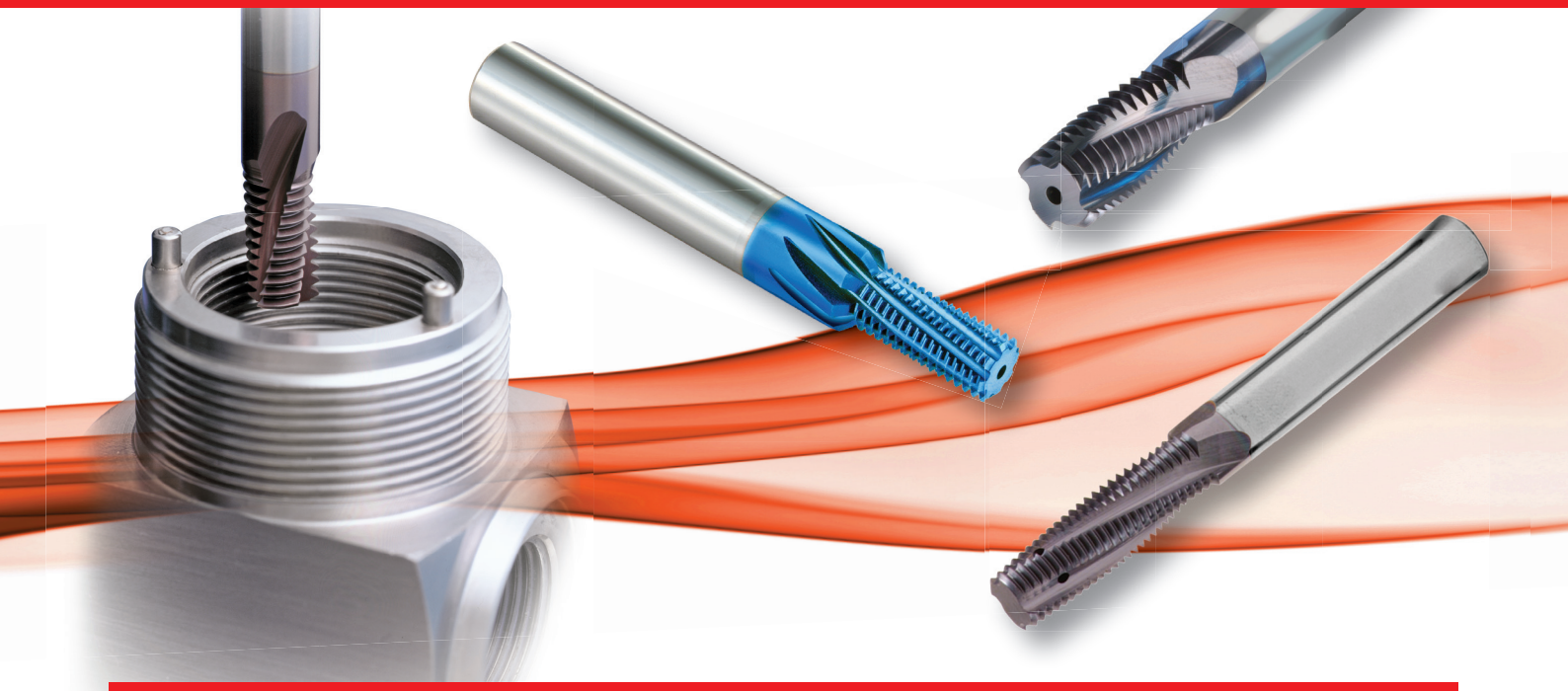
Mill-Thread Solid Carbide | B08



Advantages of Mill-Thread Solid Carbide

- Thread is generated in one pass.
- Spiral flutes allow smooth cutting action.
- Shorter machining time due to multi, 3 to 6 flutes.
- 2.2 mm and up cutting diameter.
- Threads up to shoulder in blind hole.
- Longer tool life due to special multi-layer coating.
- Same tool can be used for a variety of materials.
- Excellent surface finish.
- Low cutting pressure allows thin wall machining.
- Same tool used for R.H and L.H. threads.

Demonstration

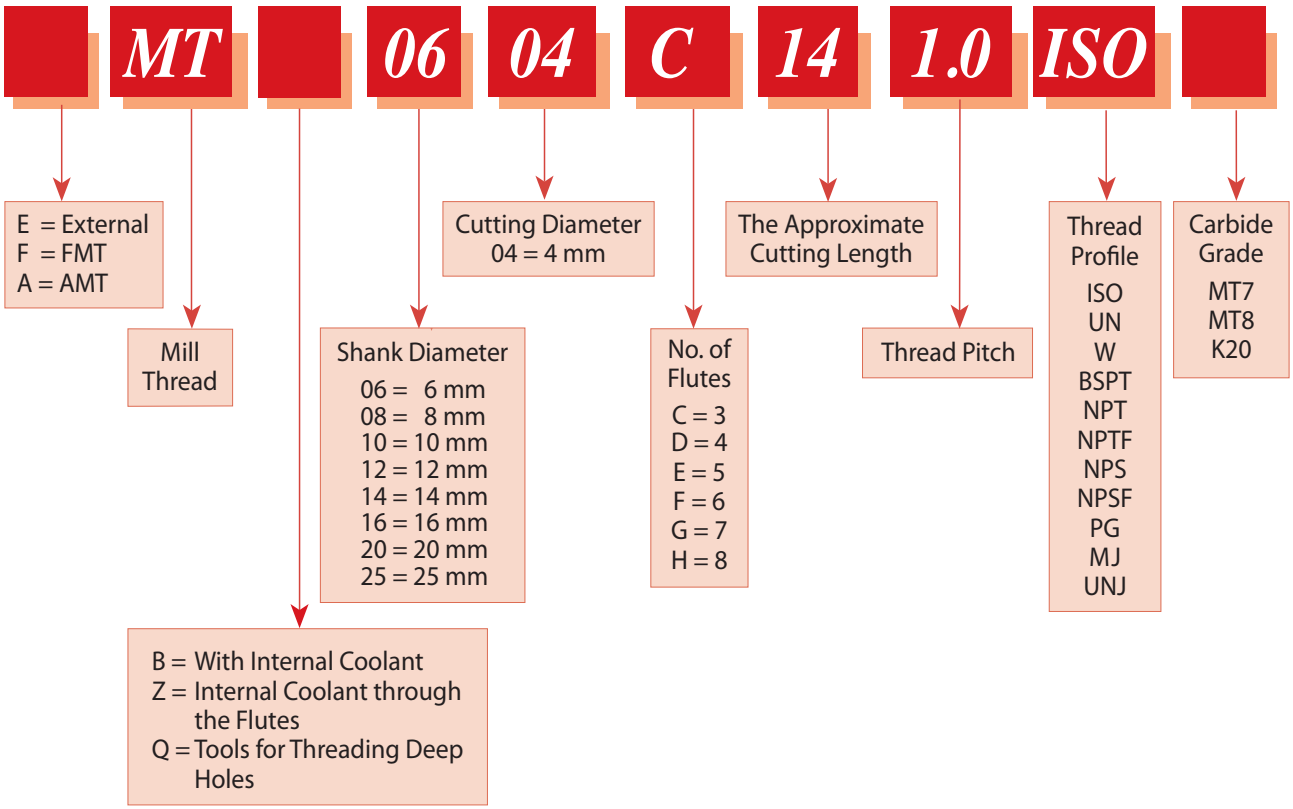
MT - Thread Mills without internal coolant
MTB - Thread Mills with internal coolant bore for blind holes
MTZ - Thread Mills with internal coolant through the flutes
MTQ - Thread Mills that include relieved neck for deep work pieces
FMT - Fast Thread Mills with internal coolant bore
AMT - Solid Carbide Thread Mills for Aluminum machining
EMT - Thread Mills For External Threads

Demonstration

Contents: Page:

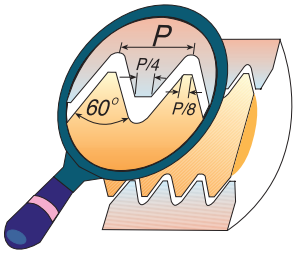
Product Identification

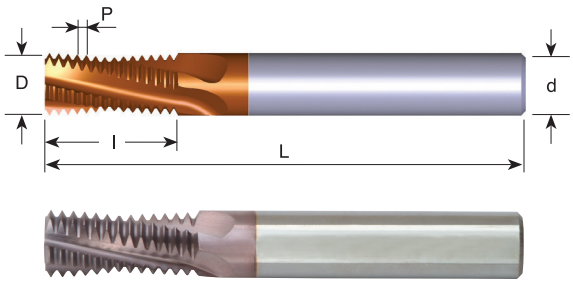
Mill-Thread Solid Carbide Ordering Codes



ISO

Tools for Internal Thread





Grade	P	M	K	N	S	H
MT7	●	○	●	○	○	

Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	l	L
0.5	M3	M4	MT 06022 C5 0.5 ISO	6	2.2	3	5.3	58
0.5		M5	MT 06038 C10 0.5 ISO	6	3.8	3	10.3	58
0.5		M6, M8	MT 06053 D10 0.5 ISO	6	5.3	4	10.3	58
0.7	M4		MT 06031 C7 0.7 ISO	6	3.1	3	7.4	58
0.75		M6, M8	MT 06045 C10 0.75 ISO	6	4.5	3	10.1	58
0.75		M6, M8	MT 0605 C13 0.75 ISO	6	5.0	3	13.1	58
0.8	M5		MT 06036 C9 0.8 ISO	6	3.6	3	9.2	58
0.8	M5		MT 0604 C13 0.8 ISO	6	4.0	3	13.2	58
1.0	M6	M8	MT 0604 C10 1.0 ISO	6	4.0	3	10.5	58
1.0	M6	M8	MT 0604 C14 1.0 ISO	6	4.0	3	14.5	58
1.0		M9	MT 0606 C12 1.0 ISO	6	6.0	3	12.5	58
1.0		M10	MT 0808 D16 1.0 ISO	8	8.0	4	16.5	64
1.25	M8	M10	MT 0605 C14 1.25 ISO	6	5.0	3	14.4	58
1.25	M8	M10	MT 0605 C19 1.25 ISO	6	5.0	3	19.4	58
1.5	M10	M12	MT 0807 C17 1.5 ISO	8	7.0	3	17.3	64
1.5	M10	M12	MT 0807 C24 1.5 ISO	8	7.0	3	24.8	76
1.5		M14	MT 1010 D21 1.5 ISO	10	10.0	4	21.8	73
1.5		M14	MT 1212 D29 1.5 ISO	12	12.0	4	29.3	84
1.5		M16, M18	MT 1414 D32 1.5 ISO	14	14.0	4	32.3	84
1.5		M20	MT 1616 F33 1.5 ISO	16	16.0	6	33.8	105
1.75	M12		MT 0808 C20 1.75 ISO	8	8.0	3	20.1	64
1.75	M12		MT 0808 C28 1.75 ISO	8	8.0	3	28.9	76
2.0	M14	M17	MT 1010 C27 2.0 ISO	10	10.0	3	27.0	73
2.0	M14	M17	MT 1010 C39 2.0 ISO	10	10.0	3	39.0	105
2.0	M16	M18, M20	MT 1212 D27 2.0 ISO	12	12.0	4	27.0	84
2.0	M16	M18, M20	MT 14128 D39 2.0 ISO	14	12.8	4	39.0	105
2.0		M26	MT 2020 F41 2.0 ISO	20	20.0	6	41.0	105
2.5	M18, M20		MT 1414 D33 2.5 ISO	14	14.0	4	33.8	84
2.5	M18, M20		MT 1414 D48 2.5 ISO	14	14.0	4	48.8	105
3.0	M24	M28	MT 1616 C40 3.0 ISO	16	16.0	3	40.5	105
3.0	M24	M28	MT 1616 C58 3.0 ISO	16	16.0	3	58.5	120
3.0	M27	M28, M30	MT 2020 D43 3.0 ISO	20	20.0	4	43.5	105

