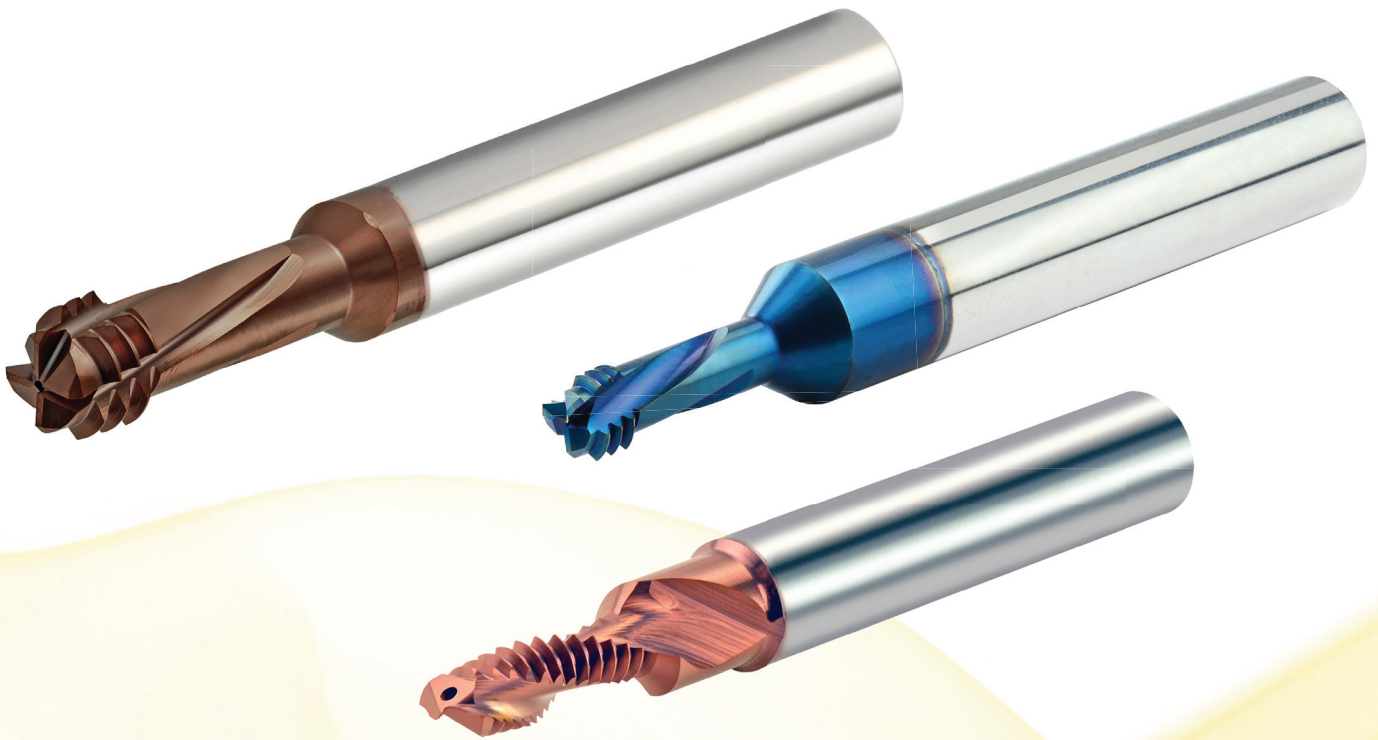


Multi - Function Thread Mills 3 in 1 Operations

B10



High Performance tools with internal coolant supply for the production of internal threads.

Produces the thread hole, the thread and a chamfer in one work process.

Contents:	Page:	Contents:	Page:
DMT, DMTH Introduction	2	DMTH	6-7
Advantages	2	ISO	6
Product Identification	2	UN	6
DMT	3-5	Case Studies	7
ISO	3	MT Drill - MTD	8-9
UN	4	Advantages	8
G (BSP)	5	Product Identification	8
NPT	5	ISO	9
		UNC	9
		UNF	9

DMT and DMTH

DMT

High Performance tools with internal coolant supply for the production of internal threads. Circular movement produces the thread hole, the thread and a chamfer in one work process.

