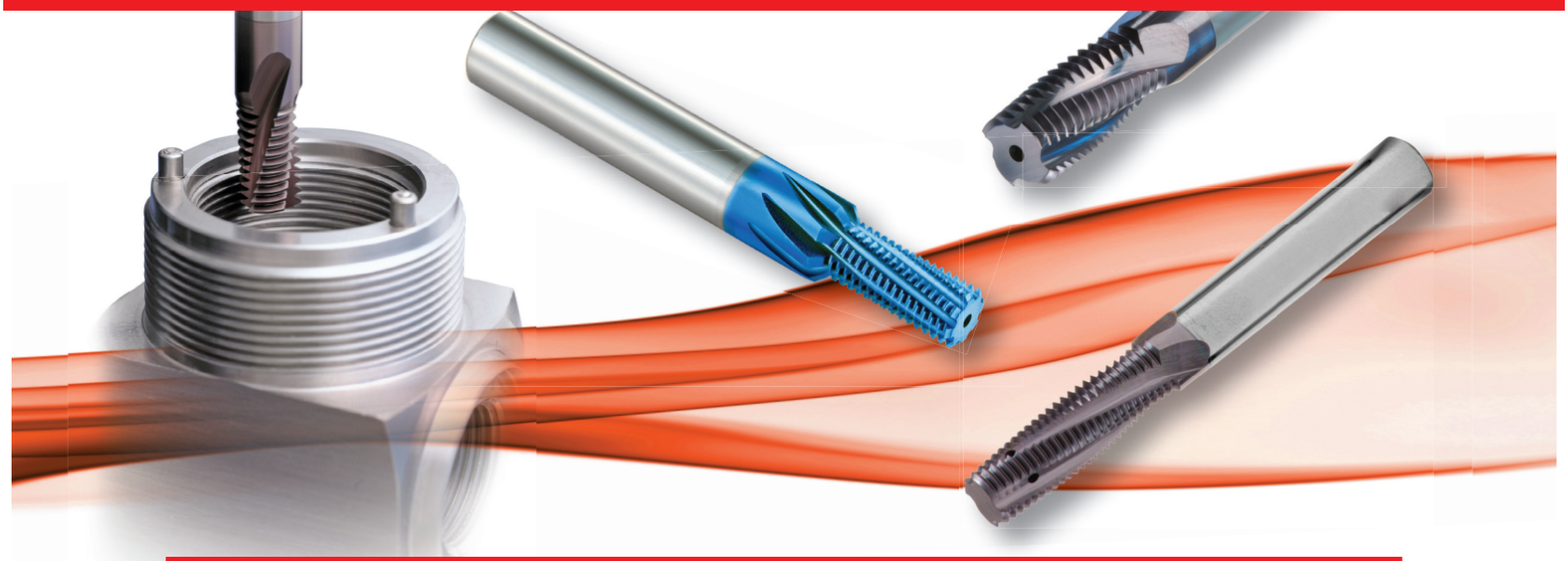
Mill-Thread Solid Carbide | B08



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:

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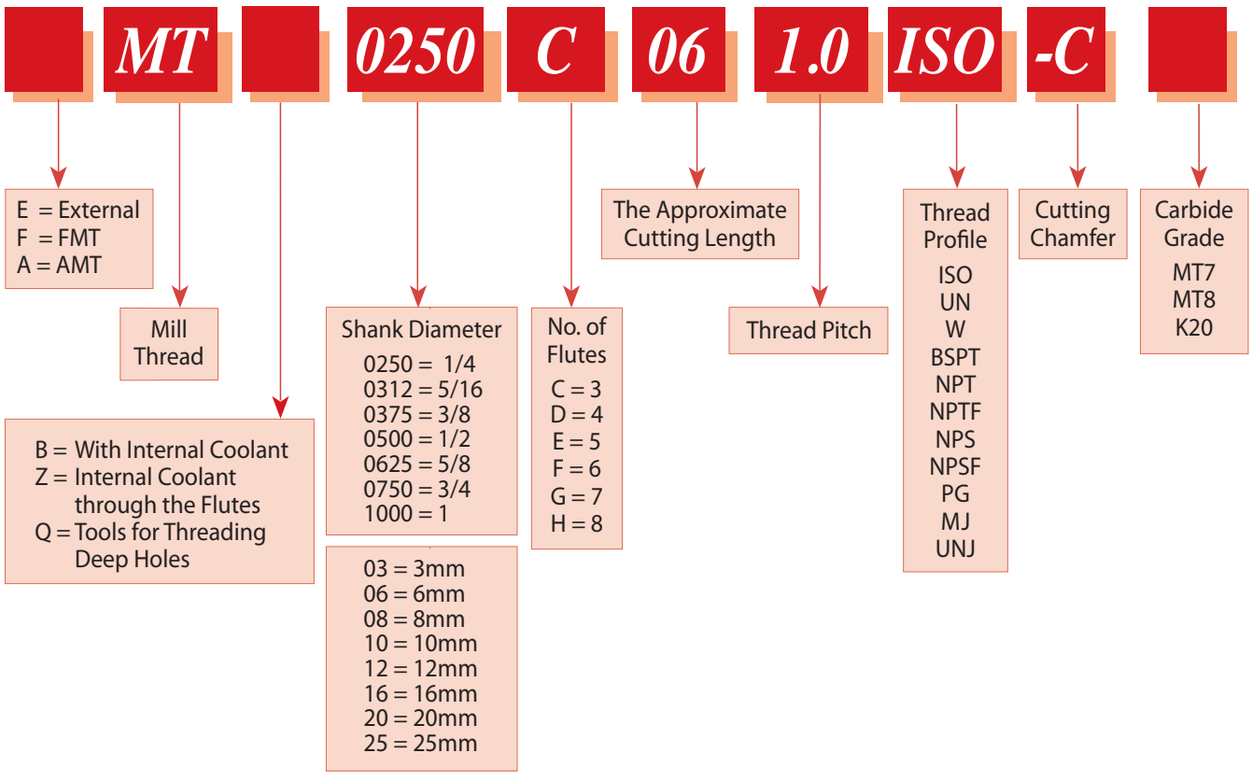
Product Identification

Mill-Thread Solid Carbide Ordering Codes

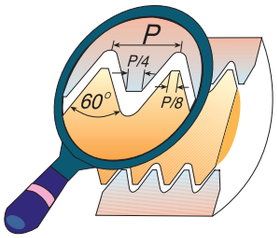


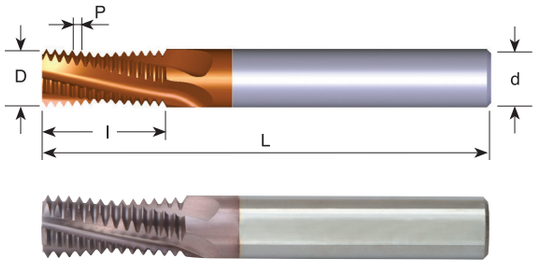
Mill-Thread Solid Carbide

Carmex Precision Tools Ltd.

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 0250 C02 0.5 ISO**	1/4	.087	3	.21	2.5
0.5		M5	**MT 0250 C04 0.5 ISO**	1/4	.150	3	.41	2.5
0.5		M6, M8	**MT 0250 D04 0.5 ISO**	1/4	.209	4	.41	2.5
0.7	M4		**MT 0250 C03 0.7 ISO**	1/4	.122	3	.29	2.5
0.75		M6, M8	**MT 0250 C04 0.75 ISO**	1/4	.177	3	.40	2.5
0.75		M6, M8	**MT 0250 C05 0.75 ISO**	1/4	.197	3	.52	2.5
0.8	M5		**MT 0250 C04 0.8 ISO**	1/4	.142	3	.36	2.5
0.8	M5		**MT 0250 C05 0.8 ISO**	1/4	.157	3	.52	2.5
1.0	M6	M8	**MT 0250 C04 1.0 ISO**	1/4	.157	3	.41	2.5
1.0	M6	M8	**MT 0250 C06 1.0 ISO**	1/4	.157	3	.57	2.5
1.0		M8, M9	**MT 0250 C05 1.0 ISO**	1/4	.236	3	.49	2.5
1.0		M10	**MT 0312 D07 1.0 ISO**	5/16	.313	4	.65	2.5
1.25	M8	M10	**MT 0250 C06 1.25 ISO**	1/4	.197	3	.57	2.5
1.25	M8	M10	**MT 0250 C07 1.25 ISO**	1/4	.197	3	.76	2.5
1.5	M10	M12	**MT 0312 C07 1.5 ISO**	5/16	.276	3	.68	2.5
1.5	M10	M12	**MT 0312 C09 1.5 ISO**	5/16	.276	3	.98	2.5
1.5		M14	**MT 0375 D09 1.5 ISO**	3/8	.375	4	.86	3.0
1.5		M14	**MT 0500 D11 1.5 ISO**	1/2	.472	4	1.15	3.5
1.5		M16, M18	**MT 0625 D12 1.5 ISO**	5/8	.551	4	1.27	4.0
1.5		M20	**MT 0625 F13 1.5 ISO**	5/8	.625	6	1.33	4.0
1.75	M12		**MT 0312 C08 1.75 ISO**	5/16	.313	3	.79	2.5
1.75	M12		**MT 0312 C011 1.75 ISO**	5/16	.313	3	1.14	2.5
2.0	M14	M17	**MT 0375 C11 2.0 ISO**	3/8	.375	3	1.06	3.0
2.0	M14	M17	**MT 0375 C15 2.0 ISO**	3/8	.375	3	1.54	4.0
2.0	M16	M18, M20	**MT 0500 D11 2.0 ISO**	1/2	.472	4	1.06	3.5
2.0	M16	M18, M20	**MT 0500 D15 2.0 ISO**	1/2	.500	4	1.54	4.0
2.0		M26	**MT 0750 F16 2.0 ISO**	3/4	.750	6	1.61	4.0
2.5	M18, M20		**MT 0625 D13 2.5 ISO**	5/8	.551	4	1.33	4.0
2.5	M18, M20		**MT 0625 D19 2.5 ISO**	5/8	.551	4	1.92	4.0
3.0	M24	M28	**MT 0625 C16 3.0 ISO**	5/8	.625	3	1.59	4.0
3.0	M24	M28	**MT 0625 C23 3.0 ISO**	5/8	.625	3	2.31	4.5
3.0	M27	M28, M30	**MT 0750 D17 3.0 ISO**	3/4	.750	4	1.71	4.0