Order example: MT 1212 D27 2.0 ISO MT7

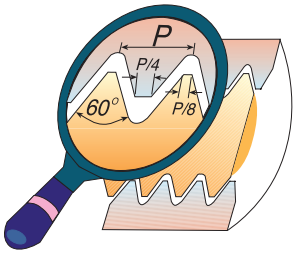
● First choice ○ Alternative

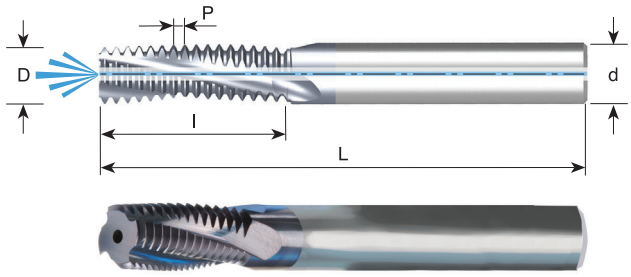
For thread mills with coolant bore see following pages

For small thread mills see pages B09-3, 4, 11, 15, 17 and B11-3, 6

ISO With internal coolant bore

Tools for Internal Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	l	L
0.5		M5	**MTB 06038 C10 0.5 ISO**	6	3.8	3	10.3	58
0.7	M4		**MTB 06031 C7 0.7 ISO**	6	3.1	3	7.4	58
0.75		M6, M8	**MTB 06045 C10 0.75 ISO**	6	4.5	3	10.1	58
0.75		M12, M14	**MTB 1010 D24 0.75 ISO**	10	10.0	4	24.4	73
0.8	M5		**MTB 06038 C9 0.8 ISO**	6	3.8	3	9.2	58
0.8	M5		**MTB 0604 C13 0.8 ISO**	6	4.0	3	13.2	58
1.0	M6		**MTB 06046 C10 1.0 ISO**	6	4.6	3	10.5	58
1.0	M6		**MTB 06046 C14 1.0 ISO**	6	4.6	3	14.5	58
1.0		M8	**MTB 0606 C12 1.0 ISO**	6	6.0	3	12.5	58
1.0		M10	**MTB 0808 D16 1.0 ISO**	8	8.0	4	16.5	64
1.0		M12	**MTB 1010 D24 1.0 ISO**	10	10.0	4	24.5	73
1.25	M8	M10	**MTB 0606 C14 1.25 ISO**	6	6.0	3	14.4	58
1.25	M8	M10	**MTB 0606 C19 1.25 ISO**	6	6.0	3	19.4	58
1.5	M10	M12	**MTB 08078 C17 1.5 ISO**	8	7.8	3	17.0	64
1.5	M10	M12	**MTB 08078 C24 1.5 ISO**	8	7.8	3	24.8	76
1.5		M14	**MTB 1010 D21 1.5 ISO**	10	10.0	4	21.8	73
1.5		M14-M18	**MTB 1212 D26 1.5 ISO**	12	12.0	4	26.3	84
1.5		M20	**MTB 1616 F33 1.5 ISO**	16	16.0	6	33.8	105
1.75	M12		**MTB 1009 C20 1.75 ISO**	10	9.0	3	20.1	73
1.75	M12		**MTB 1009 C28 1.75 ISO**	10	9.0	3	28.9	73
2.0	M14	M17	**MTB 1010 C27 2.0 ISO**	10	10.0	3	27.0	73
2.0	M14	M17	**MTB 1211 D39 2.0 ISO**	12	11.0	4	39.0	105
2.0	M16	M18, M20	**MTB 12118 D27 2.0 ISO**	12	11.8	4	27.0	84
2.0	M16	M18, M20	**MTB 12118 D39 2.0 ISO**	12	11.8	4	39.0	105
2.0		M26	**MTB 2020 F41 2.0 ISO**	20	20.0	6	41.0	105
2.5	M20		**MTB 1615 E33 2.5 ISO**	16	15.0	5	33.8	105
2.5	M20		**MTB 1615 E48 2.5 ISO**	16	15.0	5	48.8	105
3.0	M24	M28	**MTB 2018 D40 3.0 ISO**	20	18.0	4	40.5	105
3.0	M24	M28	**MTB 2018 D58 3.0 ISO**	20	18.0	4	58.5	120
3.0	M27	M28, M30	**MTB 2020 D43 3.0 ISO**	20	20.0	4	43.5	105

Order example: MTB 08078 C17 1.5 ISO MT7

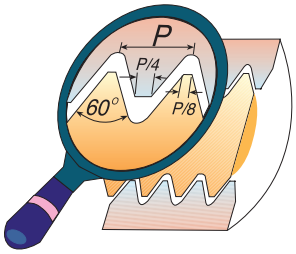
● First choice ○ Alternative

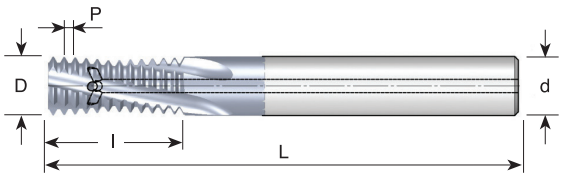
For thread mills with coolant through the flutes see next page

For small thread mills see pages B09-3, 4, 11, 15, 17 and B11-3, 6

ISO With internal coolant through the flutes

Tools for Internal Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	l	L
1.0	M6	M8	**MTZ 06048 C10 1.0 ISO**	6	4.8	3	10.5	58
1.0		M8, M9	**MTZ 0606 C12 1.0 ISO**	6	6.0	3	12.5	58
1.0		M10	**MTZ 0808 D16 1.0 ISO**	8	8.0	4	16.5	64
1.25	M8	M10	**MTZ 0606 C14 1.25 ISO**	6	6.0	3	14.4	58
1.25	M8	M10	**MTZ 0606 C19 1.25 ISO**	6	6.0	3	19.4	58
1.5	M10	M12	**MTZ 08078 C17 1.5 ISO**	8	7.8	3	17.0	64
1.5	M10	M12	**MTZ 0808 C23 1.5 ISO**	8	8.0	3	23.3	64
1.5		M14	**MTZ 1010 D21 1.5 ISO**	10	10.0	4	21.8	73
1.5		M14, M16	**MTZ 1212 D26 1.5 ISO**	12	12.0	4	26.3	84
1.5		M16, M18	**MTZ 1414 D32 1.5 ISO**	14	14.0	4	32.3	101
1.5		M20	**MTZ 1616 E33 1.5 ISO**	16	16.0	5	33.8	101
1.75	M12		**MTZ 1009 C20 1.75 ISO**	10	9.0	3	20.1	73
1.75	M12		**MTZ 1009 C28 1.75 ISO**	10	9.0	3	28.9	73
2.0	M14	M17	**MTZ 1010 C27 2.0 ISO**	10	10.0	3	27.0	73
2.0	M16	M18, M20	**MTZ 12118 D27 2.0 ISO**	12	11.8	4	27.0	84
2.5	M20		**MTZ 1615 E33 2.5 ISO**	16	15.0	5	33.8	101

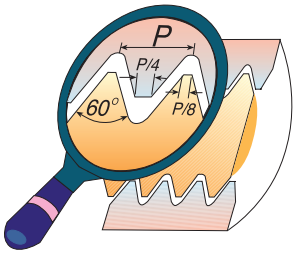
Order example: MTZ 08078 C17 1.5 ISO MT7

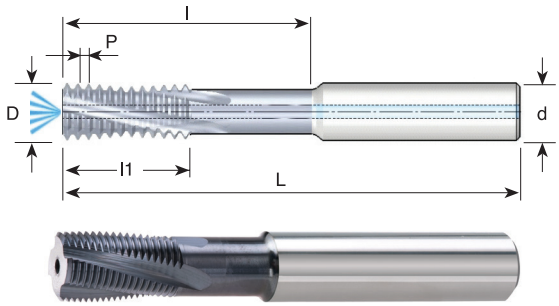
● First choice ○ Alternative

For small thread mills see pages B09-3, 4, 11, 15, 17 and B11-3, 6

ISO With relieved neck and internal coolant bore

Tools for Internal Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch mm	M fine	Ordering Code	d	D	No. of Flutes	l1	l	L
1.0	Ø ≥ 12	**MTQ 1010 D32 1.0 ISO**	10	10.0	4	18.0	32.0	73
1.0	Ø ≥ 14	**MTQ 1212 D38 1.0 ISO**	12	12.0	4	21.0	38.0	84
1.0	Ø ≥ 18	**MTQ 1616 F45 1.0 ISO**	16	16.0	6	26.0	45.0	105
1.5	Ø ≥ 13	**MTQ 1010 D30 1.5 ISO**	10	10.0	4	18.0	30.0	73
1.5	Ø ≥ 15	**MTQ 1212 D34 1.5 ISO**	12	12.0	4	19.5	34.5	84
1.5	Ø ≥ 19	**MTQ 1616 F43 1.5 ISO**	16	16.0	6	25.5	43.5	105
1.5	Ø ≥ 23	**MTQ 2020 F60 1.5 ISO**	20	20.0	6	36.0	60.0	105
2.0	Ø ≥ 16	**MTQ 1212 D42 2.0 ISO**	12	12.0	4	24.0	42.0	84
2.0	Ø ≥ 20	**MTQ 1616 E45 2.0 ISO**	16	16.0	5	26.0	45.0	105
2.0	Ø ≥ 24	**MTQ 2020 F56 2.0 ISO**	20	20.0	6	34.0	56.0	105
3.0	Ø ≥ 22	**MTQ 1616 D45 3.0 ISO**	16	16.0	4	30.0	45.0	105
3.0	Ø ≥ 26	**MTQ 2020 E54 3.0 ISO**	20	20.0	5	33.0	54.0	105
3.5	Ø ≥ 26	**MTQ 2020 D45 3.5 ISO**	20	20.0	4	28.0	45.5	105
4.0	Ø ≥ 31	**MTQ 2525 D64 4.0 ISO**	25	25.0	4	40.0	64.0	160

Order example: MTQ 1010 D30 1.5 ISO MT7

● First choice ○ Alternative

For small thread mills see pages B09-3, 4, 11, 15, 17 and B11-3, 6

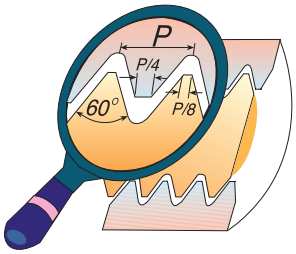
ISO Fast MT with internal coolant bore

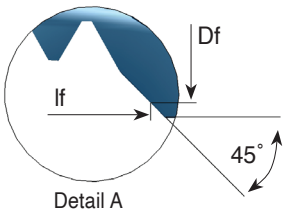
Tools for Internal Thread

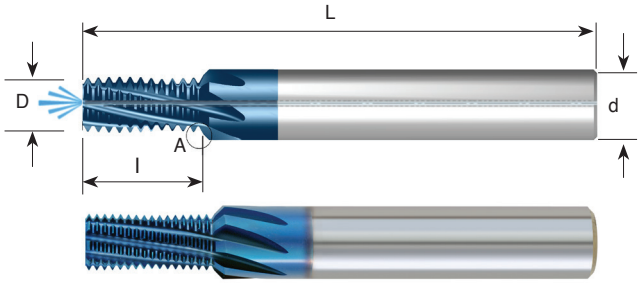
- **A unique line of solid carbide thread milling tools (FMT) for increased productivity and extended tool life.**
- **Large number of flutes results in significantly shorter machining time.**

Carbide grade MT8:

Sub Micron grade with advanced PVD triple coating (ISO K10-K20).
Extremely high heat resistance and smooth cutting operation for high performance in normal and general machining conditions on all materials.







