Thread Milling Cutters

Threading and deburring in one operation

ThreadBurr

- Threading and deburring in one operation
- No additional time for deburring

Contents

THREAD MILLING TOOLS

Thread milling

ADVANTAGES

A secure machining operation

Minimal risk for machining stops as the cutting forces are low and the chips are short. Should there be an accident, the work piece will not be destroyed, as the tool will not be caught since the diameter of the thread mill is less than the thread.

Higher quality thread

The cutting conditions are extremely good when you are thread milling. The result of the thread is a higher quality of surface finish, tolerance, angle, etc. compared with other threading methods.

Correct Thread Diameter right away

The Pitch diameter has been optically measured on thread mills from SmiCut and the theoretical external diameter has been individually laser marked on each cutter so you will get a correct thread straight away. When the tool starts to wear it´s possible to make adjustments in the CNC-program.

Flexible tool

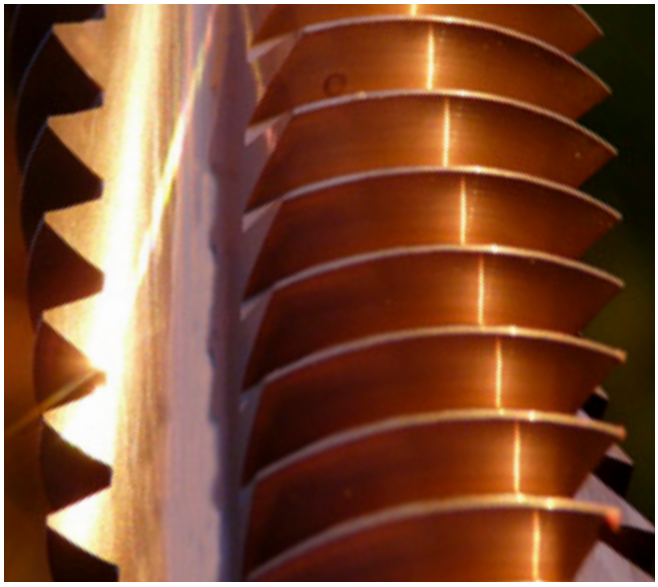
Same cutter can be used for right hand and left hand thread. Threads with different diameters can be made with the same tool as long as the pitch is the same. The same thread mill can be used for blind holes and through holes. W, BSPT, PG, NPT, NPTF and NPSF are thread profiles where you can use the same tool for external and internal thread.

Threading without burrs

The thread entrance will be burr free when using ThreadBurr. Threading and deburring in one operation. No additional time for deburring.

Shorter machining time

The machining time will be short as you don´t need to chamfer the thread while using ThreadBurr. Big diameters, fine pitches and long holes saves the most time compared with thread tapping. Thread milling in a lathe with live tools saves time compared with thread turning.



Threading in difficult machined materials

The excellent cutting conditions makes it possible to thread mill materials such as hardened steel up to HRC 65, Titanium and other difficult machined materials.

Threading in blind holes

When thread milling you will get a complete thread profile to the bottom of the hole. When tapping it´s necessary to drill much deeper as it´s not until the third thread the tap will make a complete thread profile. Sometimes you are able to change the construction as you don´t have to take the deep hole into consideration.

Less wear on the machine spindle

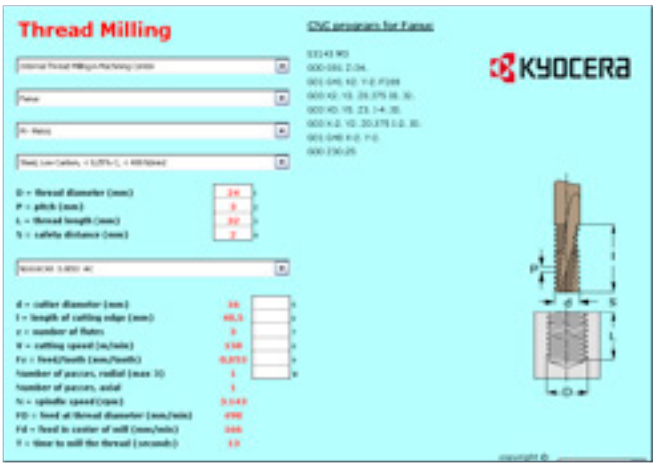
Thread milling will give you longer life to the machine spindle compared with tapping as the rotation on the spindle doesn´t need to be stopped and reversed for every thread.

Thread milling

SOFTWARE

Makes it easy to Thread Mill

Specify control system, material, thread diameter, pitch and thread length. The program will recommend suitable tools. Choose one and you will recieve suggested cutting data, time to mill the thread and CNC programming code. The software is made in excel and is less than 500kb even though it includes 19 different languages. It will be mailed free of charge.