Order example: MT 1212 D27 2.0 ISO MT7

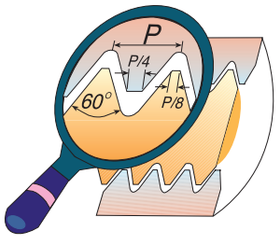
● First choice ○ Alternative

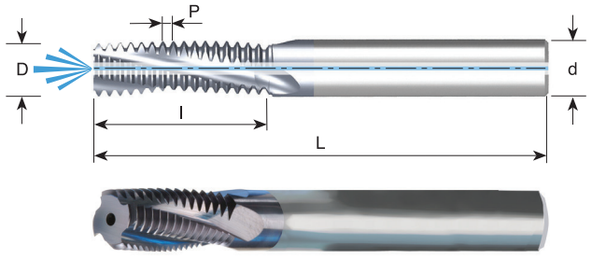
For thread mills with coolant bore see following pages

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 0250 C04 0.5 ISO**	1/4	.150	3	.41	2.5
0.7	M4		**MTB 0250 C02 0.7 ISO**	1/4	.122	3	.29	2.5
0.75		M6, M8	**MTB 0250 C04 0.75 ISO**	1/4	.177	3	.40	2.5
0.75		M12, M14	**MTB 0375 D09 0.75 ISO**	3/8	.375	4	.96	3.0
0.8	M5		**MTB 0250 C03 0.8 ISO**	1/4	.150	3	.36	2.5
0.8	M5		**MTB 0250 C05 0.8 ISO**	1/4	.157	3	.52	2.5
1.0	M6		**MTB 0250 C04 1.0 ISO**	1/4	.181	3	.41	2.5
1.0	M6		**MTB 0250 C06 1.0 ISO**	1/4	.181	3	.57	2.5
1.0		M8	**MTB 0250 C05 1.0 ISO**	1/4	.250	3	.50	2.5
1.0		M10	**MTB 0312 D06 1.0 ISO**	5/16	.312	4	.65	2.5
1.0		M12	**MTB 0375 D09 1.0 ISO**	3/8	.375	4	.96	3.0
1.25	M8	M10	**MTB 0250 C05 1.25 ISO**	1/4	.249	3	.57	2.5
1.25	M8	M10	**MTB 0250 C07 1.25 ISO**	1/4	.249	3	.76	2.5
1.5	M10	M12	**MTB 0312 C06 1.5 ISO**	5/16	.306	3	.67	2.5
1.5	M10	M12	**MTB 0312 C09 1.5 ISO**	5/16	.306	3	.98	2.5
1.5		M14	**MTB 0375 D08 1.5 ISO**	3/8	.375	4	.86	3.0
1.5		M15-M19	**MTB 0500 D10 1.5 ISO**	1/2	.500	4	1.04	4.0
1.5		M20	**MTB 0625 F13 1.5 ISO**	5/8	.625	6	1.33	4.0
1.75	M12		**MTB 0375 C07 1.75 ISO**	3/8	.354	3	.79	3.0
1.75	M12		**MTB 0375 C11 1.75 ISO**	3/8	.354	3	1.14	3.0
2.0	M14	M17	**MTB 0375 C10 2.0 ISO**	3/8	.375	3	1.06	3.0
2.0	M14	M17	**MTB 0500 D16 2.0 ISO**	1/2	.433	4	1.54	4.0
2.0	M16	M18, M20	**MTB 0500 D10 2.0 ISO**	1/2	.465	4	1.06	4.0
2.0	M16	M18, M20	**MTB 0500 D15 2.0 ISO**	1/2	.465	4	1.54	4.0
2.0		M26	**MTB 0750 F16 2.0 ISO**	3/4	.750	6	1.61	4.0
2.5	M20		**MTB 0625 E13 2.5 ISO**	5/8	.591	5	1.33	4.0
2.5	M20		**MTB 0625 E19 2.5 ISO**	5/8	.591	5	1.92	4.0
3.0	M24	M28	**MTB 0750 D15 3.0 ISO**	3/4	.709	4	1.59	4.0
3.0	M24	M28	**MTB 0750 D23 3.0 ISO**	3/4	.709	4	2.30	5.0
3.0	M27	M28, M30	**MTB 0750 D17 3.0 ISO**	3/4	.750	4	1.71	4.0

Order example: MTB 08078 C17 1.5 ISO MT7

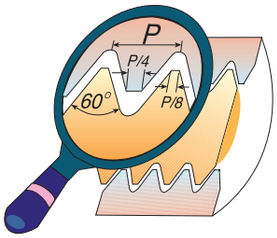
● First choice ○ Alternative

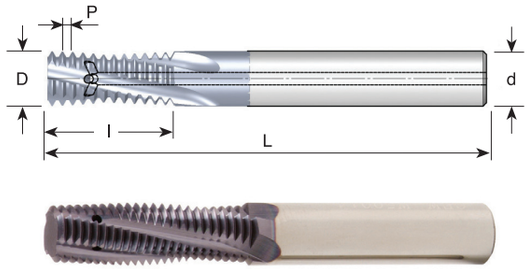
For thread mills with coolant through the flutes see next page

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 mm	D	No. of Flutes	l	L
1.0	M6	M8	**MTZ 06048 C10 1.0 ISO**	6	.189	3	.41	2.3
1.0		M8, M9	**MTZ 0606 C12 1.0 ISO**	6	.236	3	.49	2.3
1.0		M10	**MTZ 0808 D16 1.0 ISO**	8	.315	4	.65	2.5
1.25	M8	M10	**MTZ 0606 C14 1.25 ISO**	6	.236	3	.57	2.3
1.25	M8	M10	**MTZ 0606 C19 1.25 ISO**	6	.236	3	.76	2.3
1.5	M10	M12	**MTZ 08078 C17 1.5 ISO**	8	.307	3	.67	2.5
1.5	M10	M12	**MTZ 0808 C23 1.5 ISO**	8	.315	3	.92	2.5
1.5		M14	**MTZ 1010 D21 1.5 ISO**	10	.394	4	.86	2.9
1.5		M14, M16	**MTZ 1212 D26 1.5 ISO**	12	.472	4	1.03	3.3
1.5		M16, M18	**MTZ 1414 D32 1.5 ISO**	14	.551	4	1.27	4.0
1.5		M20	**MTZ 1616 E33 1.5 ISO**	16	.630	5	1.33	4.0
1.75	M12		**MTZ 1009 C20 1.75 ISO**	10	.354	3	.79	2.9
1.75	M12		**MTZ 1009 C28 1.75 ISO**	10	.354	3	1.14	2.9
2.0	M14	M17	**MTZ 1010 C27 2.0 ISO**	10	.394	3	1.06	2.9
2.0	M16	M18, M20	**MTZ 12118 D27 2.0 ISO**	12	.465	4	1.06	3.3
2.5	M20		**MTZ 1615 E33 2.5 ISO**	16	.591	5	1.33	4.0

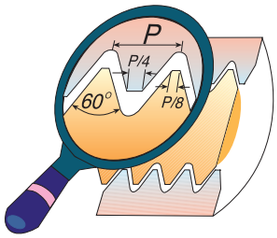
Order example: MTZ 08078 C17 1.5 ISO MT7

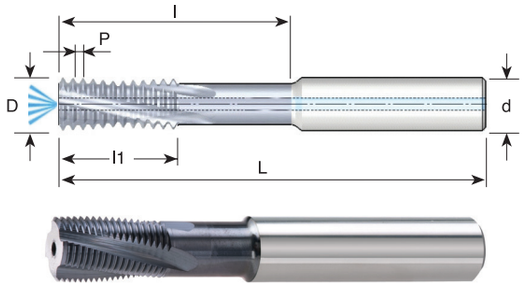
● First choice ○ Alternative

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 mm	D	No. of Flutes	l1	l	L
1.0	Ø ≥ 12	**MTQ 1010 D32 1.0 ISO**	10	.394	4	.71	1.26	2.9
1.0	Ø ≥ 14	**MTQ 1212 D38 1.0 ISO**	12	.472	4	.83	1.50	3.3
1.0	Ø ≥ 18	**MTQ 1616 F45 1.0 ISO**	16	.630	6	1.02	1.77	4.1
1.5	Ø ≥ 13	**MTQ 1010 D30 1.5 ISO**	10	.394	4	.71	1.18	2.9
1.5	Ø ≥ 15	**MTQ 1212 D34 1.5 ISO**	12	.472	4	.77	1.36	3.3
1.5	Ø ≥ 19	**MTQ 1616 F43 1.5 ISO**	16	.630	6	1.00	1.71	4.1
1.5	Ø ≥ 23	**MTQ 2020 F60 1.5 ISO**	20	.787	6	1.42	2.36	4.1
2.0	Ø ≥ 16	**MTQ 1212 D42 2.0 ISO**	12	.472	4	.94	1.65	3.3
2.0	Ø ≥ 20	**MTQ 1616 E45 2.0 ISO**	16	.630	5	1.02	1.77	4.1
2.0	Ø ≥ 24	**MTQ 2020 F56 2.0 ISO**	20	.787	6	1.34	2.20	4.1
3.0	Ø ≥ 22	**MTQ 1616 D45 3.0 ISO**	16	.630	4	1.18	1.77	4.1
3.0	Ø ≥ 26	**MTQ 2020 E54 3.0 ISO**	20	.787	5	1.30	2.13	4.1
3.5	Ø ≥ 26	**MTQ 2020 D45 3.5 ISO**	20	.787	4	1.10	1.79	4.1
4.0	Ø ≥ 31	**MTQ 2525 D64 4.0 ISO**	25	.984	4	1.58	2.52	6.3

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

Mill-Thread Solid Carbide

Carmex Precision Tools Ltd.