Grade	P	M	K	N	S	H
MT8	●	●	●	○	●	≤52 HRc

Pitch mm	M coarse	M fine	Ordering Code	d	D	Df	Flutes	l	lf	L
0.5	M3	M3.5	***FMT 06024 D6 0.5 ISO**	6	2.4	4.4	4	6.3	7.3	58
0.5		M4,M5	**FMT 06033 E8 0.5 ISO**	6	3.3	5.3	5	8.3	9.3	58
0.7	M4		**FMT 06032 E7 0.7 ISO**	6	3.2	4.8	5	7.4	8.2	58
0.75		M6	**FMT 0805 F12 0.75 ISO**	8	5.0	7.0	6	12.4	13.4	64
0.8	M5		**FMT 0604 E9 0.8 ISO**	6	4.0	5.7	5	9.2	10.1	58
1.0	M6	M8	**FMT 08048 F10 1.0 ISO**	8	4.8	6.8	6	10.5	11.5	64
1.0		M10,M12	**FMT 12087 G20 1.0 ISO**	12	8.7	11.7	7	20.5	22.0	84
1.25	M8	M10	**FMT 10064 G14 1.25 ISO**	10	6.4	9.6	7	14.4	16.0	73
1.5	M10	M14	**FMT 1008 G17 1.5 ISO**	10	8.0	9.8	7	17.3	18.2	73
1.75	M12		**FMT 12095 G20 1.75 ISO**	12	9.5	11.7	7	20.1	21.2	84
2.0	M14, M16	M18	**FMT 1411 G29 2.0 ISO**	14	11.0	13.4	7	29.0	30.2	83

Order example: FMT 1008 G17 1.5 ISO MT8

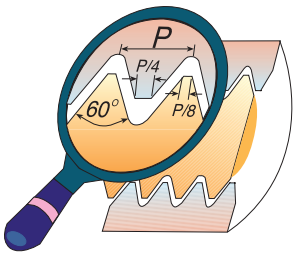
● First choice ○ Alternative

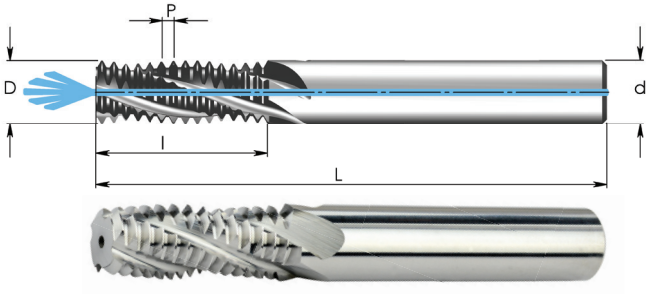
* Without internal coolant

For small thread mills see page B09-17

ISO With internal coolant bore

Tools for Internal Thread





Thread length: 2xD

Grade	P	M	K	N	S	H
K20	○	○	●	●	●	

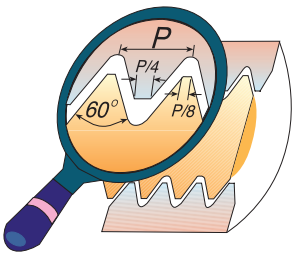
Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	l	L
0.5	M3	M4	* AMT 03024 C6 0.5 ISO	3	2.4	3	6.8	39
0.5		M5	AMT 06043 C10 0.5 ISO	6	4.3	3	10.8	58
0.7	M4		AMT 06031 C8 0.7 ISO	6	3.1	3	8.8	58
0.75		M6	AMT 0605 C13 0.75 ISO	6	5.0	3	13.1	58
0.8	M5		AMT 0604 C10 0.8 ISO	6	4.0	3	10.8	58
1.0	M6		AMT 06048 C13 1.0 ISO	6	4.8	3	13.5	58
1.0		M10	AMT 0808 D21 1.0 ISO	8	8.0	4	21.5	64
1.25	M8	M10	AMT 08064 C16 1.25 ISO	8	6.4	3	16.9	64
1.5	M10		AMT 0808 C21 1.5 ISO	8	8.0	3	21.8	64
1.5		M14	AMT 12112 D29 1.5 ISO	12	11.2	4	29.3	84
1.75	M12		AMT 10095 D25 1.75 ISO	10	9.5	4	25.4	73
2.0	M16	M17	AMT14126 D35 2.0 ISO	14	12.6	4	35.0	83

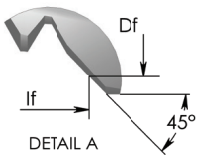
Order example: AMT 08064 C16 1.25 ISO K20

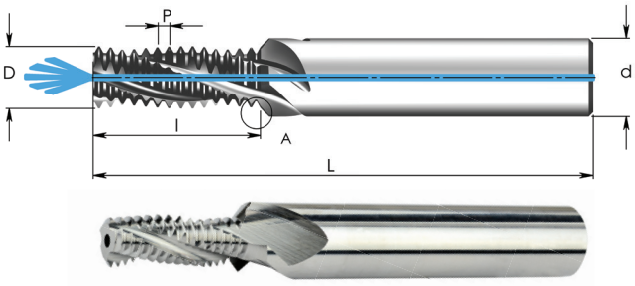
* Without internal coolant

ISO With internal coolant bore and cutting chamfer

Tools for Internal thread







Thread length: 2xD

Grade	P	M	K	N	S	H
K20	○	○	●	●	●	

Pitch mm	M coarse	M fine	Ordering Code	d	D	Df	No. of Flutes	l	If	L
0.8	M5		AMT 0604 C10 0.8 ISO-C	6	4.0	5.3	3	10.8	11.5	58
1.0	M6		AMT 08048 C13 1.0 ISO-C	8	4.8	6.4	3	13.5	14.3	64
1.25	M8	M10	AMT 10064 C16 1.25 ISO-C	10	6.4	8.3	3	16.9	17.9	73
1.5	M10		AMT 1208 C21 1.5 ISO-C	12	8.0	10.4	3	21.8	23.0	84

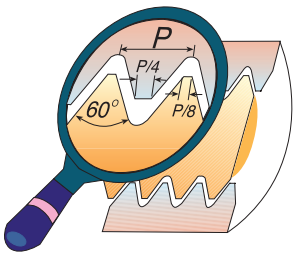
Order example: AMT 10064 C16 1.25 ISO-C K20

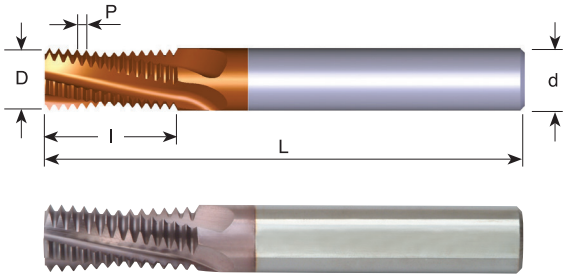
For information about AMT Thread Mills and cutting data see page B12-16

● First choice ○ Alternative

UN

Tools for Internal Thread





Grade	P	M	K	N	S	H
MT7	●	○	●	○	○	

Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	l	L
40	5			**MT 06025 C6 40 UN**	6	2.5	3	6.0	58
32	8	10	12	**MT 06032 C6 32 UN**	6	3.2	3	6.8	58
28		1/4		**MT 0604 C11 28 UN**	6	4.0	3	11.3	58
28		1/4		**MT 06052 C15 28 UN**	6	5.2	3	15.0	58
28			7/16-1/2	**MT 0606 C14 28 UN**	6	6.0	3	14.1	58
24		5/16		**MT 0605 C14 24 UN**	6	5.0	3	14.3	58
24		3/8	9/16-5/8	**MT 0807 C21 24 UN**	8	7.0	3	20.6	64
20	1/4			**MT 06045 C12 20 UN**	6	4.5	3	12.1	58
20		7/16-1/2		**MT 0807 C21 20 UN**	8	7.0	3	21.0	64
20			3/4-1	**MT 1212 E27 20 UN**	12	12.0	5	27.3	84
18	5/16			**MT 0605 C14 18 UN**	6	5.0	3	14.8	58
18	5/16			**MT 0606 C20 18 UN**	6	6.0	3	20.5	58
18		9/16-5/8	1 1/8-1 5/8	**MT 1010 D26 18 UN**	10	10.0	4	26.1	73
16	3/8			**MT 0606 C16 16 UN**	6	6.0	3	16.7	58
16	3/8			**MT 08074 C24 16 UN**	8	7.4	3	24.6	64
16		3/4		**MT 1212 D31 16 UN**	12	12.0	4	31.0	84
14	7/16			**MT 0807 C20 14 UN**	8	7.0	3	20.9	64
14	7/16			**MT 10085 C28 14 UN**	10	8.5	3	28.1	73
14		7/8		**MT 1615 E37 14 UN**	16	15.0	5	37.2	105
13	1/2			**MT 0808 C22 13 UN**	8	8.0	3	22.5	64
13	1/2			**MT 10098 D32 13 UN**	10	9.8	4	32.2	73
12	9/16			**MT 1010 C26 12 UN**	10	10.0	3	26.5	73
12	9/16			**MT 12116 D37 12 UN**	12	11.6	4	37.0	84
12		1-1 1/2		**MT 1616 E41 12 UN**	16	16.0	5	41.3	105
11	5/8			**MT 1010 C28 11 UN**	10	10.0	3	28.9	73
11	5/8			**MT 1212 D38 11 UN**	12	12.0	4	38.1	84
10	3/4			**MT 1212 C34 10 UN**	12	12.0	3	34.3	84
10	3/4			**MT 16147 E49 10 UN**	16	14.7	5	49.5	105
9	7/8			**MT 1615 C38 9 UN**	16	15.0	3	38.1	105
8	1			**MT 1616 C42 8 UN**	16	16.0	3	42.9	105
7	1 1/8 - 1 1/4			**MT 2020 D45 7 UN**	20	20.0	4	45.3	105

Order example: MT 1615 E37 14 UN MT7

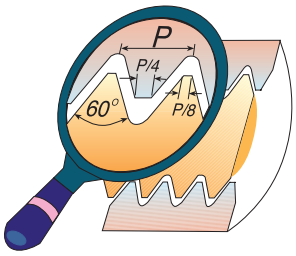
● First choice ○ Alternative

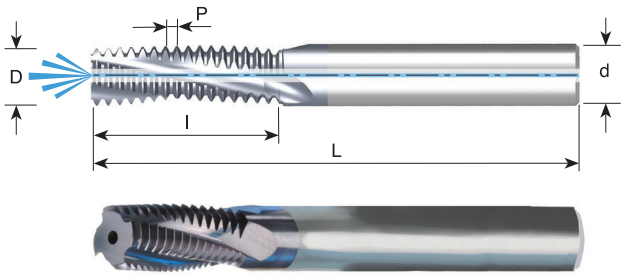
For thread mills with coolant bore see following pages