Carbide grade: MT7 Sub-micron grade with Titanium Aluminum Nitride multi-layer coating (ISO K10-K20).

DMTH

The DMTH tools expand the range of the existing DMT line providing the ability to cut steels, hardened materials, stainless steels and super alloys.

- Advance Carbide grade dedicated for hardened materials
- Triple blue coating for high wear and heat resistance

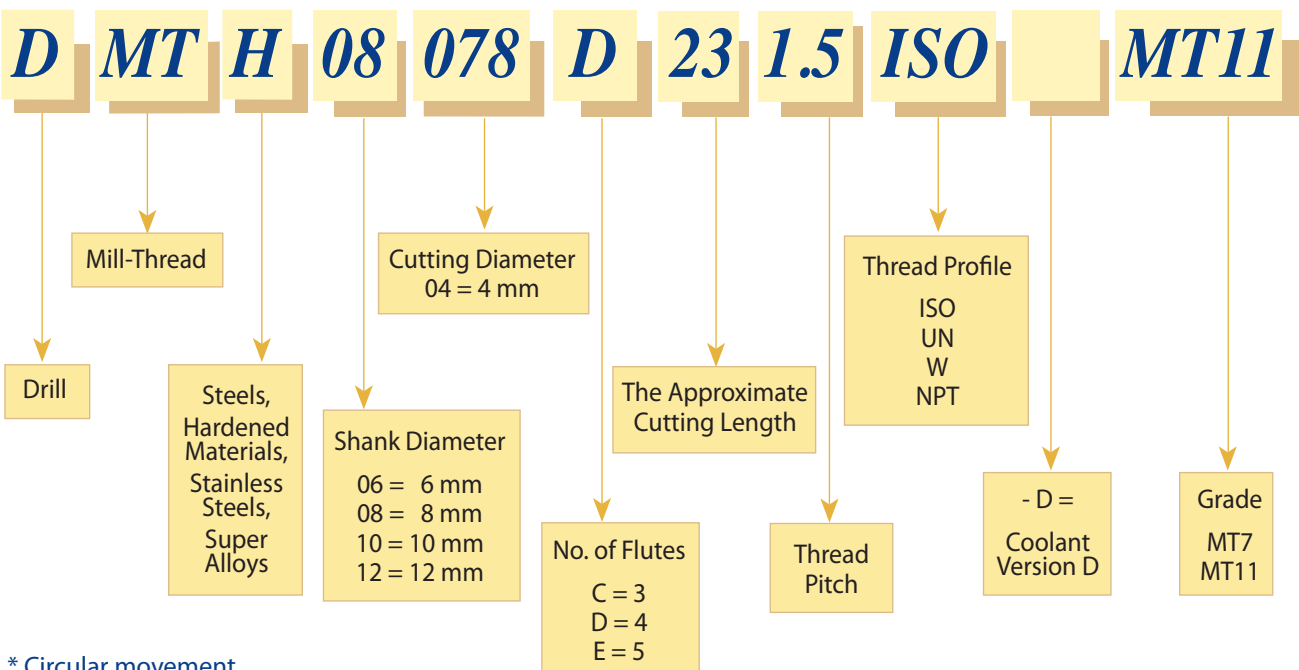
Carbide grade: MT11 Ultra-fine Sub-micron grade with advanced PVD triple blue coating (for DMTH).

Advantages

- Cancels the need for drilling the hole.
- Short cycle time and high performance reduces machining costs.
- Suitable for blind and through holes.
- Full Profile thread.
- No time lost for tool change, since drilling, chamfering and thread milling are done with one tool.
- Same tool for right-hand or left-hand threads.
- Cuts a wide range of materials.