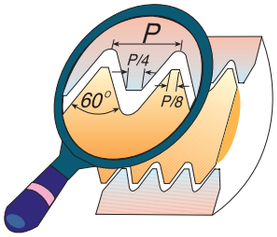
ISO Fast MT with internal coolant bore

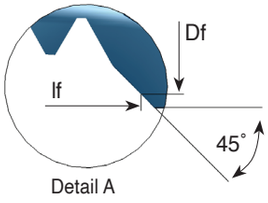
Tools for Internal Thread

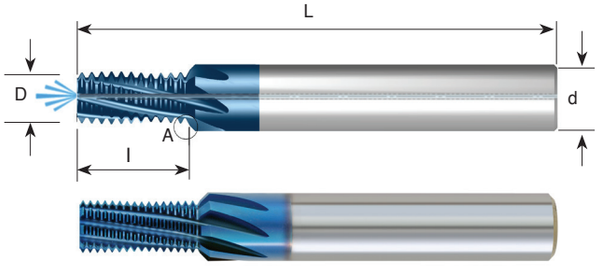
- **A unique line of solid carbide thread milling tools (FMT) for increased productivity and extended tool life.**
- **Large number of flutes results in significantly shorter machining time.**

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 mm	D	Df	Flutes	l	lf	L
0.5	M3	M3.5	***FMT 06024 D6 0.5 ISO**	6	.094	.173	4	.25	.29	2.3
0.5		M4,M5	**FMT 06033 E8 0.5 ISO**	6	.130	.209	5	.33	.37	2.3
0.7	M4		**FMT 06032 E7 0.7 ISO**	6	.126	.189	5	.29	.32	2.3
0.75		M6	**FMT 0805 F12 0.75 ISO**	8	.197	.276	6	.49	.53	2.5
0.8	M5		**FMT 0604 E9 0.8 ISO**	6	.157	.224	5	.36	.40	2.3
1.0	M6	M8	**FMT 08048 F10 1.0 ISO**	8	.189	.268	6	.41	.45	2.5
1.0	M10	M12	**FMT 12087 G20 1.0 ISO**	12	.343	.461	7	.81	.87	3.3
1.25	M8	M10	**FMT 10064 G14 1.25 ISO**	10	.252	.378	7	.57	.63	2.9
1.5	M10	M14	**FMT 1008 G17 1.5 ISO**	10	.315	.386	7	.68	.72	2.9
1.75	M12		**FMT 12095 G20 1.75 ISO**	12	.374	.461	7	.79	.83	3.3
2.0	M14, M16	M18	**FMT 1411 G29 2.0 ISO**	14	.433	.528	7	1.14	1.19	3.3

Order example: FMT 1008 G17 1.5 ISO MT8

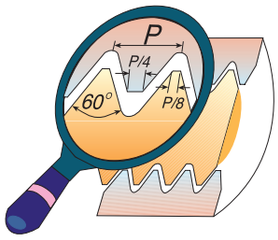
● First choice ○ Alternative

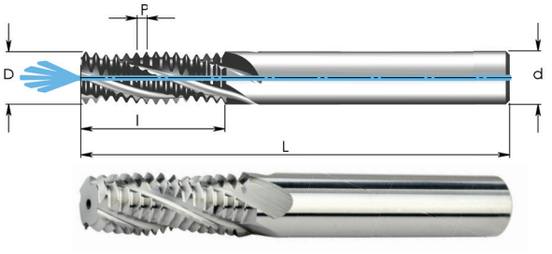
* Without internal coolant

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	○	○	●	●	●	

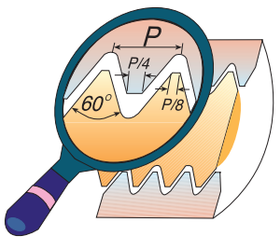
Pitch mm	M coarse	M fine	Ordering Code	d mm	D	No. of Flutes	l	L
0.5	M3	M4	* **AMT 03024 C6 0.5 ISO**	3	.094	3	.27	1.5
0.5		M5	**AMT 06043 C10 0.5 ISO**	6	.169	3	.42	2.3
0.7	M4		**AMT 06031 C8 0.7 ISO**	6	.122	3	.35	2.3
0.75		M6	**AMT 0605 C13 0.75 ISO**	6	.197	3	.52	2.3
0.8	M5		**AMT 0604 C10 0.8 ISO**	6	.157	3	.42	2.3
1.0	M6		**AMT 06048 C13 1.0 ISO**	6	.189	3	.53	2.3
1.0		M10	**AMT 0808 D21 1.0 ISO**	8	.315	4	.85	2.5
1.25	M8	M10	**AMT 08064 C16 1.25 ISO**	8	.252	3	.66	2.5
1.5	M10		**AMT 0808 C21 1.5 ISO**	8	.315	3	.86	2.5
1.5		M14	**AMT 12112 D29 1.5 ISO**	12	.441	4	1.15	3.3
1.75	M12		**AMT 10095 D25 1.75 ISO**	10	.374	4	1.00	2.9
2.0	M16	M17	**AMT14126 D35 2.0 ISO**	14	.496	4	1.38	3.3

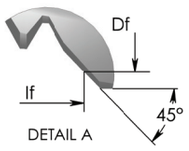
Order example: AMT 08064 C16 1.25 ISO K20

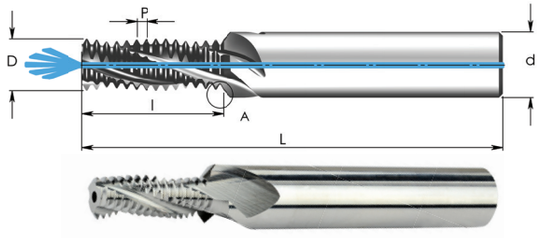
* Without internal coolant

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 mm	D	Df	No. of Flutes	l	lf	L
0.8	M5		**AMT 0604 C10 0.8 ISO-C**	6	.157	.21	3	.42	.45	2.3
1.0	M6		**AMT 08048 C13 1.0 ISO-C**	8	.189	.25	3	.52	.56	2.5
1.25	M8	M10	**AMT 10064 C16 1.25 ISO-C**	10	.252	.33	3	.66	.70	2.9
1.5	M10		**AMT 1208 C21 1.5 ISO-C**	12	.315	.41	3	.36	.91	3.3

Order example: AMT 10064 C16 1.25 ISO-C K20

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

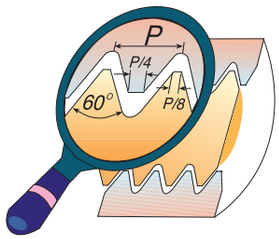
● First choice ○ Alternative

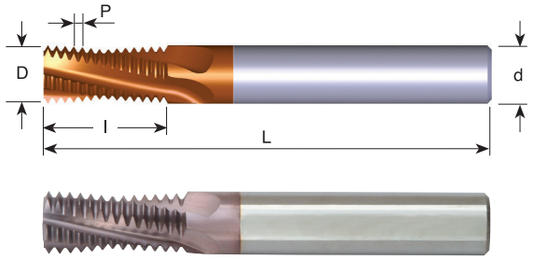
Mill-Thread Solid Carbide

Carmex Precision Tools Ltd.

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 0250 C02 40 UN**	1/4	.098	3	.24	2.5
32	8	10	12	**MT 0250 C02 32 UN**	1/4	.126	3	.27	2.5
28		1/4		**MT 0250 C04 28 UN**	1/4	.157	3	.45	2.5
28		1/4		**MT 0250 C06 28 UN**	1/4	.205	3	.59	2.5
28			7/16-1/2	**MT 0250 C05 28 UN**	1/4	.236	3	.57	2.5
24		5/16		**MT 0250 C06 24 UN**	1/4	.197	3	.56	2.5
24		3/8	9/16-5/8	**MT 0312 C08 24 UN**	5/16	.276	3	.81	2.5
20	1/4			**MT 0250 C05 20 UN**	1/4	.177	3	.48	2.5
20		7/16-1/2		**MT 0312 C08 20 UN**	5/16	.276	3	.83	2.5
20			3/4-1	**MT 0500 E11 20 UN**	1/2	.472	5	1.08	3.5
18	5/16			**MT 0250 C06 18 UN**	1/4	.197	3	.58	2.5
18	5/16			**MT 0250 C08 18 UN**	1/4	.236	3	.81	2.5
18		9/16-5/8	1 1/8-1 5/8	**MT 0375 D10 18 UN**	3/8	.375	4	1.03	3.0
16	3/8			**MT 0250 C07 16 UN**	1/4	.236	3	.66	2.5
16	3/8			**MT 0312 C09 16 UN**	5/16	.291	3	.97	2.5
16		3/4		**MT 0500 D12 16 UN**	1/2	.472	4	1.22	3.5
14	7/16			**MT 0312 C08 14 UN**	5/16	.276	3	.82	2.5
14	7/16			**MT 0375 C11 14 UN**	3/8	.335	3	1.11	3.0
14		7/8		**MT 0625 E15 14 UN**	5/8	.591	5	1.46	4.0
13	1/2			**MT 0312 C09 13 UN**	5/16	.312	3	.88	2.5
13	1/2			**MT 0375 D12 13 UN**	3/8	.375	4	1.27	3.0
12	9/16			**MT 0375 C10 12 UN**	3/8	.375	3	1.04	3.0
12	9/16			**MT 0500 D14 12 UN**	1/2	.457	4	1.46	3.5
12		1 - 1 1/2		**MT 0625 E16 12 UN**	5/8	.625	5	1.63	4.0
11	5/8			**MT 0375 C11 11 UN**	3/8	.375	3	1.14	3.0
11	5/8			**MT 0500 D15 11 UN**	1/2	.472	4	1.50	3.5
10	3/4			**MT 0500 C14 10 UN**	1/2	.472	3	1.35	3.5
10	3/4			**MT 0625 E19 10 UN**	5/8	.579	5	1.95	4.0
9	7/8			**MT 0625 C15 9 UN**	5/8	.591	3	1.50	4.0
8	1			**MT 0625 C17 8 UN**	5/8	.625	3	1.69	4.0
7	1 1/8 - 1 1/4			**MT 0750 D17 7 UN**	3/4	.750	4	1.78	4.0

Order example: MT 1615 E37 14 UN MT7

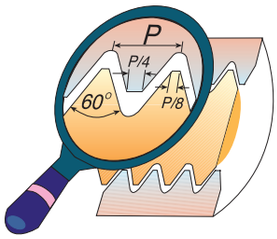
● First choice ○ Alternative

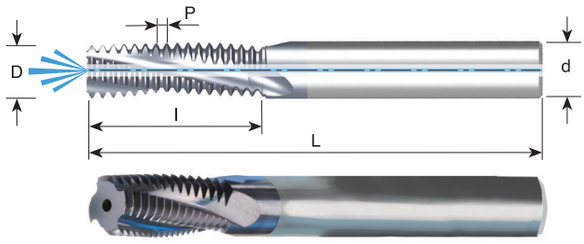
For thread mills with coolant bore see following pages