For small thread mills see pages B09-5, 6, 12, 15, 17 and B11-4, 6

UN With internal coolant bore

Tools for Internal Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	l	L
32	8	10	12	**MTB 06032 C6 32 UN**	6	3.2	3	6.8	58
32			5/16	**MTB 0606 C14 32 UN**	6	6.0	3	14.7	58
32			3/8	**MTB 0808 D18 32 UN**	8	8.0	4	18.7	64
28		1/4		**MTB 0605 C11 28 UN**	6	5.0	3	11.3	58
28		1/4		**MTB 06052 C15 28 UN**	6	5.2	3	15.0	58
28			7/16-1/2	**MTB 0606 C14 28 UN**	6	6.0	3	14.1	58
24		5/16		**MTB 08066 C14 24 UN**	8	6.6	3	14.3	64
24		3/8	9/16-5/8	**MTB 0808 D21 24 UN**	8	8.0	4	20.6	64
20	1/4			**MTB 06047 C12 20 UN**	6	4.7	3	12.1	58
20		7/16-1/2		**MTB 0808 C21 20 UN**	8	8.0	3	21.0	64
20		1/2		**MTB 1010 D22 20 UN**	10	10.0	4	22.3	73
20			3/4-1	**MTB 1212 E27 20 UN**	12	12.0	5	27.3	84
18	5/16			**MTB 06056 C14 18 UN**	6	5.6	3	14.8	58
18	5/16			**MTB 0606 C20 18 UN**	6	6.0	3	20.5	58
18		9/16-5/8	1 1/8-1 5/8	**MTB 12113 D26 18 UN**	12	11.3	4	26.1	84
16	3/8			**MTB 08067 C16 16 UN**	8	6.7	3	16.7	64
16	3/8			**MTB 08074 C24 16 UN**	8	7.4	3	24.6	64
16		3/4		**MTB 1212 D31 16 UN**	12	12.0	4	31.0	84
14	7/16			**MTB 08077 C20 14 UN**	8	7.7	3	20.9	64
14	7/16			**MTB 10085 C28 14 UN**	10	8.5	3	28.1	73
14		7/8		**MTB 1616 E37 14 UN**	16	16.0	5	37.2	105
13	1/2			**MTB 10092 C22 13 UN**	10	9.2	3	22.5	73
13	1/2			**MTB 10098 D32 13 UN**	10	9.8	4	32.2	73
12	9/16			**MTB 12105 C26 12 UN**	12	10.5	3	26.5	84
12	9/16			**MTB 12116 D37 12 UN**	12	11.6	4	37.0	84
12		1-1 1/2		**MTB 1616 E41 12 UN**	16	16.0	5	41.3	105
11	5/8			**MTB 12114 C28 11 UN**	12	11.4	3	28.9	84
11	5/8			**MTB 1212 D38 11 UN**	12	12.0	4	38.1	84
10	3/4			**MTB 16144 D34 10 UN**	16	14.4	4	34.3	105
10	3/4			**MTB 16147 E49 10 UN**	16	14.7	5	49.5	105
9	7/8			**MTB 1616 C38 9 UN**	16	16.0	3	38.1	105
8	1			**MTB 20195 D42 8 UN**	20	19.5	4	42.9	105
7	1 1/8 - 1 1/4			**MTB 2020 D45 7 UN**	20	20.0	4	45.3	105

Order example: MTB 1212 D31 16 UN MT7

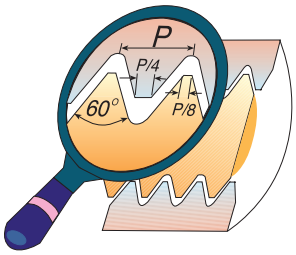
● First choice ○ Alternative

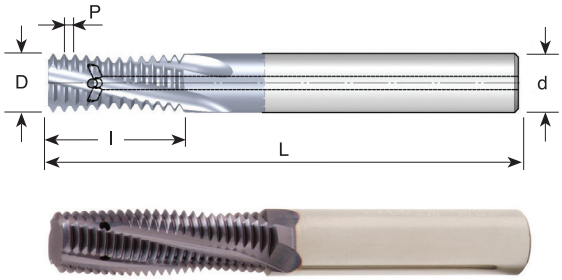
For thread mills with coolant through the flutes see next page

For small thread mills see pages B09-5, 6, 12, 15, 17 and B11-4, 6

UN With internal coolant through the flutes

Tools for Internal Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	l	L
28		1/4		**MTZ 0605 C11 28 UN**	6	5.0	3	11.3	58
28			7/16-1/2	**MTZ 0606 C14 28 UN**	6	6.0	3	14.1	58
24		5/16		**MTZ 08066 C14 24 UN**	8	6.6	3	14.3	64
24		3/8	9/16-5/8	**MTZ 0808 D21 24 UN**	8	8.0	4	20.6	64
20		7/16		**MTZ 0808 C21 20 UN**	8	8.0	3	21.0	64
20		1/2		**MTZ 1010 D22 20 UN**	10	10.0	4	22.3	73
20			3/4-1	**MTZ 1212 E27 20 UN**	12	12.0	5	27.3	84
18	5/16			**MTZ 06056 C14 18 UN**	6	5.6	3	14.8	58
18	5/16			**MTZ 0606 C20 18 UN**	6	6.0	3	20.5	58
18		9/16-5/8	1 1/8-1 5/8	**MTZ 12113 D26 18 UN**	12	11.3	4	26.1	84
16	3/8			**MTZ 08067 C16 16 UN**	8	6.7	3	16.7	64
16	3/8			**MTZ 08074 C24 16 UN**	8	7.4	3	24.6	64
16		3/4		**MTZ 1212 D31 16 UN**	12	12.0	4	31.0	84
14	7/16			**MTZ 08077 C20 14 UN**	8	7.7	3	20.9	64
14	7/16			**MTZ 10085 C28 14 UN**	10	8.5	3	28.1	73
14		7/8		**MTZ 1616 E37 14 UN**	16	16.0	5	37.2	101
13	1/2			**MTZ 10092 C22 13 UN**	10	9.2	3	22.5	73
13	1/2			**MTZ 10098 D32 13 UN**	10	9.8	4	32.2	73
12	9/16			**MTZ 12105 C26 12 UN**	12	10.5	3	26.5	84
12	9/16			**MTZ 12116 D37 12 UN**	12	11.6	4	37.0	84
12		1-1 1/2		**MTZ 1616 E41 12 UN**	16	16.0	5	41.3	101
11	5/8			**MTZ 12114 C28 11 UN**	12	11.4	3	28.9	84
10	3/4			**MTZ 16144 D34 10 UN**	16	14.4	4	34.3	105

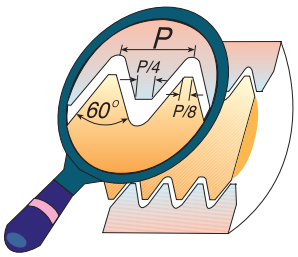
Order example: MTZ 0808 D21 24 UN MT7

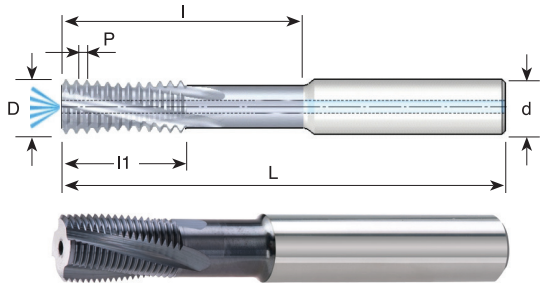
● First choice ○ Alternative

For small thread mills see pages B09-5, 6, 12, 15, 17 and B11-4, 6

UN With relieved neck and internal coolant bore

Tools for Internal Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	Thread size	Ordering Code	d	D	No. of Flutes	l1	l	L
20	Ø ≥ 12	**MTQ 1010 D30 20 UN**	10	10.0	4	17.8	30.5	73
20	Ø ≥ 14	**MTQ 1212 E35 20 UN**	12	12.0	5	20.3	35.6	84
20	Ø ≥ 18	**MTQ 1616 F43 20 UN**	16	16.0	6	25.4	43.2	105
18	Ø ≥ 15	**MTQ 1212 D35 18 UN**	12	12.0	4	19.7	35.3	84
16	Ø ≥ 15	**MTQ 1212 D35 16 UN**	12	12.0	4	20.7	35.0	84
16	Ø ≥ 19	**MTQ 1616 E42 16 UN**	16	16.0	5	25.4	42.9	105
16	Ø ≥ 23	**MTQ 2020 F58 16 UN**	20	20.0	6	36.5	58.8	105
14	Ø ≥ 20	**MTQ 1616 E45 14 UN**	16	16.0	5	25.4	45.3	105
12	Ø ≥ 16	**MTQ 1212 D42 12 UN**	12	12.0	4	25.4	42.3	84
12	Ø ≥ 24	**MTQ 2020 E55 12 UN**	20	20.0	5	33.9	55.1	105

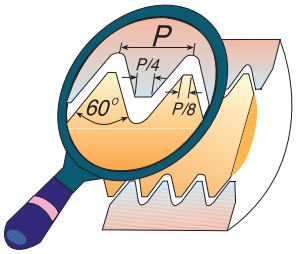
Order example: MTQ 1212 D35 16 UN MT7

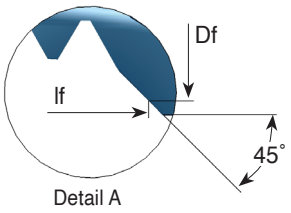
● First choice ○ Alternative

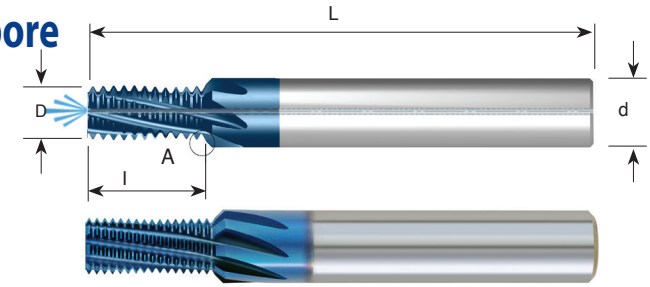
For small thread mills see pages B09-5, 6, 12, 15, 17 and B11-4, 6

UN Fast MT with internal coolant bore

Tools for Internal Thread







Grade	P	M	K	N	S	H
MT8	●	●	●	○	●	≤52 HRc

Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	Df	No. of Flutes	l	lf	L
28		1/4		**FMT 08052 F11 28 UN**	8	5.2	7.0	6	11.3	12.3	64
28			7/16-1/2	**FMT 12098 H19 28 UN**	12	9.8	11.8	8	19.5	20.5	84
24		5/16		**FMT 10066 G14 24 UN**	10	6.6	9.6	7	14.3	15.8	73
24		3/8	9/16, 5/8, 11/16	**FMT 12082 G17 24 UN**	12	8.2	10.6	7	17.5	18.7	84
20	1/4			***FMT 08048 E12 20 UN**	8	4.8	6.8	5	12.1	13.1	64
20		7/16		**FMT 12092 H21 20 UN**	12	9.2	11.4	8	21.0	22.1	84
20		1/2	3/4, 7/8, 1	**FMT 14111 H22 20 UN**	14	11.1	13.5	8	22.2	23.4	84
18	5/16			**FMT 1006 F14 18 UN**	10	6.0	8.4	6	14.8	16.0	73
18		9/16, 5/8	1 1/16, 1 1/8	**FMT 16125 H26 18 UN**	16	12.5	15.0	8	26.1	27.4	105
16	3/8			**FMT 10074 F16 16 UN**	10	7.4	9.6	6	16.7	17.8	73
16		3/4		**FMT 20167 H34 16 UN**	20	16.7	19.3	8	34.1	35.4	105
14	7/16	7/8		**FMT 12085 F20 14 UN**	12	8.5	10.7	6	20.9	22.0	84
13	1/2			**FMT 12098 F24 13 UN**	12	9.8	11.8	6	24.4	25.4	84
12	9/16	1		**FMT 16116 F26 12 UN**	16	11.6	15.2	6	26.5	28.3	105
11	5/8			**FMT 1612 F33 11 UN**	16	12.0	15.4	6	33.4	35.1	105