Product Identification

DMT 3 in 1 - *Drill, Thread, Chamfer Ordering Codes



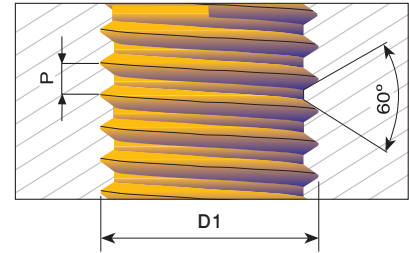
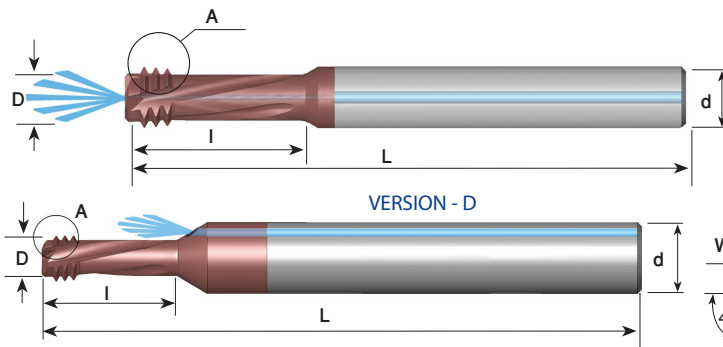
* Circular movement

DMT

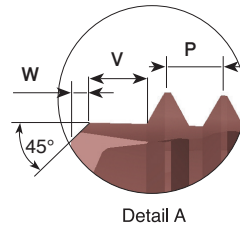


Demonstration

ISO With internal coolant bore Tools for Internal Thread



Left hand cutting
For CNC code use M04



Detail A



Grade	P	M	K	N	S	H
MT7	○	●	●	●	○	

Pitch mm	M Coarse	M Fine	Ordering Code	d	D	No. of Flutes	I	W	V	L	Thread depth
0.5	M3	M3.5, M4	*DMT 06024 C7 0.5 ISO-D	6	2.40	3	7.2	0.2	0.5	58	2xD1
0.7	M4		*DMT 06032 C11 0.7 ISO-D	6	3.15	3	11.6	0.2	0.7	58	2.5xD1
0.8	M5		*DMT 0604 C14 0.8 ISO-D	6	4.00	3	14.4	0.3	0.8	58	2.5xD1
1.0	M6, M7	M8, M9	DMT 08047 C14 1.0 ISO	8	4.70	3	14.0	0.4	1.0	64	2xD1
1.0	M6, M7	M8, M9	DMT 08047 C20 1.0 ISO	8	4.70	3	20.4	0.4	1.0	64	3xD1
1.25	M8, M9	M10, M12	DMT 08061 D18 1.25 ISO	8	6.10	4	18.0	0.5	1.25	64	2xD1
1.25	M8, M9	M10, M12	DMT 08061 D27 1.25 ISO	8	6.10	4	27.0	0.5	1.25	64	3xD1
1.5	M10	M13-M15	DMT 08078 D23 1.5 ISO	8	7.80	4	23.0	0.6	1.5	64	2xD1
1.75	M12		DMT 1009 D26 1.75 ISO	10	9.00	4	26.0	0.6	1.75	73	2xD1
2.0	M16	M17-M23	DMT 12118 D35 2.0 ISO	12	11.80	4	35.0	0.6	2.0	84	2xD1