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 0250 C02 32 UN**	1/4	.126	3	.27	2.5
32			5/16	**MTB 0250 C05 32 UN**	1/4	.250	3	.58	2.5
32			3/8	**MTB 0312 D07 32 UN**	5/16	.312	4	.74	2.5
28		1/4		**MTB 0250 C04 28 UN**	1/4	.197	3	.44	2.5
28		1/4		**MTB 0250 C06 28 UN**	1/4	.205	3	.59	2.5
28			7/16-1/2	**MTB 0250 C05 28 UN**	1/4	.250	3	.56	2.5
24		5/16		**MTB 0312 C05 24 UN**	5/16	.260	3	.56	2.5
24		3/8	9/16-5/8	**MTB 0312 D08 24 UN**	5/16	.312	4	.81	2.5
20	1/4			**MTB 0250 C04 20 UN**	1/4	.185	3	.48	2.5
20		7/16-1/2		**MTB 0312 C08 20 UN**	5/16	.312	3	.83	2.5
20		1/2		**MTB 0375 D08 20 UN**	3/8	.375	4	.88	3.0
20			3/4-1	**MTB 0500 E10 20 UN**	1/2	.500	5	1.07	4.0
18	5/16			**MTB 0250 C05 18 UN**	1/4	.220	3	.58	2.5
18	5/16			**MTB 0250 C08 18 UN**	1/4	.236	3	.81	2.5
18		9/16-5/8	1 1/8-1 5/8	**MTB 0500 D10 18 UN**	1/2	.445	4	1.03	4.0
16	3/8			**MTB 0312 C06 16 UN**	5/16	.264	3	.66	2.5
16	3/8			**MTB 0312 C09 16 UN**	5/16	.291	3	.97	2.5
16		3/4		**MTB 0500 D12 16 UN**	1/2	.500	4	1.22	4.0
14	7/16			**MTB 0312 C08 14 UN**	5/16	.303	3	.82	2.5
14	7/16			**MTB 0375 C11 14 UN**	3/8	.335	3	1.11	3.0
14		7/8		**MTB 0625 E14 14 UN**	5/8	.625	5	1.46	4.0
13	1/2			**MTB 0375 C08 13 UN**	3/8	.362	3	.89	3.0
13	1/2			**MTB 0375 D12 13 UN**	3/8	.375	4	1.27	3.0
12	9/16			**MTB 0500 C10 12 UN**	1/2	.413	3	1.04	4.0
12	9/16			**MTB 0500 D14 12 UN**	1/2	.457	4	1.46	4.0
12		1-1 1/2		**MTB 0625 E16 12 UN**	5/8	.625	5	1.63	4.0
11	5/8			**MTB 0500 C11 11 UN**	1/2	.449	3	1.14	4.0
11	5/8			**MTB 0500 D15 11 UN**	1/2	.472	4	1.50	4.0
10	3/4			**MTB 0625 D13 10 UN**	5/8	.567	4	1.35	4.0
10	3/4			**MTB 0625 E19 10 UN**	5/8	.579	5	1.95	4.0
9	7/8			**MTB 0625 C15 9 UN**	5/8	.625	3	1.50	4.0
8	1			**MTB 0750 D16 8 UN**	3/4	.750	4	1.69	4.0
7	1 1/8 - 1 1/4			**MTB 0750 D17 7 UN**	3/4	.750	4	1.78	4.0

Order example: MTB 1212 D31 16 UN MT7

● First choice ○ Alternative

For thread mills with coolant through the flutes see next page

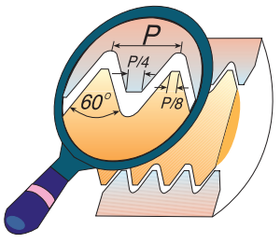
For small thread mills see pages B09-5, 6, 12, 15, 17 and B11-4, 6

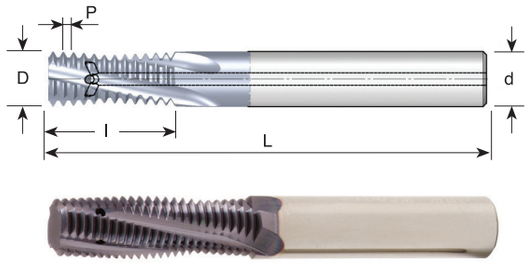
Mill-Thread Solid Carbide

Carmex Precision Tools Ltd.

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 mm	D	No. of Flutes	l	L
28		1/4		**MTZ 0605 C11 28 UN**	6	.197	3	.44	2.3
28			7/16-1/2	**MTZ 0606 C14 28 UN**	6	.236	3	.56	2.3
24		5/16		**MTZ 08066 C14 24 UN**	8	.260	3	.56	2.5
24		3/8	9/16-5/8	**MTZ 0808 D21 24 UN**	8	.315	4	.81	2.5
20		7/16		**MTZ 0808 C21 20 UN**	8	.315	3	.83	2.5
20		1/2		**MTZ 1010 D22 20 UN**	10	.394	4	.88	2.9
20			3/4-1	**MTZ 1212 E27 20 UN**	12	.472	5	1.07	3.3
18	5/16			**MTZ 06056 C14 18 UN**	6	.220	3	.58	2.3
18	5/16			**MTZ 0606 C20 18 UN**	6	.236	3	.81	2.3
18		9/16-5/8	1 1/8-1 5/8	**MTZ 12113 D26 18 UN**	12	.445	4	1.03	3.3
16	3/8			**MTZ 08067 C16 16 UN**	8	.264	3	.66	2.5
16	3/8			**MTZ 08074 C24 16 UN**	8	.291	3	.97	2.5
16		3/4		**MTZ 1212 D31 16 UN**	12	.472	4	1.22	3.3
14	7/16			**MTZ 08077 C20 14 UN**	8	.303	3	.82	2.5
14	7/16			**MTZ 10085 C28 14 UN**	10	.335	3	1.11	2.9
14		7/8		**MTZ 1616 E37 14 UN**	16	.630	5	1.46	4.0
13	1/2			**MTZ 10092 C22 13 UN**	10	.362	3	.89	2.9
13	1/2			**MTZ 10098 D32 13 UN**	10	.386	4	1.27	2.9
12	9/16			**MTZ 12105 C26 12 UN**	12	.413	3	1.04	3.3
12	9/16			**MTZ 12116 D37 12 UN**	12	.457	4	1.46	3.3
12		1-1 1/2		**MTZ 1616 E41 12 UN**	16	.630	5	1.63	4.0
11	5/8			**MTZ 12114 C28 11 UN**	12	.449	3	1.14	3.3
10	3/4			**MTZ 16144 D34 10 UN**	16	.567	4	1.35	4.0

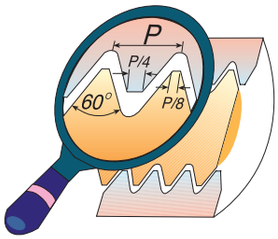
Order example: MTZ 0808 D21 24 UN MT7

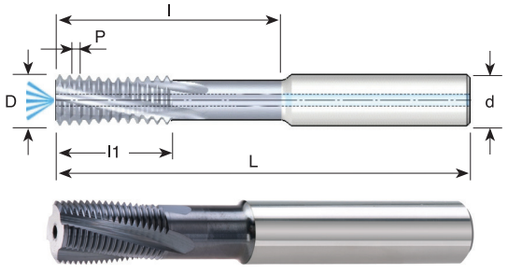
● First choice ○ Alternative

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 mm	D	No. of Flutes	l1	l	L
20	Ø ≥ .47	**MTQ 1010 D30 20 UN**	10	.394	4	.70	1.20	2.9
20	Ø ≥ .55	**MTQ 1212 E35 20 UN**	12	.472	5	.80	1.40	3.3
20	Ø ≥ .71	**MTQ 1616 F43 20 UN**	16	.630	6	1.00	1.70	4.1
18	Ø ≥ .59	**MTQ 1212 D35 18 UN**	12	.472	4	.78	1.39	3.3
16	Ø ≥ .59	**MTQ 1212 D35 16 UN**	12	.472	4	.81	1.38	3.3
16	Ø ≥ .75	**MTQ 1616 E42 16 UN**	16	.630	5	1.00	1.69	4.1
16	Ø ≥ .91	**MTQ 2020 F58 16 UN**	20	.787	6	1.44	2.31	4.1
14	Ø ≥ .79	**MTQ 1616 E45 14 UN**	16	.630	5	1.00	1.78	4.1
12	Ø ≥ .63	**MTQ 1212 D42 12 UN**	12	.472	4	1.00	1.67	3.3
12	Ø ≥ .95	**MTQ 2020 E55 12 UN**	20	.787	5	1.33	2.17	4.1

Order example: MTQ 1212 D35 16 UN MT7

● First choice ○ Alternative

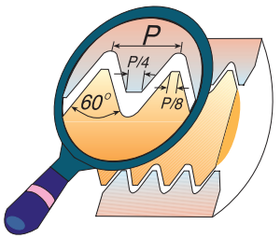
For small thread mills see pages B09-5, 6, 12, 15, 17 and B11-4, 6

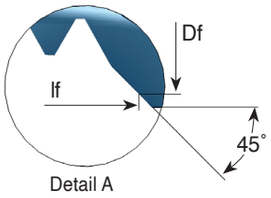
Mill-Thread Solid Carbide

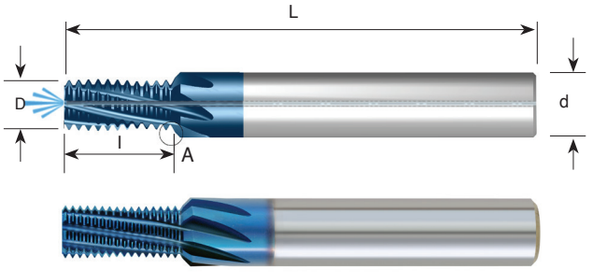
Carmex Precision Tools Ltd.