Choose among these languages

- Chinese (simp.)
- Chinese (trad.)
- Danish
- Dutch
- English
- Estonian
- Finish
- French
- Italian
- Japanese
- Korean
- Norweigan
- Polish
- Portuguese
- Romanian
- Russian
- Spanish
- Swedish
- German

Code Key

NB	10	10	D	23	1.5	ISO	AC
Type of Tool	Shank Dimension	Cutter Diameter	Cutting Edges	Cutting Length	Pitch	Thread Profile	Carbide Grade

N = Internal threading
E = External threading
X = In- and external threading
B = Burring
F = Chamfering
S = Micro, one tooth
M = Micro, two teeth
K = Internal coolant
T = Internal radial coolant

C = Three flute
D = Four flute
E = Five flute
F = Six flute

Cutting data

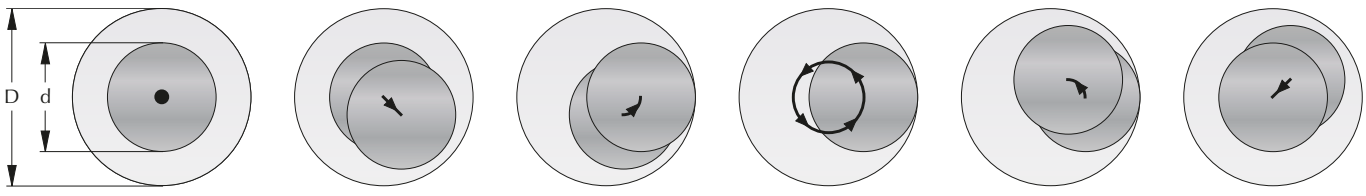
THREAD MILLING

Cutting Speed (V_c) and Material Factor (F_m)

Material		Hardness HB	Tensile Strength N/mm²	Cutting Speed (V_c) m/min	Material Factor (F_m)
Steel	Low carbon, C < 0,25%	< 120	< 400	150 - 200	1,2
	Medium carbon, C < 0,55%	< 200	< 700	120 - 170	1,1
	High carbon, C < 0,85%	< 250	< 850	110 - 150	1,0
	Low alloy	< 250	< 850	100 - 140	1,0
	High alloy	< 350	< 1200	70 - 110	0,9
	Hardened, HRC < 45			60 - 100	0,8
	Hardened, HRC < 55			30 - 60	0,7
	Hardened, HRC < 65			20 - 40	0,6
Cast iron	Lamellar graphite	< 150	< 500	130 - 180	1,2
	Lamellar graphite	< 300	< 1000	100 - 150	1,1
	Nodular graphite, malleable	< 200	< 700	100 - 150	1,0
	Nodular graphite, malleable	< 300	< 1000	80 - 120	0,9
Stainless steel	Free machining	< 250	< 850	130 - 180	1,0
	Austenitic	< 250	< 850	90 - 140	0,9
	Ferritic and austenitic	< 300	< 1000	80 - 120	0,8
Titanium	Unalloyed	< 200	< 700	60 - 80	0,8
	Alloyed	< 270	< 900	50 - 70	0,7
	Alloyed	< 350	< 1250	30 - 50	0,6
Nickel	Unalloyed	< 150	< 500	80 - 120	0,8
	Alloyed	< 270	< 900	60 - 80	0,7
	Alloyed	< 350	< 1250	50 - 70	0,6
Copper	Unalloyed	< 100	< 350	150 - 250	1,0
	Brass, bronze	< 200	< 700	130 - 180	1,0
	High strength bronze	< 470	< 1500	60 - 80	0,8
Aluminium	Unalloyed	< 100	< 350	500 - 900	1,4
	Alloyed, Si < 0.5%	< 150	< 500	400 - 800	1,3
	Alloyed, Si < 10%	< 120	< 400	300 - 500	1,2
	Alloyed, Si > 10%	< 120	< 400	200 - 400	1,1
Inconel	718	< 370		50 - 70	0,6
Graphite				300 - 500	1,0

Engagement Factor (F_e)

	B/d = 0,05	B/d = 0,06	B/d = 0,07	B/d = 0,08	B/d = 0,09	B/d = 0,10	B/d = 0,12	B/d = 0,14	B/d = 0,16
H / d = 1,0	1,75	1,59	1,45	1,31	1,20	1,09	0,99	0,90	0,82
H / d = 1,25	1,52	1,38	1,25	1,14	1,04	0,94	0,86	0,78	0,70
H / d = 1,5	1,31	1,20	1,09	0,99	0,90	0,82	0,74	0,67	0,61
H / d = 1,75	1,20	1,09	0,99	0,90	0,82	0,74	0,67	0,61	0,56
H / d = 2,0	1,09	0,99	0,90	0,82	0,74	0,67	0,61	0,56	0,51
H / d = 2,25	0,99	0,90	0,82	0,74	0,67	0,61	0,56	0,51	0,46
H / d = 2,5	0,90	0,82	0,74	0,67	0,61	0,56	0,51	0,46	0,42
H / d = 3,0	0,78	0,70	0,64	0,58	0,53	0,48	0,44	0,40	0,36
H / d = 3,5	0,67	0,61	0,56	0,51	0,46	0,42	0,38	0,35	0,31
H / d = 4,0	0,61	0,56	0,51	0,46	0,42	0,38	0,35	0,31	0,29