* Tools version-D

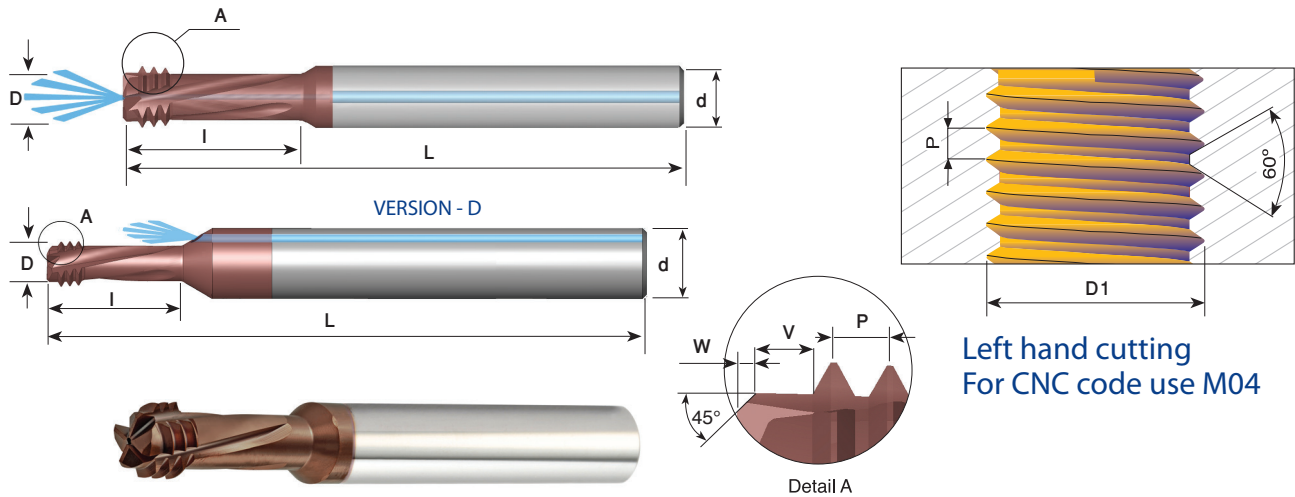
● First choice

○ Alternative

Order example: DMT 08047 C14 1.0 ISO MT7

UN With internal coolant bore

Tools for Internal Thread



For thread depth up to 2 x D1

Grade	P	M	K	N	S	H
MT7	○	●	●	●	○	

Pitch TPI	UN, UNEF, UNF UNC, UNS	Ordering Code	d	D	No. of Flutes	I	W	V	L	Thread length
40	4, 5, 6	*DMT 06021 C7 40 UN-D	6	2.10	3	7.0	0.1	0.6	58	2xD1
36	8	*DMT 06033 C12 36 UN-D	6	3.30	3	12.0	0.2	0.7	58	2.5xD1
32	6	*DMT 06026 C8 32 UN-D	6	2.60	3	8.7	0.2	0.8	58	2xD1
32	8	*DMT 06032 C12 32 UN-D	6	3.20	3	12.3	0.3	0.8	58	2.5xD1
32	10	*DMT 06038 C14 32 UN-D	6	3.80	3	14.0	0.3	0.8	58	2.5xD1
28	1/4-3/8	DMT 0805 C14 28 UN	8	5.00	3	14.5	0.4	0.9	64	2xD1
24	10,12	*DMT 06035 C12 24 UN-D	6	3.50	3	12.1	0.3	1.05	58	2xD1
24	5/16-1/2	DMT 08065 D17 24 UN	8	6.50	4	17.0	0.5	1.05	64	2xD1
20	1/4-3/8	DMT 08048 C14 20 UN	8	4.80	3	14.0	0.4	1.25	64	2xD1
18	5/16-7/16	DMT 0806 D17 18 UN	8	6.00	4	17.0	0.5	1.4	64	2xD1
16	3/8-1/2	DMT 08067 C22 16 UN	8	6.70	3	22.0	0.5	1.6	64	2xD1
14	7/16	DMT 0808 D26 14 UN	8	8.00	4	26.5	0.6	1.8	64	2xD1
13	1/2	DMT 1010 D29 13 UN	10	10.00	4	29.8	0.6	2.0	73	2xD1