UN Fast MT with internal coolant bore

Tools for Internal Thread







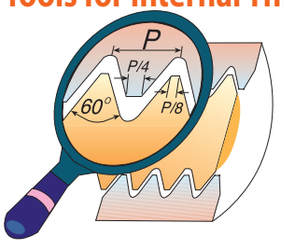
Grade	P	M	K	N	S	H
MT8	●	●	●	○	●	≤52 HRc

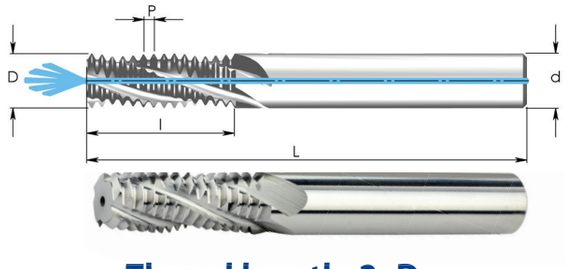
Pitch TPI	UNC	UNF	UNEF	Ordering Code	d mm	D	Df	No. of Flutes	l	lf	L
28		1/4		**FMT 08052 F11 28 UN**	8	.205	.283	6	.44	.48	2.5
28			7/16-1/2	**FMT 12098 H19 28 UN**	12	.386	.465	8	.77	.81	3.3
24		5/16		**FMT 10066 G14 24 UN**	10	.260	.378	7	.56	.62	2.9
24		3/8	9/16, 5/8, 11/16	**FMT 12082 G17 24 UN**	12	.323	.417	7	.69	.74	3.3
20	1/4			* **FMT 08048 E12 20 UN**	8	.189	.268	5	.48	.52	2.5
20		7/16		**FMT 12092 H21 20 UN**	12	.362	.449	8	.83	.87	3.3
20		1/2	3/4, 7/8, 1	**FMT 14111 H22 20 UN**	14	.437	.531	8	.87	.92	3.3
18	5/16			**FMT 1006 F14 18 UN**	10	.236	.331	6	.58	.63	2.9
18		9/16, 5/8	1 1/16, 1 1/8	**FMT 16125 H26 18 UN**	16	.492	.591	8	1.03	1.08	4.1
16	3/8			**FMT 10074 F16 16 UN**	10	.291	.378	6	.66	.70	2.9
16		3/4		**FMT 20167 H34 16 UN**	20	.657	.760	8	1.34	1.39	4.1
14	7/16	7/8		**FMT 12085 F20 14 UN**	12	.335	.421	6	.82	.87	3.3
13	1/2			**FMT 12098 F24 13 UN**	12	.386	.465	6	.96	1.00	3.3
12	9/16	1		**FMT 16116 F26 12 UN**	16	.457	.598	6	1.04	1.11	4.1
11	5/8			**FMT 1612 F33 11 UN**	16	.472	.606	6	1.31	1.38	4.1

Order example: FMT 08048 E12 20 UN MT8
* 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 mm	D	No. of Flutes	l	L
32	8	10	12	**AMT 06032 C9 32 UN**	6	.126	3	.36	2.3
28		1/4		**AMT 06052 C14 28 UN**	6	.205	3	.55	2.3
24		3/8	9/16-5/8	**AMT 0808 D20 24 UN**	8	.315	4	.81	2.5
20	1/4			**AMT 06048 C14 20 UN**	6	.189	3	.57	2.3
20		7/16		**AMT 10092 C23 20 UN**	10	.362	3	.92	2.9
18	5/16			**AMT 0606 C17 18 UN**	6	.236	3	.69	2.3
18		9/16-5/8	1 1/8 - 1 5/8	**AMT 1212 D30 18 UN**	12	.472	4	1.19	3.3
16	3/8			**AMT 08074 C21 16 UN**	8	.291	3	.84	2.5
16		3/4		**AMT 1616 E38 16 UN**	16	.630	5	1.53	4.1

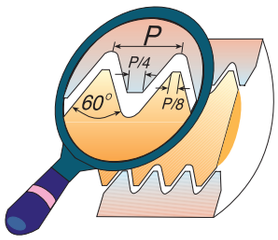
For information about AMT Thread Mills and cutting data see page B12-16

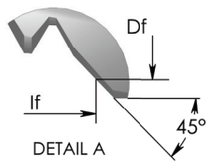
● First choice ○ Alternative

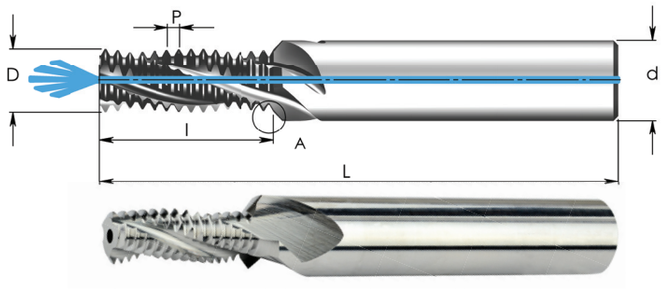
Mill-Thread Solid Carbide

UN With internal coolant bore and cutting chamfer

Tools for Internal Thread







Thread length: 2xD

Grade	P	M	K	N	S	H
K20	○	○	●	●	●	

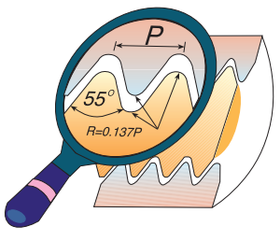
Pitch TPI	UNC	UNF	UNEF	Ordering Code	d mm	D	Df	No. of Flutes	l	lf	L
20	1/4			**AMT 08048 C14 20UN-C**	8	.189	.27	3	.57	.61	2.5
18	5/16			**AMT 1006 C17 18UN-C**	10	.236	.33	3	.69	.74	2.9
16	3/8			**AMT 12074 C21 16UN-C**	12	.291	.39	3	.84	.89	3.3

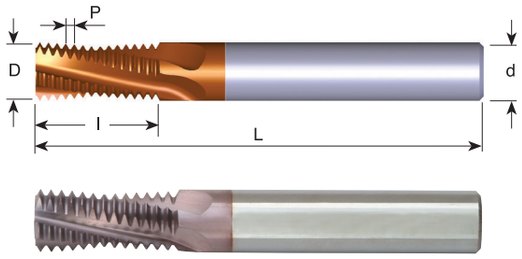
Order example: AMT 12074 C21 16UN-C K20

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 mm	D	No. of Flutes	l	L
28	G1/16-G1/8	**MT 0606 C9 28 W**	6	.236	3	.38	2.3
19	G1/4-3/8	**MT 0808 C14 19 W**	8	.315	3	.55	2.5
14	G1/2-7/8	**MT 1212 D19 14 W**	12	.472	4	.75	3.3
14	G1/2-7/8	**MT 1212 D26 14 W**	12	.472	4	1.04	3.3
11	G≥1	**MT 1212 C24 11 W**	12	.472	3	.95	3.3
11	G≥1	**MT 1616 D38 11 W**	16	.630	4	1.50	4.1
11	G≥1	**MT 2020 E47 11 W**	20	.787	5	1.86	4.1

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

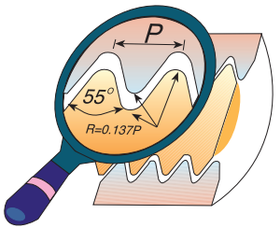
● First choice ○ Alternative

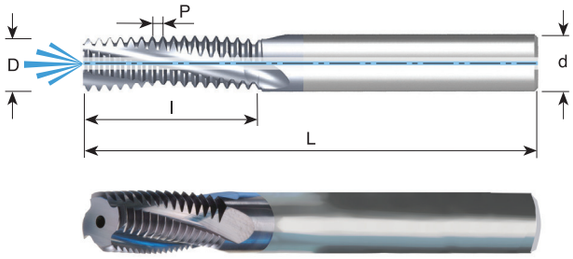
Mill-Thread Solid Carbide

Carmex Precision Tools Ltd.

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

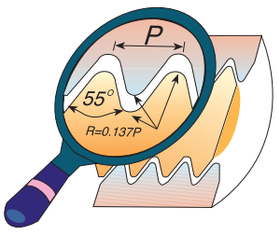
Pitch TPI	Standard	Ordering Code	d mm	D	No. of Flutes	l	L
28	G1/8	**MTB 08078 C14 28 W**	8	.307	3	.56	2.5
28	G1/8	**MTB 0808 C20 28 W**	8	.315	3	.80	2.5
19	G1/4	**MTB 1010 D16 19 W**	10	.394	4	.66	2.9
19	G1/4	**MTB 1211 D27 19 W**	12	.433	4	1.08	3.3
19	G3/8	**MTB 1414 D26 19 W**	14	.551	4	1.03	3.3
19	G3/8	**MTB 1414 D34 19 W**	14	.551	4	1.34	3.3
14	G1/2-7/8	**MTB 1616 E26 14 W**	16	.630	5	1.04	4.1
11	G≥1	**MTB 1616 D38 11 W**	16	.630	4	1.50	4.1
11	G≥1	**MTB 2020 E47 11 W**	20	.787	5	1.86	4.1

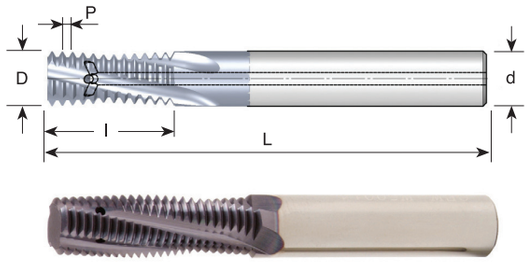
Order example: MTB 1010 D16 19 W MT7

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 mm	D	No. of Flutes	l	L
28	G1/8	**MTZ 08078 C14 28 W**	8	.307	3	.56	2.5
19	G1/4-3/8	**MTZ 1010 D16 19 W**	10	.394	4	.66	2.9
14	G1/2-7/8	**MTZ 1616 E26 14 W**	16	.630	5	1.04	4.0
11	G≥1	**MTZ 1616 D38 11 W**	16	.630	4	1.50	4.0

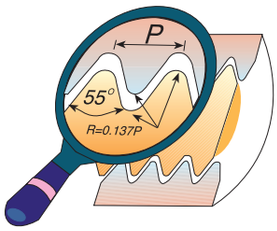
Order example: MTZ 08078 C14 28 W MT7

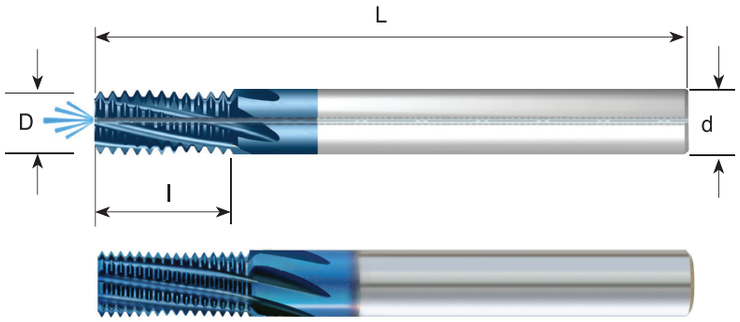
For small thread mills see pages B09-7, B09-14 and B11-5

● 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 mm	D	No. of Flutes	l	L
28	G1/8	**FMT 08078 H14 28 W**	8	.307	8	.56	2.5
19	G1/4-3/8	**FMT 1010 G16 19 W**	10	.394	7	.66	2.9
14	G1/2-7/8	**FMT 1414 H26 14 W**	14	.551	8	1.04	3.3
11	G≥1	**FMT 1616 H38 11 W**	16	.630	8	1.50	4.1

Order example: FMT 1616 H38 11W MT8

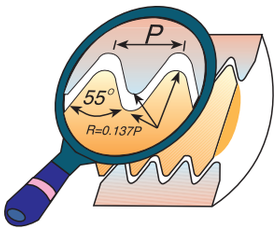
● First choice ○ Alternative

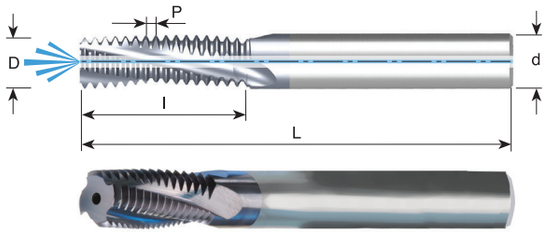
Mill-Thread Solid Carbide

Carmex Precision Tools Ltd.