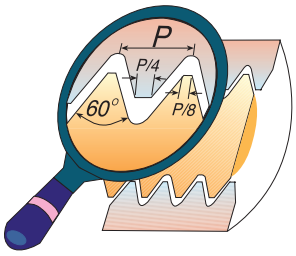
Order example: FMT 12092 H21 20 UN

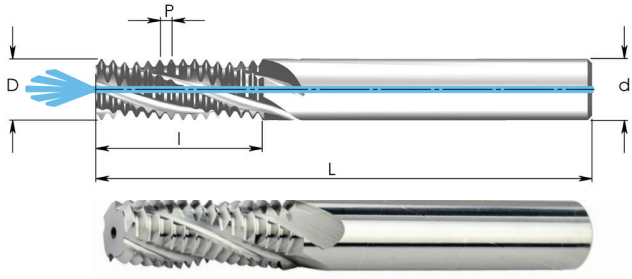
* without internal coolant

For small thread mills see page B09-17

UN With internal coolant bore

Tools for Internal Thread





Thread length: 2xD

Grade	P	M	K	N	S	H
K20	○	○	●	●	●	

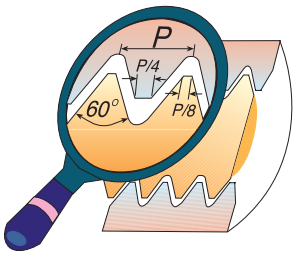
Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	l	L
32	8	10	12	**AMT 06032 C9 32 UN**	6	3.2	3	9.1	58
28		1/4		**AMT 06052 C14 28 UN**	6	5.2	3	14.0	58
24		3/8	9/16-5/8	**AMT 0808 D20 24 UN**	8	8.0	4	20.6	64
20	1/4			**AMT 06048 C14 20 UN**	6	4.8	3	14.6	58
20		7/16		**AMT 10092 C23 20 UN**	10	9.2	3	23.5	73
18	5/16			**AMT 0606 C17 18 UN**	6	6.0	3	17.6	58
18		9/16-5/8	1 1/8 - 1 5/8	**AMT 1212 D30 18 UN**	12	12.0	4	30.3	84
16	3/8			**AMT 08074 C21 16 UN**	8	7.4	3	21.4	64
16		3/4		**AMT 1616 E38 16 UN**	16	16.0	5	38.9	105

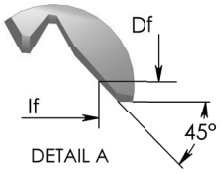
For information about AMT Thread Mills and cutting data see page B12-16

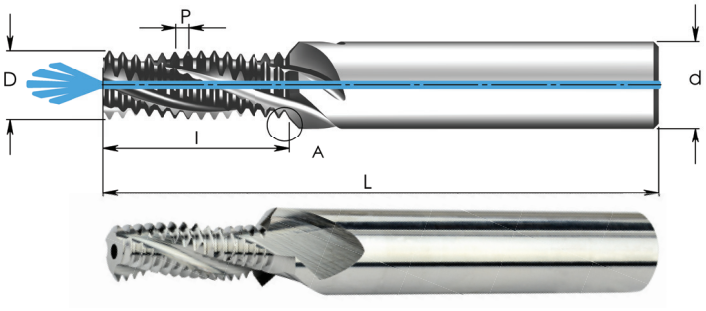
● First choice ○ Alternative

UN With internal coolant bore and cutting chamfer

Tools for Internal Thread







Thread length: 2xD

Grade	P	M	K	N	S	H
K20	○	○	●	●	●	

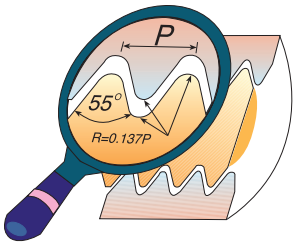
Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	Df	No. of Flutes	l	lf	L
20	1/4			**AMT 08048 C14 20UN-C**	8	4.8	6.8	3	14.6	15.6	64
18	5/16			**AMT 1006 C17 18UN-C**	10	6.0	8.4	3	17.6	18.8	73
16	3/8			**AMT 12074 C21 16UN-C**	12	7.4	10.0	3	21.4	22.7	84

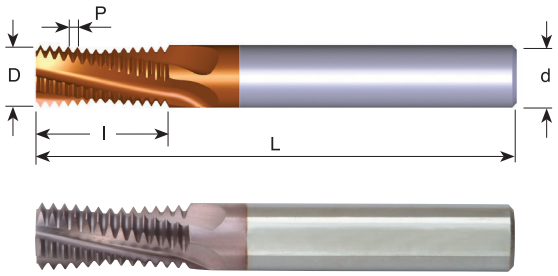
Order example: AMT 12074 C21 16UN-C K20

For information about AMT Thread Mills and cutting data see page B12-16

G (55°) BSF, BSP

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	○	●	○	○	

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
28	G1/16-G1/8	**MT 0606 C9 28 W**	6	6.0	3	9.5	58
19	G1/4-3/8	**MT 0808 C14 19 W**	8	8.0	3	14.0	64
14	G1/2-7/8	**MT 1212 D19 14 W**	12	12.0	4	19.0	84
14	G1/2-7/8	**MT 1212 D26 14 W**	12	12.0	4	26.3	84
11	G≥1	**MT 1212 C24 11 W**	12	12.0	3	24.2	84
11	G≥1	**MT 1616 D38 11 W**	16	16.0	4	38.1	105
11	G≥1	**MT 2020 E47 11 W**	20	20.0	5	47.3	105

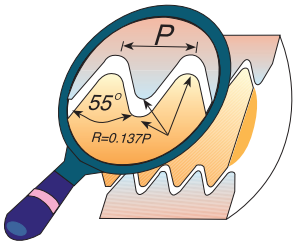
Order example: MT 1212 D19 14 W MT7

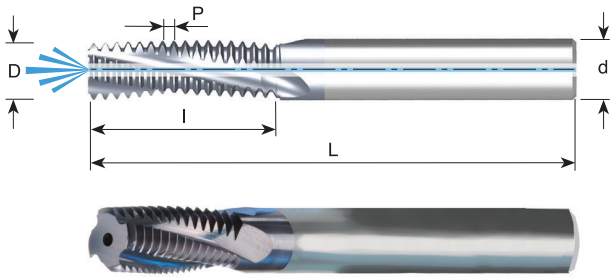
For small thread mills see pages B09-7, B09-14 and B11-5
For thread mills with coolant see next page

● First choice ○ Alternative

G (55°) BSF, BSP With internal coolant bore

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

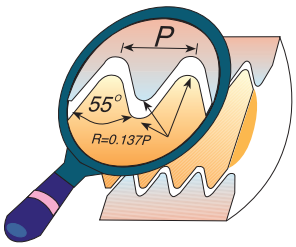
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
28	G1/8	**MTB 08078 C14 28 W**	8	7.8	3	14.1	64
28	G1/8	**MTB 0808 C20 28 W**	8	8.0	3	20.4	64
19	G1/4	**MTB 1010 D16 19 W**	10	10.0	4	16.7	73
19	G1/4	**MTB 1211 D27 19 W**	12	11.0	4	27.4	84
19	G3/8	**MTB 1414 D26 19 W**	14	14.0	4	26.1	83
19	G3/8	**MTB 1414 D34 19 W**	14	14.0	4	34.1	83
14	G1/2-7/8	**MTB 1616 E26 14 W**	16	16.0	5	26.3	105
11	G≥1	**MTB 1616 D38 11 W**	16	16.0	4	38.1	105
11	G≥1	**MTB 2020 E47 11 W**	20	20.0	5	47.3	105

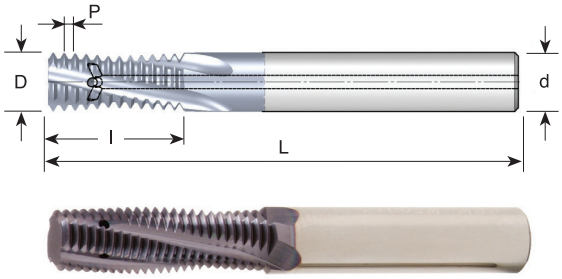
Order example: MTB 1010 D16 19 W MT7

For small thread mills see pages B09-7, B09-14 and B11-5

G (55°) BSF, BSP With internal coolant through the flutes

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
28	G1/8	**MTZ 08078 C14 28 W**	8	7.8	3	14.1	64
19	G1/4-3/8	**MTZ 1010 D16 19 W**	10	10.0	4	16.7	73
14	G1/2-7/8	**MTZ 1616 E26 14 W**	16	16.0	5	26.3	101
11	G≥1	**MTZ 1616 D38 11 W**	16	16.0	4	38.1	101

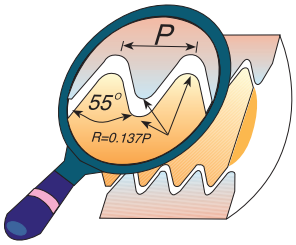
Order example: MTZ 08078 C14 28 W MT7

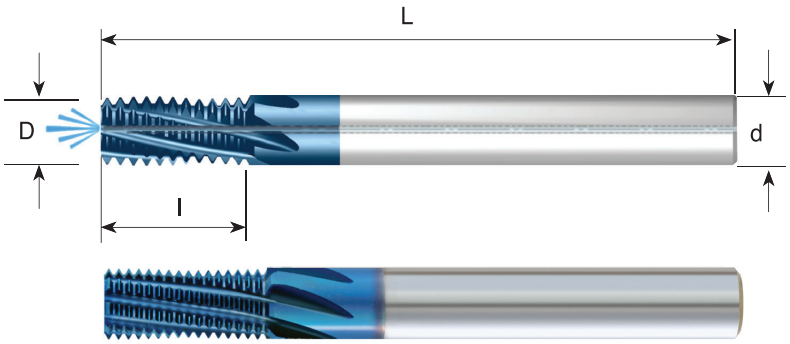
For small thread mills see pages B09-7, B09-14 and B11-5

● First choice ○ Alternative

G (55°) Fast MT With internal coolant bore

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT8	●	●	●	○	●	≤52 HRc

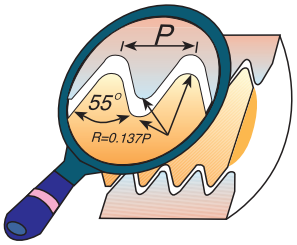
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
28	G1/8	**FMT 08078 H14 28 W**	8	7.8	8	14.1	64
19	G1/4-3/8	**FMT 1010 G16 19 W**	10	10.0	7	16.7	73
14	G1/2-7/8	**FMT 1414 H26 14 W**	14	14.0	8	26.3	84
11	G≥1	**FMT 1616 H38 11 W**	16	16.0	8	38.1	105