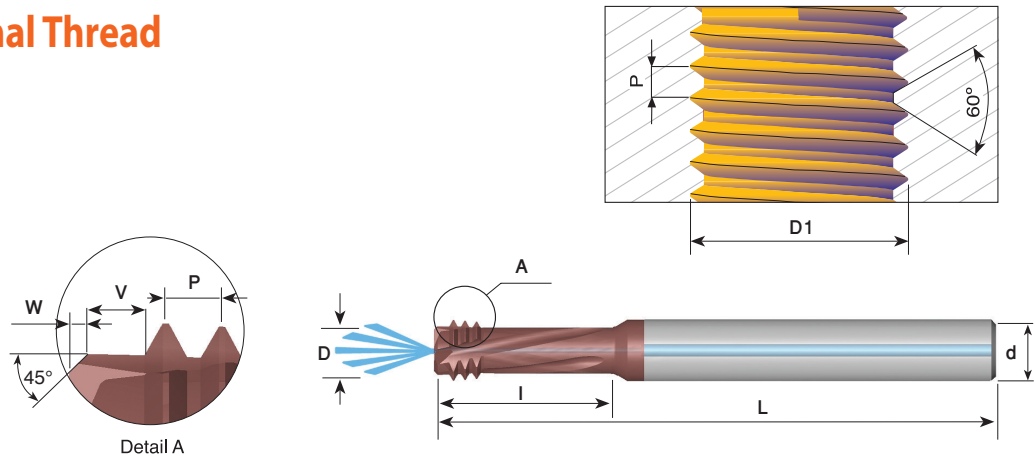
* Tools version-D

● First choice ○ Alternative

Order example: DMT 08067 C22 16 UN MT7

G (BSP) With internal coolant bore

Tools for Internal Thread



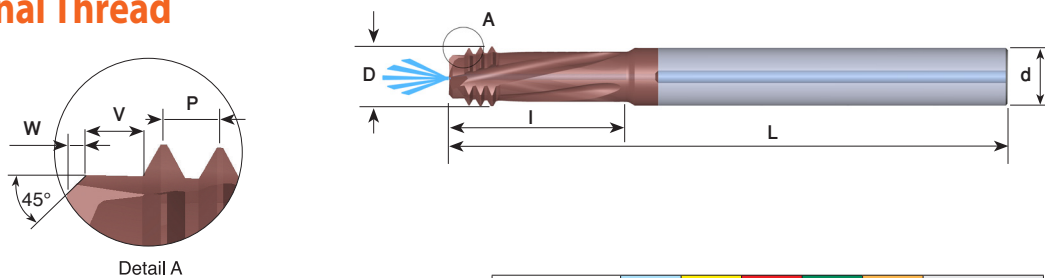
Grade	P	M	K	N	S	H
MT7	○	●	●	●	○	

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	W	V	L	Thread length
28	G1/16	DMT 0806 D17 28 W	8	6.00	4	17.8	0.6	0.9	64	2xD1
28	G1/8	DMT 08078 D21 28 W	8	7.80	4	21.8	0.6	0.9	64	2xD1
19	G1/4	DMT 12104 D29 19 W	12	10.40	4	29.6	0.7	1.3	84	2xD1
19	G3/8	DMT 1414 D36 19 W	14	14.00	4	36.7	0.8	1.3	83	2xD1

Order example: DMT 08078 D21 28 W MT7

NPT With internal coolant bore

Tools for Internal Thread



Grade	P	M	K	N	S	H
MT7	○	●	●	●	○	

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	W	V	L
27	1/16	DMT 08057 D11 27 NPT	8	5.70	4	11.2	0.4	0.9	64
27	1/8	DMT 08076 D12 27 NPT	8	7.60	4	12.1	0.4	0.9	64
18	1/4	DMT 1010 D18 18 NPT	10	10.00	4	18.2	0.6	1.4	73
18	3/8	DMT 1212 D19 18 NPT	12	12.00	4	19.6	0.6	1.4	84
14	1/2	DMT 1616 E26 14 NPT	16	16.00	5	26.9	0.6	1.8	92