Whitworth With internal coolant bore

Same Tool for Internal and External Thread





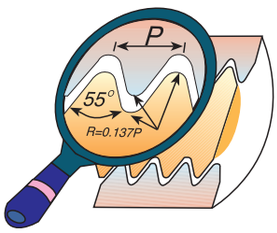
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

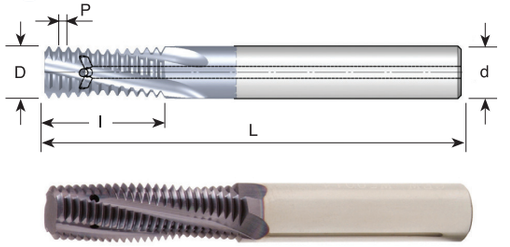
Pitch TPI	BSW	BSF	Ordering Code	d mm	D	No. of Flutes	l	L
20	1/4		**MTB 06046 C13 20 W**	6	.181	3	.52	2.3
20		3/8	**MTB 08076 D19 20 W**	8	.299	4	.78	2.5
18	5/16		**MTB 06056 C16 18 W**	6	.220	3	.64	2.3
18		7/16	**MTB 10088 D23 18 W**	10	.346	4	.92	2.9
16	3/8		**MTB 0807 D19 16 W**	8	.276	4	.78	2.5
16		1/2-9/16	**MTB 1010 E26 16 W**	10	.394	5	1.03	2.9
14	7/16		**MTB 0808 D22 14 W**	8	.315	4	.89	2.5
14		5/8-11/16	**MTB 14128 E31 14 W**	14	.504	5	1.25	3.3
12	1/2-9/16	3/4-13/16	**MTB 1009 D26 12 W**	10	.354	4	1.04	2.9
11	5/8	7/8	**MTB 12118 E33 11 W**	12	.465	5	1.32	3.3
10	3/4	1	**MTB 1414 E39 10 W**	14	.551	5	1.55	4.1
9	7/8	1 1/8	**MTB 1616 E43 9 W**	16	.630	5	1.72	4.1

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 mm	D	No. of Flutes	l	L
20	1/4	3/8	* **MTZ 06046 C12 20 W**	6	.181	3	.48	2.3
18	5/16	7/16	**MTZ 06053 C14 18 W**	6	.209	3	.58	2.3
16	3/8		**MTZ 08068 C16 16 W**	8	.268	3	.66	2.5
16		1/2-9/16	**MTZ 10092 D24 16 W**	10	.362	4	.97	2.9
14	7/16	5/8-11/16	**MTZ 08078 D20 14 W**	8	.307	4	.82	2.5
12	1/2	3/4-13/16	**MTZ 10086 D24 12 W**	10	.339	4	.96	2.9
11	5/8	7/8	**MTZ 12109 D28 11 W**	12	.429	4	1.14	3.3

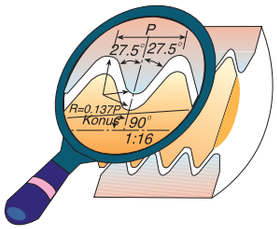
Order example: MTZ 08068 C16 16 W MT7

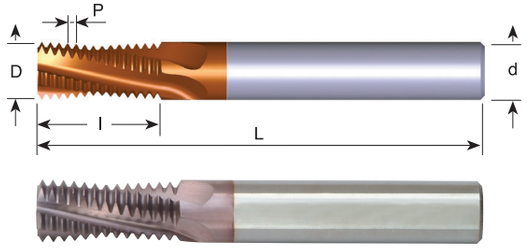
* Cutter without coolant

● 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 mm	D	No. of Flutes	l	L
28	RC1/16-1/8	**MT 0606 C9 28 BSPT**	6	.236	3	.37	2.3
19	RC1/4-3/8	**MT 0808 C14 19 BSPT**	8	.315	3	.55	2.5
14	RC1/2-7/8	**MT 1212 D19 14 BSPT**	12	.472	4	.75	3.3
11	RC1-2	**MT 1616 D28 11 BSPT**	16	.630	4	1.14	4.1

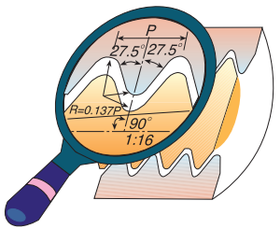
Order example: MT 1616 D28 11 BSPT MT7

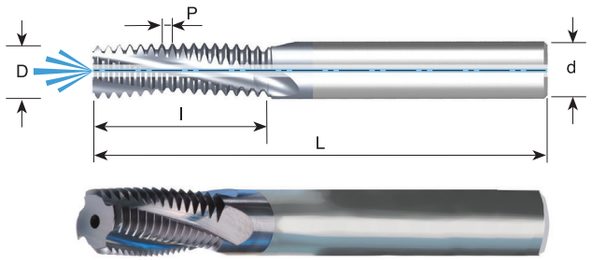
For thread mills with coolant through the flutes see next page

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 mm	D	No. of Flutes	l	L
28	RC1/8	**MTB 08078 C14 28 BSPT**	8	.307	3	.56	2.5
19	RC1/4-3/8	**MTB 1010 D16 19 BSPT**	10	.394	4	.66	2.9
14	RC1/2-7/8	**MTB 1616 E26 14 BSPT**	16	.630	5	1.04	4.1
11	RC1-2	**MTB 1616 D28 11 BSPT**	16	.630	4	1.14	4.1

Order example: MTB 08078 C14 28 BSPT MT7

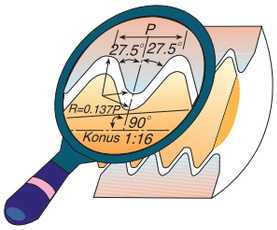
● First choice ○ Alternative

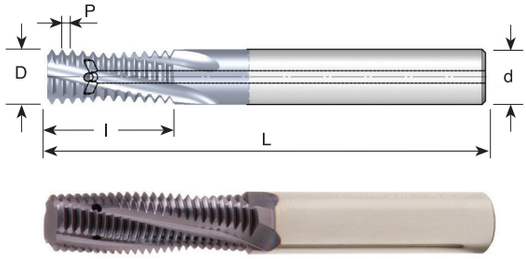
Mill-Thread Solid Carbide

Carmex Precision Tools Ltd.

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 mm	D	No. of Flutes	l	L
28	RC1/8	**MTZ 08078 C14 28 BSPT**	8	.307	3	.56	2.5
19	RC1/4-3/8	**MTZ 1010 D16 19 BSPT**	10	.394	4	.66	2.9
14	RC1/2-7/8	**MTZ 1616 E26 14 BSPT**	16	.630	5	1.04	4.0
11	RC1-2	**MTZ 1616 D28 11 BSPT**	16	.630	4	1.14	4.0

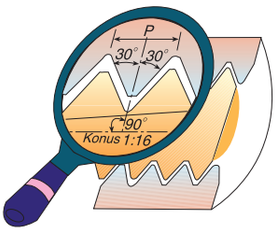
Order example: MTZ 1010 D16 19 BSPT MT7

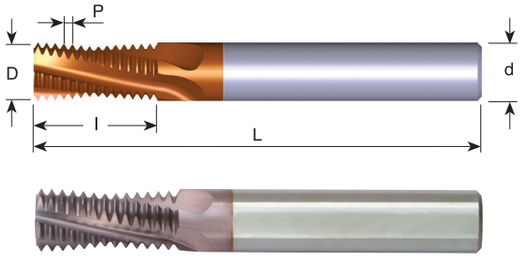
● First choice ○ Alternative

For conical preparation end mills see page B08-23

NPT

Same Tool for Internal and External Thread





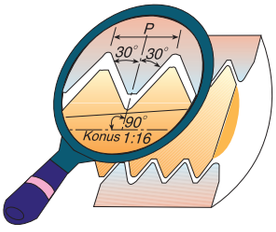
Grade	P	M	K	N	S	H
MT7	●	○	●	○	○	

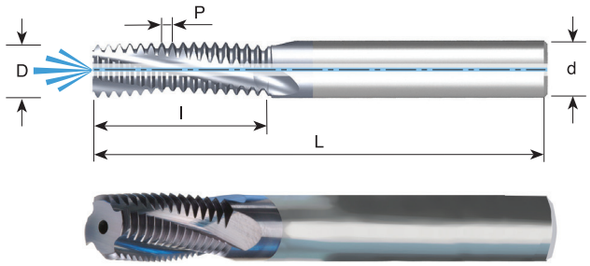
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
27	1/16	**MT 0250 C03 27 NPT**	1/4	.230	3	.39	2.5
27	1/8	**MT 0250 C04 27 NPT**	1/4	.250	3	.39	2.5
18	1/4-3/8	**MT 0312 C06 18 NPT**	5/16	.312	3	.58	2.5
14	1/2-3/4	**MT 0500 D08 14 NPT**	1/2	.500	4	.82	3.5
11.5	1-2	**MT 0625 D11 11.5 NPT**	5/8	.625	4	1.09	4.0
8	≥ 2 1/2	**MT 0750 D16 8 NPT**	3/4	.750	4	1.56	4.0

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 0312 C04 27 NPT**	5/16	.299	3	.43	2.5
18	1/4-3/8	**MTB 0375 D06 18 NPT**	3/8	.375	4	.64	3.0
14	1/2-3/4	**MTB 0625 D08 14 NPT**	5/8	.610	4	.89	4.0
11.5	1-2	**MTB 0750 D11 11.5 NPT**	3/4	.750	4	1.17	4.0
8	≥ 2 1/2	**MTB 0750 D15 8 NPT**	3/4	.750	4	1.56	4.0

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

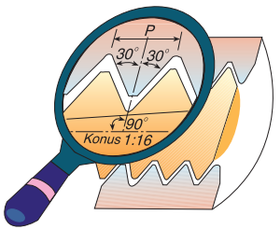
● First choice ○ Alternative

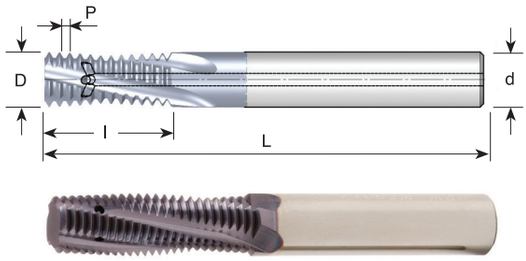
Mill-Thread Solid Carbide

Carmex Precision Tools Ltd.

