                 | 0.05 | 0.05 | 0.07 | 0.09 | 0.11 | 0.13 | 0.14 | 0.15 | 0.16 | 0.16 | 0.17 | 0.18 | 0.18 |
|              | High Carbon Steels ≥ 0.55%C                  | 90 60-                 | 0.03                 | 0.04 | 0.05 | 0.06 | 0.08 | 0.09 | 0.10 | 0.12 | 0.13 | 0.14 | 0.14 | 0.16 | 0.17 | 0.18 |
|              | Alloy Steels, Treated Steels                 | 80 50-                 | 0.03                 | 0.04 | 0.04 | 0.05 | 0.05 | 0.06 | 0.07 | 0.07 | 0.08 | 0.09 | 0.10 | 0.12 | 0.13 | 0.14 |
| <b>M</b>     | Stainless Steels - Free Cutting              | 70-100                 | 0.02                 | 0.03 | 0.03 | 0.04 | 0.05 | 0.06 | 0.06 | 0.07 | 0.08 | 0.09 | 0.10 | 0.11 | 0.12 | 0.13 |
|              | Stainless Steels - Austenitic                | 90 60-                 | 0.02                 | 0.03 | 0.03 | 0.04 | 0.05 | 0.06 | 0.06 | 0.07 | 0.08 | 0.09 | 0.10 | 0.11 | 0.12 | 0.13 |
|              | Cast Steels                                  | 90 70-                 | 0.03                 | 0.04 | 0.04 | 0.05 | 0.05 | 0.06 | 0.07 | 0.07 | 0.08 | 0.09 | 0.10 | 0.12 | 0.13 | 0.14 |
| <b>K</b>     | Cast Iron                                    | 80 40-                 | 0.04                 | 0.05 | 0.05 | 0.07 | 0.09 | 0.11 | 0.13 | 0.14 | 0.15 | 0.16 | 0.16 | 0.17 | 0.18 | 0.18 |
| <b>N</b>     | Aluminum ≤12%Si, Copper                      | 100-200                | 0.04                 | 0.05 | 0.05 | 0.07 | 0.09 | 0.11 | 0.13 | 0.14 | 0.15 | 0.16 | 0.16 | 0.17 | 0.18 | 0.18 |
|              | Aluminum 12% Si                              | 60-140                 | 0.03                 | 0.03 | 0.03 | 0.04 | 0.05 | 0.06 | 0.06 | 0.07 | 0.08 | 0.09 | 0.10 | 0.11 | 0.13 | 0.14 |
|              | , Synthetics, Duroplastics<br>Thermoplastics | 50-200                 | 0.09                 | 0.10 | 0.11 | 0.12 | 0.14 | 0.16 | 0.18 | 0.19 | 0.19 | 0.19 | 0.19 | 0.19 | 0.20 | 0.20 |
| <b>S</b>     | Nickel Alloys and Titanium Alloys            | 40 20-                 | 0.03                 | 0.03 | 0.03 | 0.04 | 0.04 | 0.05 | 0.06 | 0.06 | 0.06 | 0.07 | 0.07 | 0.07 | 0.08 | 0.08 |