Order example: DMT 1010 D18 18 NPT MT7

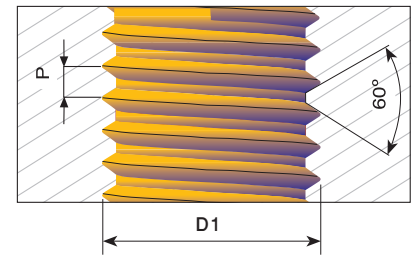
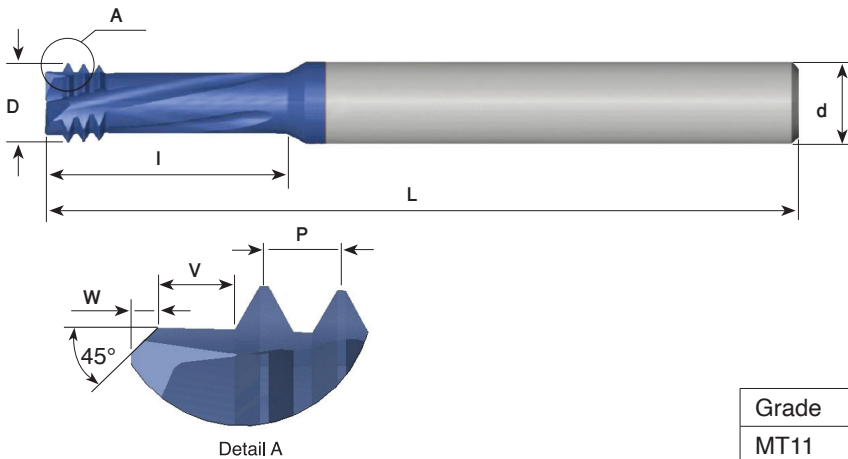
● First choice ○ Alternative

DMTH

For information see page B10-2

ISO

Tools for Internal Thread



Left hand cutting
For CNC code use M04

Grade	P	M	K	N	S	H
MT11	●	●	○	○	●	≤55 HRc

Pitch mm	M Coarse	M Fine	Ordering Code	d	D	No. of Flutes	I	W	V	L	Thread depth
0.7	M4		DMTH 06032 C11 0.7 ISO	6	3.15	3	11.6	0.2	0.7	58	2.5xD1
0.8	M5		DMTH 0604 C14 0.8 ISO	6	4.00	3	14.4	0.3	0.8	58	2.5xD1
1.0	M6,M7	M8,M9	DMTH 08047 C14 1.0 ISO	8	4.70	3	14.4	0.4	1.0	64	2xD1
1.25	M8,M9	M10,M12	DMTH 08061 D19 1.25 ISO	8	6.10	4	19.0	0.5	1.25	64	2xD1
1.5	M10	M13-M15	DMTH 08078 D23 1.5 ISO	8	7.80	4	23.6	0.6	1.5	64	2xD1
1.75	M12		DMTH 1009 D28 1.75 ISO	10	9.00	4	28.1	0.6	1.75	73	2xD1
2.0	M16	M17-M23	DMTH 12118 D36 2.0 ISO	12	11.80	4	36.6	0.6	2.0	84	2xD1

Order example: DMTH 1009 D28 1.75 ISO MT11

UN

Tools for Internal Thread

Grade	P	M	K	N	S	H
MT11	●	●	○	○	●	≤55 HRc

Pitch TPI	UN, UNEF, UNF UNC, UNS	Ordering Code	d	D	No. of Flutes	I	W	V	L	Thread depth
40	4, 5, 6	DMTH 06021 C7 40 UN	6	2.10	3	7.0	0.1	0.6	58	2xD1
32	6	DMTH 06026 C8 32 UN	6	2.60	3	8.7	0.1	0.8	58	2xD1
28	1/4-3/8	DMTH 0805 C14 28 UN	8	5.00	3	14.9	0.4	0.9	64	2xD1
24	5/16-1/2	DMTH 08065 D18 24 UN	8	6.50	4	18.5	0.5	1.05	64	2xD1
20	1/4-3/8	DMTH 08048 C15 20 UN	8	4.80	3	15.6	0.4	1.25	64	2xD1
18	5/16-7/16	DMTH 0806 D19 18 UN	8	6.00	4	19.2	0.5	1.4	64	2xD1
16	3/8-1/2	DMTH 08067 C22 16 UN	8	6.70	3	22.8	0.5	1.6	64	2xD1
13	1/2	DMTH 10092 C30 13 UN	10	9.20	3	30.0	0.6	2.0	73	2xD1
11	5/8	DMTH 12114 C37 11 UN	12	11.40	3	37.0	0.6	2.3	84	2xD1