NPT With internal coolant through the flutes

Same Tool for Internal and External Thread





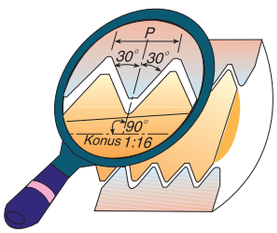
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

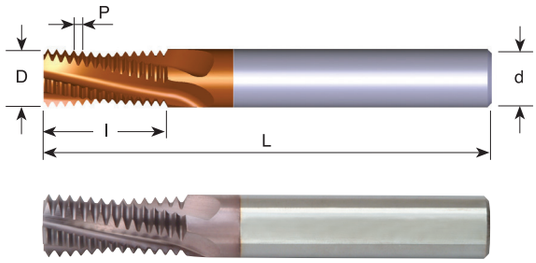
Pitch TPI	Standard	Ordering Code	d mm	D	No. of Flutes	l	L
27	1/8	**MTZ 08076 C10 27 NPT**	8	.299	3	.43	2.5
18	1/4-3/8	**MTZ 1010 D16 18 NPT**	10	.394	4	.64	2.9
14	1/2-3/4	**MTZ 16155 D22 14 NPT**	16	.610	4	.89	4.0

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	**MT 0250 C03 27 NPTF**	1/4	.230	3	.39	2.5
27	1/8	**MT 0250 C04 27 NPTF**	1/4	.250	3	.39	2.5
18	1/4-3/8	**MT 0312 C06 18 NPTF**	5/16	.312	3	.58	2.5
14	1/2-3/4	**MT 0500 D08 14 NPTF**	1/2	.500	4	.82	3.5
11.5	1-2	**MT 0625 D11 11.5 NPTF**	5/8	.625	4	1.09	4.0
8	≥ 2 1/2	**MT 0750 D16 8 NPTF**	3/4	.750	4	1.56	4.0

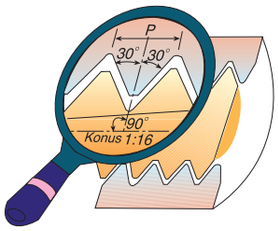
Order example: MT 1212 D20 14 NPTF MT7

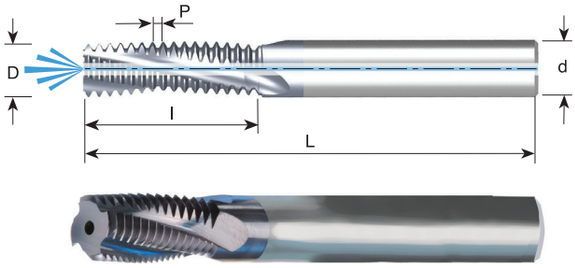
For thread mills with coolant bore see next page
For conical preparation end mills see page B08-23

● First choice ○ Alternative

NPTF With internal coolant bore

Same Tool for Internal and External Thread





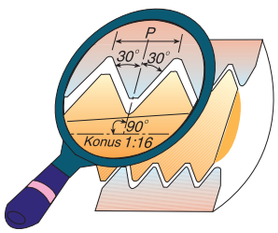
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

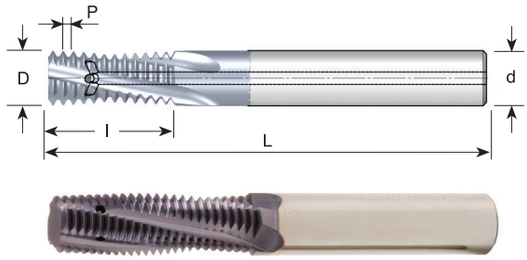
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
27	1/8	**MTB 0312 C04 27 NPTF**	5/16	.299	3	.43	2.5
18	1/4-3/8	**MTB 0375 D06 18 NPTF**	3/8	.375	4	.64	3.0
14	1/2-3/4	**MTB 0625 D08 14 NPTF**	5/8	.610	4	.89	4.0
11.5	1-2	**MTB 0750 D11 11.5 NPTF**	3/4	.750	4	1.17	4.0
8	≥ 2 1/2	**MTB 0750 D15 8 NPTF**	3/4	.750	4	1.56	4.0

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 mm	D	No. of Flutes	l	L
27	1/8	**MTZ 08076 C10 27 NPTF**	8	.299	3	.43	2.5
18	1/4-3/8	**MTZ 1010 D16 18 NPTF**	10	.394	4	.64	2.9
14	1/2-3/4	**MTZ 16155 D22 14 NPTF**	16	.610	4	.89	4.0

Order example: MTZ 1010 D16 18 NPTF MT7

For conical preparation end mills see page B08-23

● First choice ○ Alternative

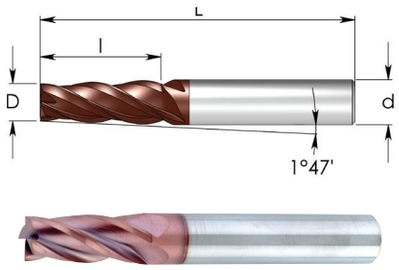
Carmex Precision Tools Ltd.

Solid Carbide Tapered End Mills

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

Advantages:

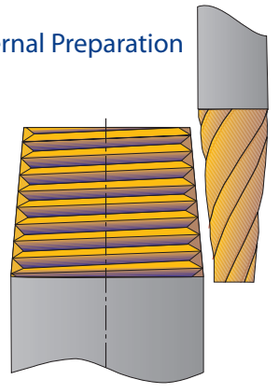
* Increases the tool life of mill thread cutters and indexable inserts.
* Equal and uniform load along the cutting edge of the mill thread cutter.
* Shorter machining time during the mill thread operation, due to the tapered preparation.
* Same tool for internal and external preparation.



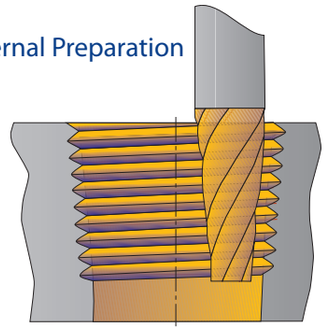
Ordering Code	d	D	l	L	No. of Flutes	Size
SC0652D12	6 mm	.20	.47	2.3	4	NPT 1/16 - 1/8 NPTF 1/16 - 1/8 BSPT 1/16 - 1/8
SC0375D09	3/8	.32	.95	3.0	4	NPT 1/8 - 1 NPTF 1/8 - 1 BSPT 1/8 - 1
SC0500D12	1/2	.42	1.26	3.5	4	NPT 1/4 - 3 NPTF 1/4 - 3 BSPT 1/4 - 3

Order example: SC 0500D12 MT7

External Preparation

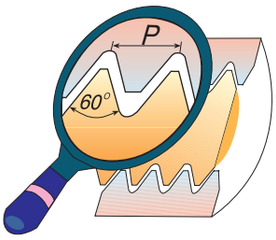


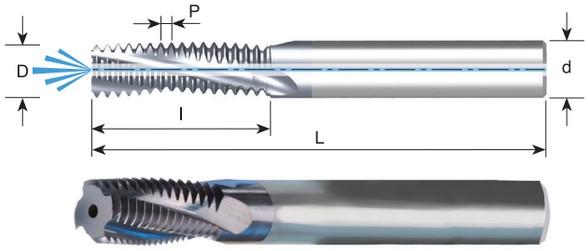
Internal Preparation



NPS With internal coolant bore

Same Tool for Internal and External Thread - Inch Shank





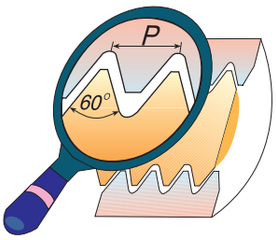
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

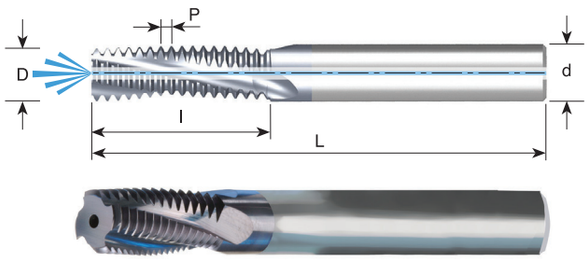
Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	l	L
27	1/8	**MTB0312C04 27 NPS**	5/16	.299	3	.43	2.5
18	1/4-3/8	**MTB0375D06 18 NPS**	3/8	.375	4	.64	3.0
14	1/2-3/4	**MTB0625D08 14 NPS**	5/8	.610	4	.89	4.0
11.5	1-2	**MTB0750D11 11.5 NPS**	3/4	.750	4	1.17	4.0

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	D	No. of Flutes	l	L
27	1/8	**MTB0312C04 27 NPSF**	5/16	.299	3	.43	2.5
18	1/4-3/8	**MTB0375D06 18 NPSF**	3/8	.375	4	.64	3.0
14	1/2-3/4	**MTB0625D08 14 NPSF**	5/8	.610	4	.89	4.0
11.5	1-2	**MTB0750D11 11.5 NPSF**	3/4	.750	4	1.17	4.0

Order example: MTB 0312 C04 27 NPSF MT7

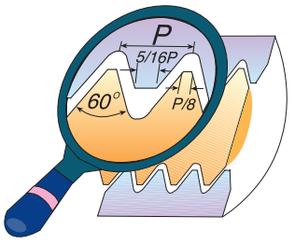
● First choice ○ Alternative

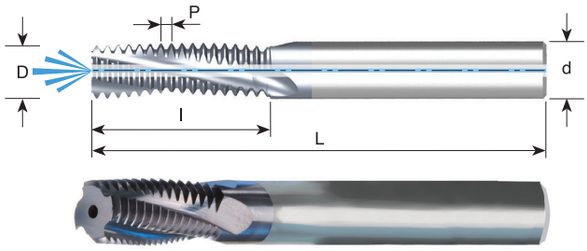
Mill-Thread Solid Carbide

Carmex Precision Tools Ltd.