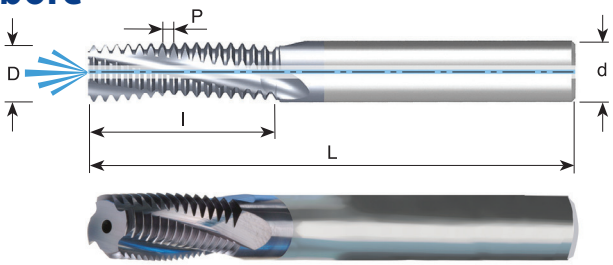
Order example: FMT 1616 H38 11W MT8

● First choice ○ Alternative

Whitworth With internal coolant bore

Same Tool for Internal and External Thread





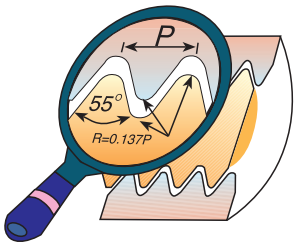
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

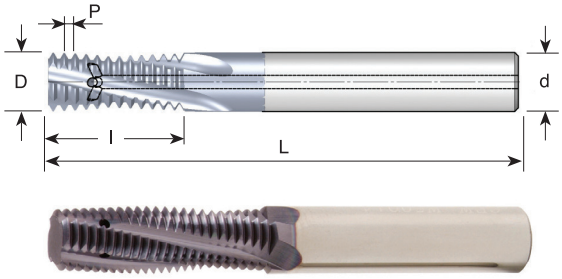
Pitch TPI	BSW	BSF	Ordering Code	d	D	No. of Flutes	l	L
20	1/4		**MTB 06046 C13 20 W**	6	4.6	3	13.3	58
20		3/8	**MTB 08076 D19 20 W**	8	7.6	4	19.7	64
18	5/16		**MTB 06056 C16 18 W**	6	5.6	3	16.2	58
18		7/16	**MTB 10088 D23 18 W**	10	8.8	4	23.3	73
16	3/8		**MTB 0807 D19 16 W**	8	7.0	4	19.8	64
16		1/2-9/16	**MTB 1010 E26 16 W**	10	10.0	5	26.1	73
14	7/16		**MTB 0808 D22 14 W**	8	8.0	4	22.7	64
14		5/8-11/16	**MTB 14128 E31 14 W**	14	12.8	5	31.8	83
12	1/2-9/16	3/4-13/16	**MTB 1009 D26 12 W**	10	9.0	4	26.5	73
11	5/8	7/8	**MTB 12118 E33 11 W**	12	11.8	5	33.5	84
10	3/4	1	**MTB 1414 E39 10 W**	14	14.0	5	39.4	105
9	7/8	1 1/8	**MTB 1616 E43 9 W**	16	16.0	5	43.7	105

Order example: MTB 06046 C13 20 W MT7

Whitworth With internal coolant through the flutes

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	BSW	BSF	Ordering Code	d	D	No. of Flutes	l	L
20	1/4	3/8	* **MTZ 06046 C12 20 W**	6	4.6	3	12.1	58
18	5/16	7/16	**MTZ 06053 C14 18 W**	6	5.3	3	14.8	58
16	3/8		**MTZ 08068 C16 16 W**	8	6.8	3	16.7	64
16		1/2-9/16	**MTZ 10092 D24 16 W**	10	9.2	4	24.6	73
14	7/16	5/8-11/16	**MTZ 08078 D20 14 W**	8	7.8	4	20.9	64
12	1/2	3/4-13/16	**MTZ 10086 D24 12 W**	10	8.6	4	24.4	73
11	5/8	7/8	**MTZ 12109 D28 11 W**	12	10.9	4	28.9	84

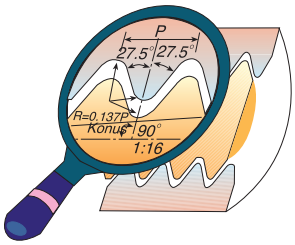
Order example: MTZ 08068 C16 16 W MT7

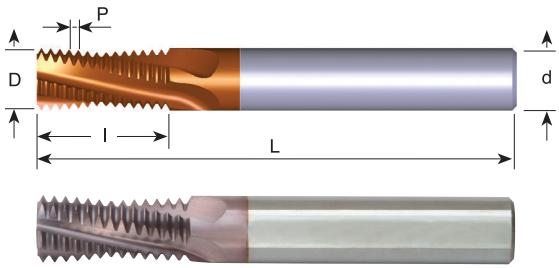
* Cutter without coolant

● First choice ○ Alternative

BSPT

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	○	●	○	○	

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
28	RC1/16-1/8	**MT 0606 C9 28 BSPT**	6	6.0	3	9.5	58
19	RC1/4-3/8	**MT 0808 C14 19 BSPT**	8	8.0	3	14.0	64
14	RC1/2-7/8	**MT 1212 D19 14 BSPT**	12	12.0	4	19.1	84
11	RC1-2	**MT 1616 D28 11 BSPT**	16	16.0	4	28.9	105

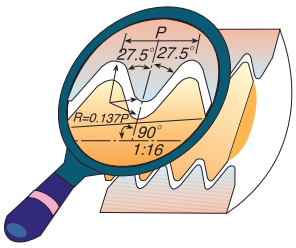
Order example: MT 1616 D28 11 BSPT MT7

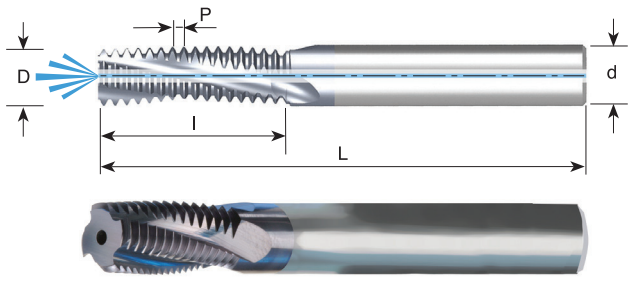
For thread mills with coolant through the flutes see next page

For conical preparation end mills see page B08-23

BSPT With internal coolant bore

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

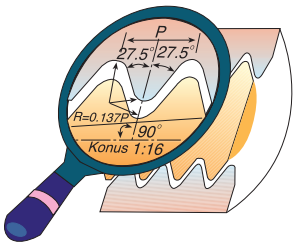
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
28	RC1/8	**MTB 08078 C14 28 BSPT**	8	7.8	3	14.1	64
19	RC1/4-3/8	**MTB 1010 D16 19 BSPT**	10	10.0	4	16.7	73
14	RC1/2-7/8	**MTB 1616 E26 14 BSPT**	16	16.0	5	26.3	105
11	RC1-2	**MTB 1616 D28 11 BSPT**	16	16.0	4	28.9	105

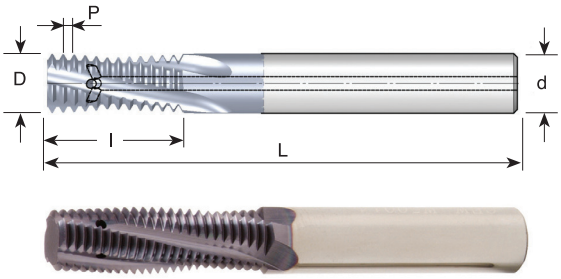
Order example: MTB 08078 C14 28 BSPT MT7

● First choice ○ Alternative

BSPT With internal coolant through the flutes

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
28	RC1/8	**MTZ 08078 C14 28 BSPT**	8	7.8	3	14.1	64
19	RC1/4-3/8	**MTZ 1010 D16 19 BSPT**	10	10.0	4	16.7	73
14	RC1/2-7/8	**MTZ 1616 E26 14 BSPT**	16	16.0	5	26.3	101
11	RC1-2	**MTZ 1616 D28 11 BSPT**	16	16.0	4	28.9	101

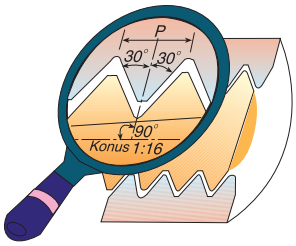
Order example: MTZ 1010 D16 19 BSPT MT7

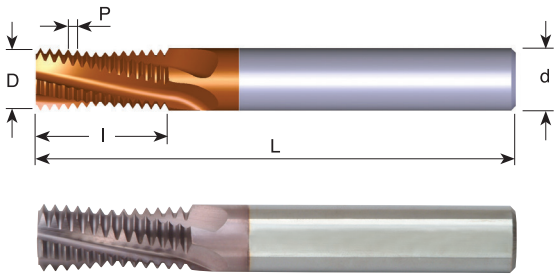
● First choice ○ Alternative

For conical preparation end mills see page B08-23

NPT

Same Tool for Internal and External Thread





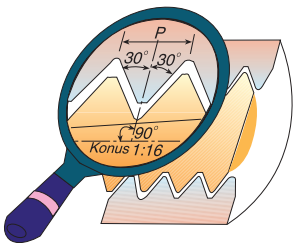
Grade	P	M	K	N	S	H
MT7	●	○	●	○	○	

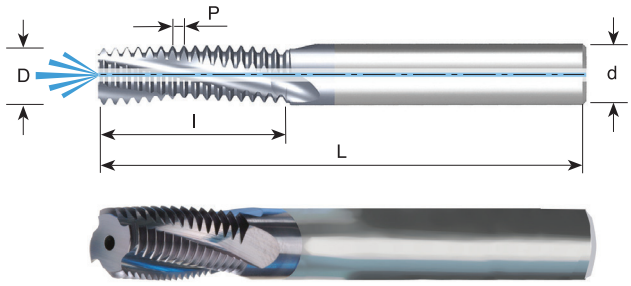
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
27	1/16-1/8	**MT 0606 C9 27 NPT**	6	6.0	3	9.9	58
18	1/4-3/8	**MT 0808 C14 18 NPT**	8	8.0	3	14.8	64
14	1/2-3/4	**MT 1212 D20 14 NPT**	12	12.0	4	20.9	84
11.5	1-2	**MT 1616 D27 11.5 NPT**	16	16.0	4	27.6	105
8	≥2 1/2	**MT 2020 D39 8 NPT**	20	20.0	4	39.7	105

Order example: MT 0808 C14 18 NPT MT7

NPT With internal coolant bore

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
27	1/8	**MTB 08076 C10 27 NPT**	8	7.6	3	10.8	64
18	1/4-3/8	**MTB 1010 D16 18 NPT**	10	10.0	4	16.2	73
14	1/2-3/4	**MTB 16155 D22 14 NPT**	16	15.5	4	22.7	105
11.5	1-2	**MTB 2020 D29 11.5 NPT**	20	20.0	4	29.8	105
8	≥2 1/2	**MTB 2020 D39 8 NPT**	20	20.0	4	39.7	105

Order example: MTB 1010 D16 18 NPT MT7

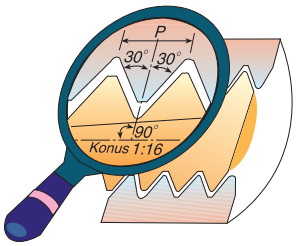
For thread mills with coolant through the flutes see next page