Order example: DMTH 08048 C15 20 UN MT11

● First choice ○ Alternative

Case Studies

Case Study no. 1

Tool Description	DMTH 08047 C14 1.0 ISO MT11
Internal Thread	M6x1.0
Thread Length	12 mm
Material	Steel 12-15 HRc SAE 4340
Cutting Data	Vc= 90 m/min Fz= 0.03 mm/tooth
Cycle Time	28 seconds
Tool Life	776

Case Study no. 2

Tool Description	DMTH 08047 C14 1.0 ISO MT11
Internal Thread	M6x1.0
Thread Length	12 mm
Material	Steel 44-45 HRc SAE 4340
Cutting Data	Vc= 71 m/min Fz= 0.02 mm/tooth
Cycle Time	53 seconds
Tool Life	196

MT Drill - MTD

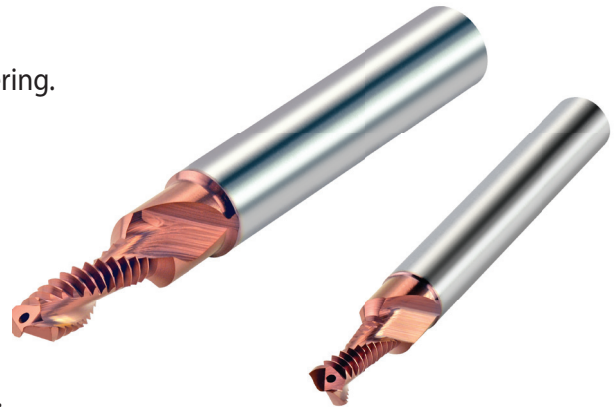
Designed to drill, chamfer and thread mill the hole in one operation.

Carbide grade: MT7: Sub-Micron carbide grade combines high hardness and toughness, with PVD triple coating for smooth cutting and high performance.

K20: Uncoated Sub-Micron carbide grade dedicated for machining Aluminum and Cast Iron.

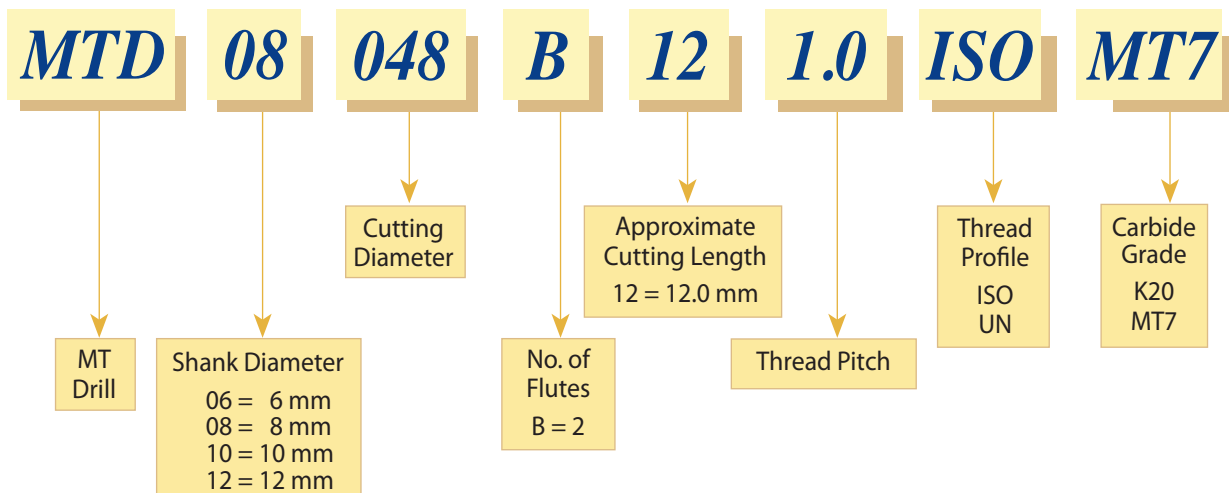
Advantages

- Two fluted drill/thread milling cutter, with 45° chamfering. Ideal for mass production applications.
- Reduces cycle times by combining operations and eliminating tool changes.
- For both right and left hand internal threads.
- Same tool for blind or through hole.
- High thread surface quality.
- Internal coolant.
- Optimized carbide grade for Aluminum and Cast Iron.