MJ With internal coolant bore

Tools for internal thread





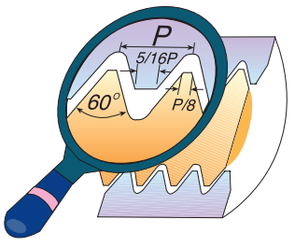
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

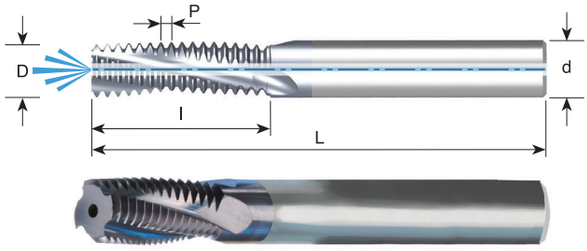
Pitch mm	Thread	Ordering Code	d mm	D	No. of Flutes	l	L
0.7	MJ4	**MTB 06032 C8 0.7 MJ**	6	.126	3	.32	2.3
0.8	MJ5	**MTB 0604 C10 0.8 MJ**	6	.157	3	.39	2.3
1.0	MJ6	**MTB 06048 D12 1.0 MJ**	6	.189	4	.49	2.3
1.25	MJ8	**MTB 08064 D15 1.25 MJ**	8	.252	4	.61	2.5
1.5	MJ10	**MTB 0808 D20 1.5 MJ**	8	.315	4	.80	2.5
1.75	MJ12	**MTB 10095 D23 1.75 MJ**	10	.374	4	.93	2.9

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

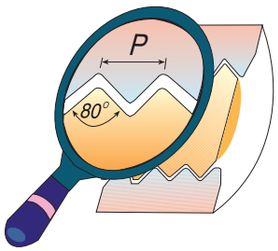
Pitch TPI	UNJC	UNJF	Ordering Code	d mm	D	No. of Flutes	l	L
28		1/4	**MTB 06052 D13 28 UNJ**	6	.205	4	.52	2.3
24		5/16	**MTB 08066 D16 24 UNJ**	8	.260	4	.65	2.5
24		3/8	**MTB 10082 D19 24 UNJ**	10	.323	4	.77	2.9
20	1/4		**MTB 06048 C13 20 UNJ**	6	.189	3	.52	2.3
20		7/16-1/2	**MTB 10092 D22 20 UNJ**	10	.362	4	.87	2.9
18	5/16		**MTB 0606 C16 18 UNJ**	6	.236	3	.64	2.3
16	3/8		**MTB 08074 D19 16 UNJ**	8	.291	4	.78	2.5
14	7/16		**MTB 10085 D22 14 UNJ**	10	.335	4	.89	2.9
13	1/2		**MTB 10098 D26 13 UNJ**	10	.386	4	1.04	2.9
12	9/16		**MTB 12116 D28 12 UNJ**	12	.457	4	1.13	3.3

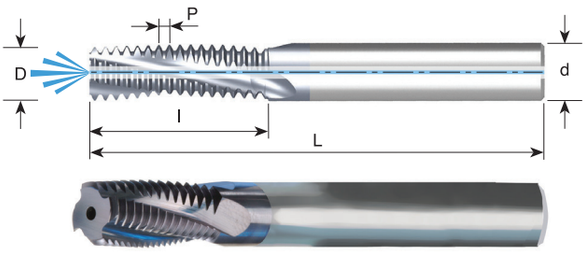
Order example: MTB 0606 C16 18 UNJ MT7

● 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 mm	D	No. of Flutes	l	L
20	Pg 7	**MTB 1010 D19 20 PG**	10	.394	4	.78	2.9
18	Pg 9, 11, 13.5, 16	**MTB 1212 D20 18 PG**	12	.472	4	.81	3.3
16	Pg 21, 29, 36, 42, 48	**MTB 1212 D23 16 PG**	12	.472	4	.91	3.3

Order example: MTB 1212 D20 18 PG MT7

● First choice ○ Alternative

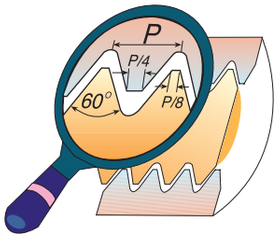
Carmex Precision Tools Ltd.

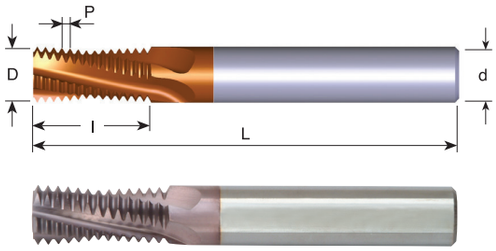
Mill - Thread Solid Carbide for External Threads

Advantages:

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

ISO



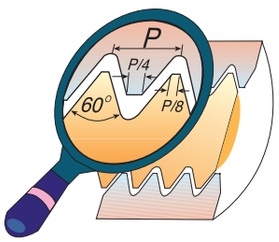


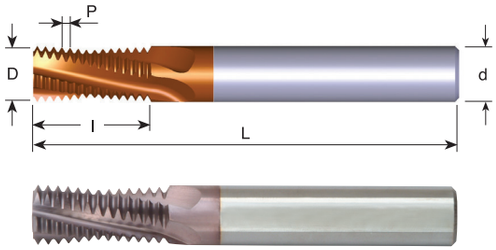
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch mm	Ordering Code	d mm	D	No. of Flutes	l	L
1.0	**EMT 1010 D16 1.0 ISO**	10	.394	4	.65	2.9
1.0	**EMT 1212 E20 1.0 ISO**	12	.472	5	.81	3.3
1.25	**EMT 1010 D16 1.25 ISO**	10	.394	4	.67	2.9
1.5	**EMT 1010 D15 1.5 ISO**	10	.394	4	.62	2.9
1.5	**EMT 1212D20 1.5 ISO**	12	.472	4	.80	3.3
1.75	**EMT 1212 D20 1.75 ISO**	12	.472	4	.79	3.3
2.0	**EMT 1010 C17 2.0 ISO**	10	.394	3	.67	2.9
2.0	**EMT 1212 D21 2.0 ISO**	12	.472	4	.83	3.3

Order example: EMT 1010 D15 1.5 ISO MT7

UN





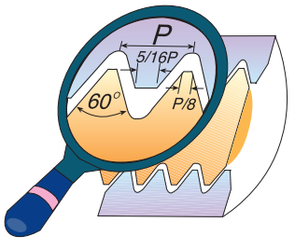
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

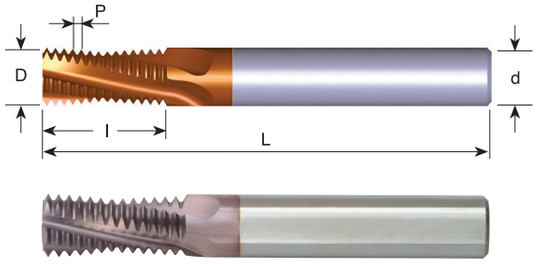
Pitch TPI	Ordering Code	d mm	D	No. of Flutes	l	L
24	**EMT 1010 D16 24 UN**	10	.394	4	.65	2.9
20	**EMT 1212 E21 20 UN**	12	.472	5	.83	3.3
18	**EMT 1212 D20 18 UN**	12	.472	4	.81	3.3
16	**EMT 1212 D21 16 UN**	12	.472	4	.84	3.3
14	**EMT 1212 D20 14 UN**	12	.472	4	.82	3.3
12	**EMT 1212 D20 12 UN**	12	.472	4	.79	3.3

Order example: EMT 1212 D20 18 UN MT7

● First choice ○ Alternative

MJ



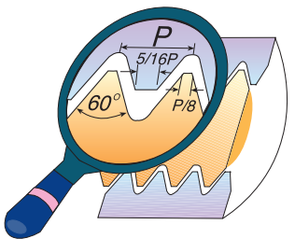


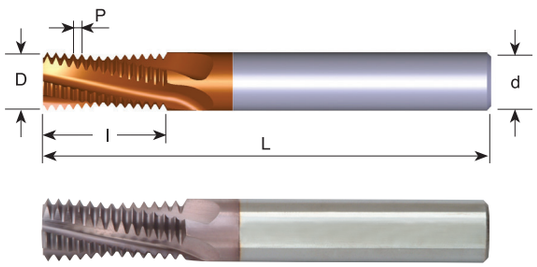
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

Pitch mm	Ordering Code	d mm	D	No. of Flutes	l	L
1.0	**EMT 1010 D20 1.0 MJ**	10	.394	4	.81	2.8
1.0	**EMT 1212 E24 1.0 MJ**	12	.472	5	.96	3.3
1.25	**EMT 1010 D19 1.25 MJ**	10	.394	4	.76	2.8
1.5	**EMT 1010 D21 1.5 MJ**	10	.394	4	.86	2.8
1.5	**EMT 1212 D26 1.5 MJ**	12	.472	4	1.04	3.3
1.75	**EMT 1212 D27 1.75 MJ**	12	.472	4	1.07	3.3
2.0	**EMT 1010 C21 2.0 MJ**	10	.394	3	.83	2.8
2.0	**EMT 1212 D27 2.0 MJ**	12	.472	4	1.06	3.3

Order example: EMT 1010 C21 2.0 MJ MT7

UNJ UNJC, UNJF, UNJEF, UNJS





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

TPI	Ordering Code	d mm	D	No. of Flutes	l	L
32	**EMT 0606 C13 32 UNJ**	6	.236	3	.55	2.2
28	**EMT 0808 D17 28 UNJ**	8	.315	4	.70	2.5
24	**EMT 1010 D20 24 UNJ**	10	.394	4	.81	2.8
20	**EMT 1212 E27 20 UNJ**	12	.472	5	1.07	3.3
18	**EMT 1212 D26 18 UNJ**	12	.472	4	1.03	3.3
16	**EMT 1212 D26 16 UNJ**	12	.472	4	1.03	3.3
14	**EMT 1212 D26 14 UNJ**	12	.472	4	1.04	3.3
12	**EMT 1212 D26 12 UNJ**	12	.472	4	1.04	3.3

Order example: EMT 0808 D17 28 UNJ MT7

For cutting data information see page B12-12

● First choice ○ Alternative