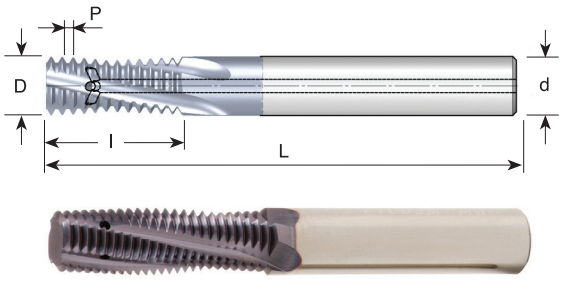
For conical preparation end mills see page B08-23

● First choice ○ Alternative

NPT With internal coolant through the flutes

Same Tool for Internal and External Thread





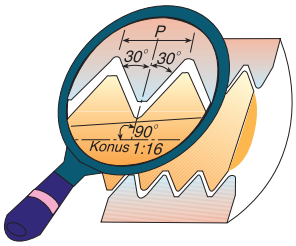
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

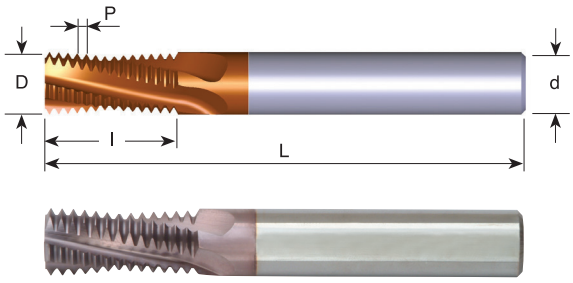
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
27	1/8	**MTZ 08076 C10 27 NPT**	8	7.6	3	10.8	64
18	1/4-3/8	**MTZ 1010 D16 18 NPT**	10	10.0	4	16.2	73
14	1/2-3/4	**MTZ 16155 D22 14 NPT**	16	15.5	4	22.7	101

Order example: MTZ 08076 C10 27 NPT MT7

NPTF

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	○	●	○	○	

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
27	1/16-1/8	**MT 0606 C9 27 NPTF**	6	6.0	3	9.9	58
18	1/4-3/8	**MT 0808 C14 18 NPTF**	8	8.0	3	14.8	64
14	1/2-3/4	**MT 1212 D20 14 NPTF**	12	12.0	4	20.9	84
11.5	1-2	**MT 1616 D27 11.5 NPTF**	16	16.0	4	27.6	105
8	≥2 1/2	**MT 2020 D39 8 NPTF**	20	20.0	4	39.7	105

Order example: MT 1212 D20 14 NPTF MT7

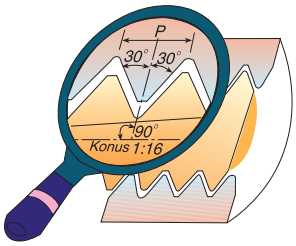
For thread mills with coolant bore see next page

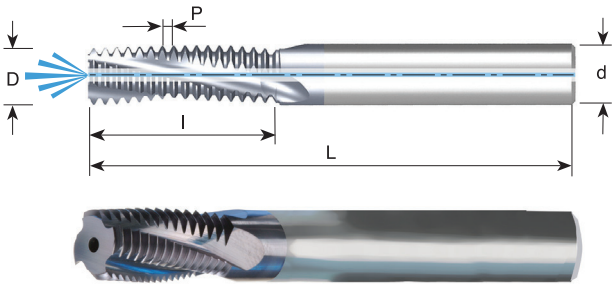
For conical preparation end mills see page B08-23

● First choice ○ Alternative

NPTF With internal coolant bore

Same Tool for Internal and External Thread





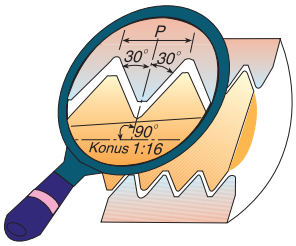
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

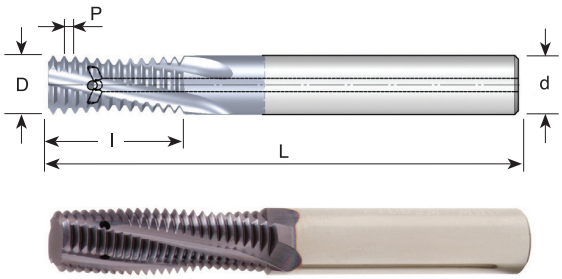
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
27	1/8	**MTB 08076 C10 27 NPTF**	8	7.6	3	10.8	64
18	1/4-3/8	**MTB 1010 D16 18 NPTF**	10	10.0	4	16.2	73
14	1/2-3/4	**MTB 16155 D22 14 NPTF**	16	15.5	4	22.7	105
11.5	1-2	**MTB 2020 D29 11.5 NPTF**	20	20.0	4	29.8	105
8	≥ 2 1/2	**MTB 2020 D39 8 NPTF**	20	20.0	4	39.7	105

Order example: MTB 16155 D22 14 NPTF MT7

NPTF With internal coolant through the flutes

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
27	1/8	**MTZ 08076 C10 27 NPTF**	8	7.6	3	10.8	64
18	1/4-3/8	**MTZ 1010 D16 18 NPTF**	10	10.0	4	16.2	73
14	1/2-3/4	**MTZ 16155 D22 14 NPTF**	16	15.5	4	22.7	101

Order example: MTZ 1010 D16 18 NPTF MT7

For conical preparation end mills see page B08-23

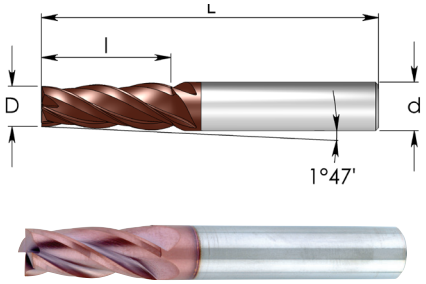
● First choice ○ Alternative

Solid Carbide Tapered End Mills

Solid carbide tapered end mills are used for milling preparation of conical threads before the thread milling operation.

Advantages:

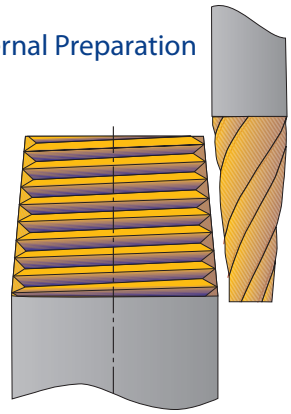
* Increases the tool life of mill thread cutters and indexable inserts.
* Equal and uniform load along the cutting edge of the mill thread cutter.
* Shorter machining time during the mill thread operation, due to the tapered preparation.
* Same tool for internal and external preparation.



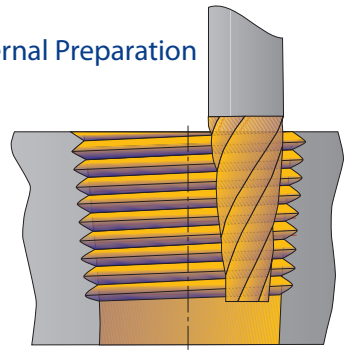
Ordering Code	d	D	l	L	No. of Flutes	Size
SC0652D12	6	5.2	12	58	4	NPT 1/16" - 1/8" NPTF 1/16" - 1/8" BSPT 1/16" - 1/8"
SC1085D24	10	8.5	24	73	4	NPT 1/4" - 1" NPTF 1/4" - 1" BSPT 1/4" - 1"
SC1210D32	12	10	32	84	4	NPT 1/4" - 3" NPTF 1/4" - 3" BSPT 1/4" - 3"

Order example: SC 1085 D24 MT7
Carbide grade: MT7

External Preparation

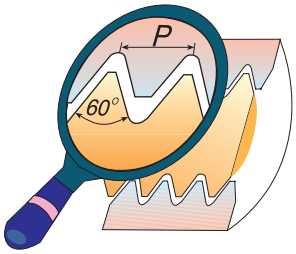


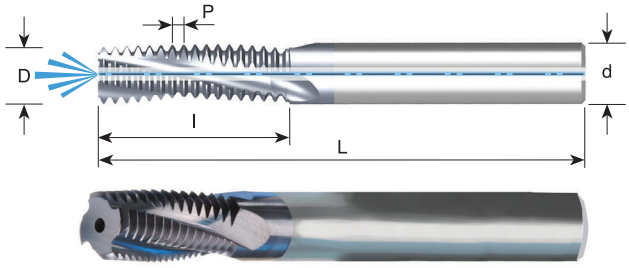
Internal Preparation



NPS With internal coolant bore

Same Tool for Internal and External Thread - Inch Shank





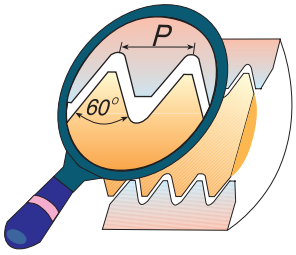
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

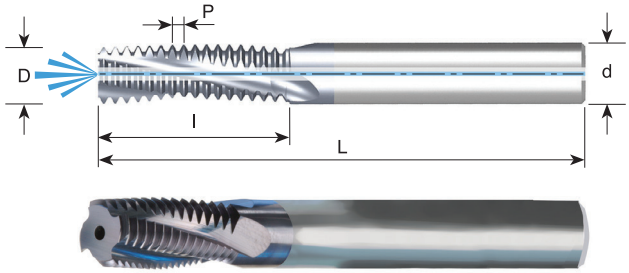
Pitch TPI	Standard	Ordering Code	d inch	D	No. of Flutes	l	L
27	1/8	**MTB 0312 C04 27 NPS**	5/16	7.6	3	10.8	63
18	1/4-3/8	**MTB 0375 D06 18 NPS**	3/8	9.5	4	16.2	76
14	1/2-3/4	**MTB 0625 D08 14 NPS**	5/8	15.5	4	22.7	101
11.5	1-2	**MTB 0750 D11 11.5 NPS**	3/4	19.0	4	29.8	101

Order example: MTB 0375 D06 18 NPS MT7

NPSF With internal coolant bore

Same Tool for Internal and External Thread - Inch Shank





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

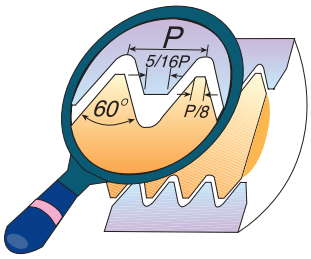
Pitch TPI	Standard	Ordering Code	d inch	D	No. of Flutes	l	L
27	1/8	**MTB 0312 C04 27 NPSF**	5/16	7.6	3	10.8	63
18	1/4-3/8	**MTB 0375 D06 18 NPSF**	3/8	9.5	4	16.2	76
14	1/2-3/4	**MTB 0625 D08 14 NPSF**	5/8	15.5	4	22.7	101
11.5	1-2	**MTB 0750 D11 11.5 NPSF**	3/4	19.0	4	29.8	101