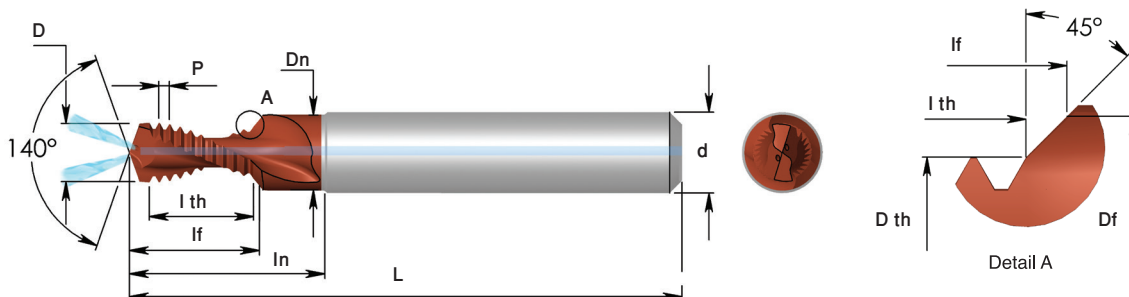
Product Identification

Mill-Thread Drill Ordering Codes



MT Drill - MTD

Tools for Internal thread



Thread length: 2xD

Grade	P	M	K	N	S	H
K20			●	●		
MT7			●	●		

ISO

Pitch mm	M Coarse	Ordering Code	d	D	Dth	Df	Dn	In	lth	lf	L
0.7	M4	MTD 06032 B7 0.7 ISO	6	3.30	3.20	4.7	4.9	15	7.7	9.8	54
0.8	M5	MTD 0604 B9 0.8 ISO	6	4.20	4.00	5.5	5.7	18	9.6	11.9	54
1.0	M6	MTD 08048 B12 1.0 ISO	8	5.00	4.80	6.5	6.8	26	12.0	14.8	62
1.25	M8	MTD 10064 B15 1.25 ISO	10	6.75	6.40	8.6	8.9	34	15.1	18.7	74
1.5	M10	MTD 1208 B19 1.5 ISO	12	8.50	8.00	10.5	10.8	35	19.5	23.8	80

UNC

Pitch TPI	UNC	Ordering Code	d	D	Dth	Df	Dn	In	lth	lf	L
20	1/4	MTD 08048 B12 20 UN	8	5.20	4.80	6.7	6.9	26	12.7	15.9	62
18	5/16	MTD 10061 B15 18 UN	10	6.60	6.10	8.3	8.6	34	15.5	19.2	74
16	3/8	MTD 12075 B19 16 UN	12	8.00	7.50	10.0	10.3	35	19.1	23.4	80
14	7/16	MTD 12088 B21 14 UN	12	9.40	8.80	11.4	11.6	35	21.8	26.6	80

UNF

Pitch TPI	UNF	Ordering Code	d	D	Dth	Df	Dn	In	lth	lf	L
32	10	MTD 06038 B9 32 UN	6	4.10	3.80	5.4	5.6	18	9.5	11.8	54
28	1/4	MTD 08052 B13 28 UN	8	5.50	5.20	6.7	6.9	26	13.0	15.7	62
24	5/16	MTD 10066 B15 24 UN	10	6.90	6.60	8.4	8.7	34	15.9	19.1	74
24	3/8	MTD 12082 B19 24 UN	12	8.50	8.20	10.0	10.3	35	19.0	22.5	80

- Tools without coolant available upon request.
- Cylindrical shank DIN6535-HA (Weldon shank, available upon request).

Order example: MTD 08048 B12 20 UN MT7

● First choice ○ Alternative