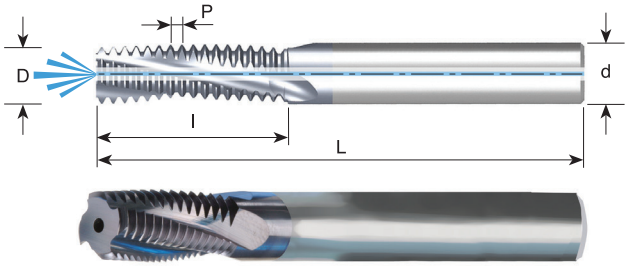
Order example: MTB 0312 C04 27 NPSF MT7

● First choice ○ Alternative

MJ With internal coolant bore

Tools for internal thread





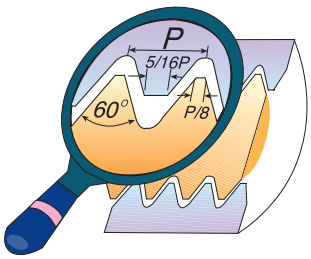
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

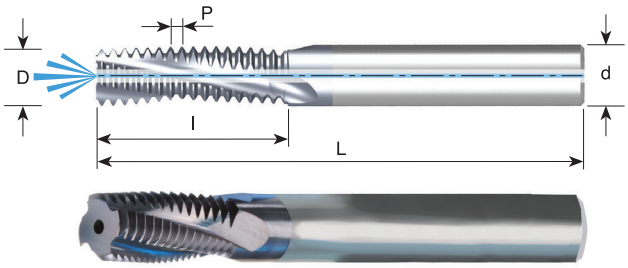
Pitch mm	Thread	Ordering Code	d	D	No. of Flutes	l	L
0.7	MJ4	**MTB 06032 C8 0.7 MJ**	6	3.2	3	8.1	58
0.8	MJ5	**MTB 0604 C10 0.8 MJ**	6	4.0	3	10.0	58
1.0	MJ6	**MTB 06048 D12 1.0 MJ**	6	4.8	4	12.5	58
1.25	MJ8	**MTB 08064 D15 1.25 MJ**	8	6.4	4	15.6	64
1.5	MJ10	**MTB 0808 D20 1.5 MJ**	8	8.0	4	20.3	64
1.75	MJ12	**MTB 10095 D23 1.75 MJ**	10	9.5	4	23.6	73

Order example: MTB 06048 D12 1.0 MJ MT7

UNJ With internal coolant bore

Tools for internal thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

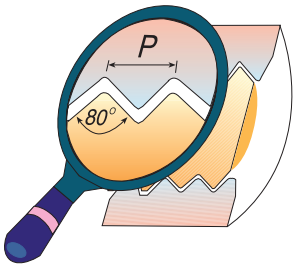
Pitch TPI	UNJC	UNJF	Ordering Code	d	D	No. of Flutes	l	L
28		1/4	**MTB 06052 D13 28 UNJ**	6	5.2	4	13.2	58
24		5/16	**MTB 08066 D16 24 UNJ**	8	6.6	4	16.4	64
24		3/8	**MTB 10082 D19 24 UNJ**	10	8.2	4	19.6	73
20	1/4		**MTB 06048 C13 20 UNJ**	6	4.8	3	13.3	58
20		7/16-1/2	**MTB 10092 D22 20 UNJ**	10	9.2	4	22.2	73
18	5/16		**MTB 0606 C16 18 UNJ**	6	6.0	3	16.2	58
16	3/8		**MTB 08074 D19 16 UNJ**	8	7.4	4	19.9	64
14	7/16		**MTB 10085 D22 14 UNJ**	10	8.5	4	22.7	73
13	1/2		**MTB 10098 D26 13 UNJ**	10	9.8	4	26.4	73
12	9/16		**MTB 12116 D28 12 UNJ**	12	11.6	4	28.6	84

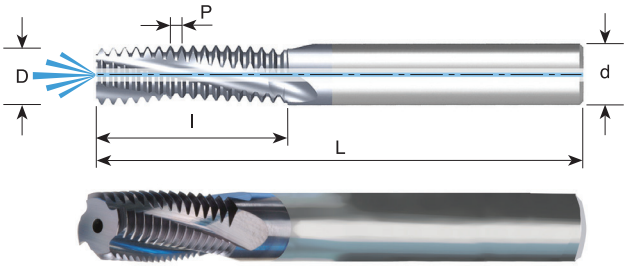
Order example: MTB 0606 C16 18 UNJ MT7

● First choice ○ Alternative

PG DIN 40430 - With internal coolant bore

Same Tool for Internal and External Thread





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
20	Pg 7	**MTB 1010 D19 20 PG**	10	10.0	4	19.7	73
18	Pg 9, 11, 13.5, 16	**MTB 1212 D20 18 PG**	12	12.0	4	20.5	84
16	Pg 21, 29, 36, 42, 48	**MTB 1212 D23 16 PG**	12	12.0	4	23.0	84

Order example: MTB 1212 D20 18 PG MT7

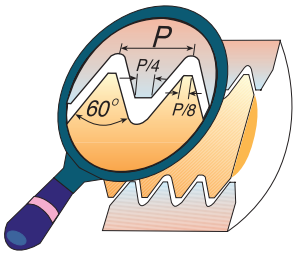
● First choice ○ Alternative

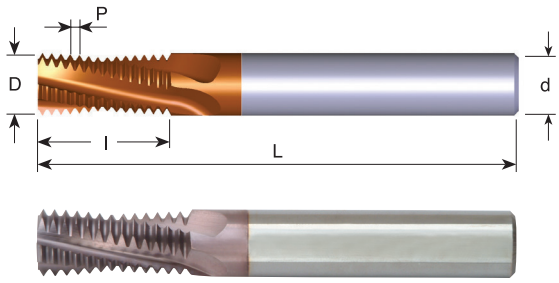
Mill - Thread Solid Carbide for External Threads

Advantages:

- Excellent surface finish thanks to the spiral flutes
- Short machining time due to multi 3 to 5 flutes

ISO



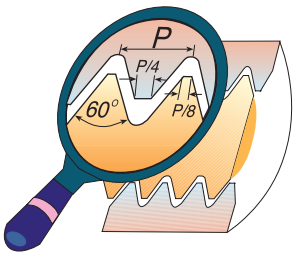


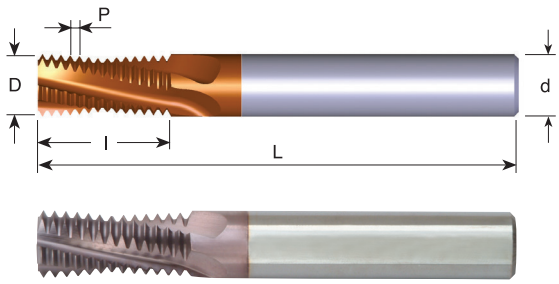
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch mm	Ordering Code	d	D	No. of Flutes	l	L
1.0	**EMT 1010 D16 1.0 ISO**	10	10.0	4	16.5	73
1.0	**EMT 1212 E20 1.0 ISO**	12	12.0	5	20.5	84
1.25	**EMT 1010 D16 1.25 ISO**	10	10.0	4	16.9	73
1.5	**EMT 1010 D15 1.5 ISO**	10	10.0	4	15.8	73
1.5	**EMT 1212 D20 1.5 ISO**	12	12.0	4	20.3	84
1.75	**EMT 1212 D20 1.75 ISO**	12	12.0	4	20.1	84
2.0	**EMT 1010 C17 2.0 ISO**	10	10.0	3	17.0	73
2.0	**EMT 1212 D21 2.0 ISO**	12	12.0	4	21.0	84

Order example: EMT 1010 D15 1.5 ISO MT7

UN





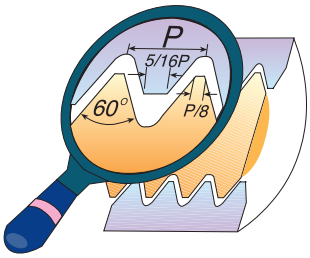
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

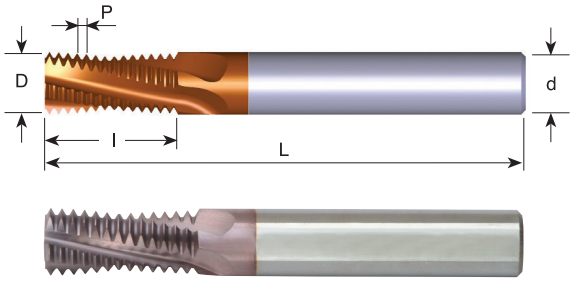
Pitch TPI	Ordering Code	d	D	No. of Flutes	l	L
24	**EMT 1010 D16 24 UN**	10	10.0	4	16.4	73
20	**EMT 1212 E21 20 UN**	12	12.0	5	21.0	84
18	**EMT 1212 D20 18 UN**	12	12.0	4	20.5	84
16	**EMT 1212 D21 16 UN**	12	12.0	4	21.4	84
14	**EMT 1212 D20 14 UN**	12	12.0	4	20.9	84
12	**EMT 1212 D20 12 UN**	12	12.0	4	20.1	84

Order example: EMT 1212 D20 18 UN MT7

● First choice ○ Alternative

MJ



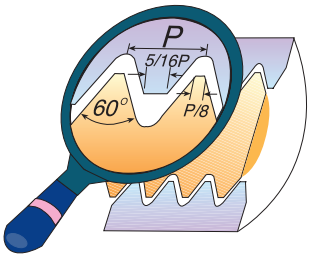


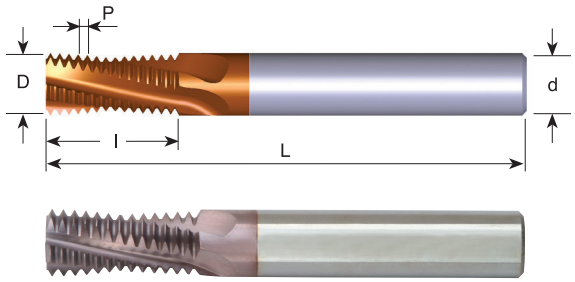
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch mm	Ordering Code	d	D	No. of Flutes	l	L
1.0	**EMT 1010 D20 1.0 MJ**	10	10.0	4	20.5	72
1.0	**EMT 1212 E24 1.0 MJ**	12	12.0	5	24.5	83
1.25	**EMT 1010 D19 1.25 MJ**	10	10.0	4	19.4	72
1.5	**EMT 1010 D21 1.5 MJ**	10	10.0	4	21.8	72
1.5	**EMT 1212 D26 1.5 MJ**	12	12.0	4	26.3	83
1.75	**EMT 1212 D27 1.75 MJ**	12	12.0	4	27.1	83
2.0	**EMT 1010 C21 2.0 MJ**	10	10.0	3	21.0	72
2.0	**EMT 1212 D27 2.0 MJ**	12	12.0	4	27.0	83

Order example: EMT 1010 C21 2.0 MJ MT7

UNJ UNJC, UNJF, UNJEF, UNJS





Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch TPI	Ordering Code	d	D	No. of Flutes	l	L
32	**EMT 0606 C13 32 UNJ**	6	6.0	3	13.9	57
28	**EMT 0808 D17 28 UNJ**	8	8.0	4	17.7	63
24	**EMT 1010 D20 24 UNJ**	10	10.0	4	20.6	72
20	**EMT 1212 E27 20 UNJ**	12	12.0	5	27.3	83
18	**EMT 1212 D26 18 UNJ**	12	12.0	4	26.1	83
16	**EMT 1212 D26 16 UNJ**	12	12.0	4	26.2	83
14	**EMT 1212 D26 14 UNJ**	12	12.0	4	26.3	83
12	**EMT 1212 D26 12 UNJ**	12	12.0	4	26.5	83

Order example: EMT 0808 D17 28 UNJ MT7

For cutting data information see page B12-12

● First choice ○ Alternative