Starting point | Compensation On | Entrance | Thread Milling | Exit | Compensation Off

Cutting data

THREAD MILLING

Diameter Factor (F_d)

D	Diameter Factor (F_d)
1,5	0,010
2,0	0,011
3,0	0,015
4,0	0,019
5,0	0,024
6,0	0,028
8,0	0,036
10,0	0,044
12,0	0,052
14,0	0,060
16,0	0,067
18,0	0,075
20,0	0,082
25,0	0,101
32,0	0,126
40,0	0,156

$$B = 0{,}54 \times P$$

$$F_z = F_m \times F_e \times F_d$$

$$n = \frac{V_c \times 1000}{\pi \times D}$$

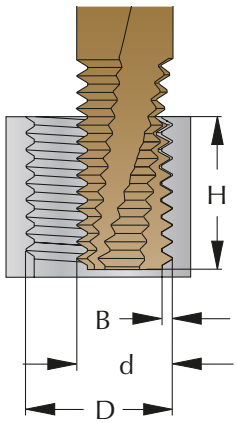
$$V_{fD} = F_z \times z \times n$$

$$V_{fd} = V_{fD} \times \frac{(D - d)}{D}$$

$$T = 278 \times \frac{D}{V_{fd}}$$

Example

- M24x3,0 thread length 36 mm
- Carbon Steel, up to 400 N/mm2
- Thread Milling with N1616C40 3.0ISO AC
- B = 0,54 x 3 = 1,62 mm
- B/d = 1,62/16 = 0,10
- H/d = 36/16 = 2,25
- Fz = 1,2 x 0,61 x 0,067 = 0,049
- n = (160 x 1000) / (π x 16) = 3183 rpm
- VfD = 0,049 x 3 x 3183 = 468 mm/min
- Vfd = 468 x (24-16) / 24 = 156 mm/min
- T = (278 x 24) / 468 = 14 seconds



- D = thread diameter (mm)
- H = thread length (mm)
- d = cutter diameter (mm)
- B = depth of profile (mm)
- P = pitch (mm)
- z = cutting edges
- F_z = feed / flute (mm/flute)
- n = spindle speed (rpm)
- V_c = cutting speed (m/min)
- V_{fD} = feed at thread diameter (mm/min)
- V_{fd} = feed in center of mill (mm/min)
- T = time to mill the thread (seconds)

Carbide Grades

AC
Micrograin Carbide
with TiAlCN coating.
Allround Grade with low friction.
Use cutting data according to the tables.

FC
Micrograin Carbide
with TiAlN coating.
Allround Grade with high heat resistance.
Use cutting data according to the tables.

Solid Carbide Thread Mills

THREADMILL ⇨ THREADBURR

Now introducing ThreadBurr on the standard ThreadMills

The advantage with ThreadBurr is that you can thread and deburr in one operation. No additional time for deburring is needed. The deburring operation is made automatically when thread milling, which gives you the deburring without any extra costs.

The red marked part numbers will gradually disappear and be replaced with the new and improved ThreadBurr. Observe that we in some cases have changed the dimensions and are providing more alternatives. See catalogue for exact dimensions.

There is never a disadvantage to use the new ThreadBurr, even if you don´t use the deburring function. With shallow holes it´s important to have the correct cutting length on the tool to get the thread deburred. With extremely short delivery times, and at a reasonable price, we cut the tool to the correct length.

Part Number OLD	Part Number NEW
E1010D20 1.0ISO AC	EB1010D21 1.0ISO AC
E1212D24 1.5ISO AC	EB1212D26 1.5ISO AC
E1616D32 2.0ISO AC	EB1616D35 2.0ISO AC
N03023C5 0.5ISO AC	NB04023C5 0.5ISO AC
N03023C7 0.5ISO AC	NB04023C6 0.5ISO AC
	NB04023C8 0.5ISO AC
N03023C7 40UN AC	NB04023C5 40UN AC
	NB04023C7 40UN AC
N03024C5 44UN AC	NB04024C5 44UN AC
N03025C9 32UN AC	NB04025C6 32UN AC
	NB04025C8 32UN AC
N0303C10 0.7ISO AC	NB0403C8 0.7ISO AC
	NB0403C10 0.7ISO AC
N0303C10 32UN AC	NB0403C7 32UN AC
	NB0403C9 32UN AC
N0303C7 0.7ISO AC	NB0403C7 0.7ISO AC
N04031C7 36UN AC	NB04031C7 36UN AC
N04038C12 0.8ISO AC	NB04038C10 0.8ISO AC
	NB04038C13 0.8ISO AC
N04038C14 24UN AC	NB04038C9 24UN AC
	NB04038C11 24UN AC
	NB0404C10 24UN AC
	NB0404C12 24UN AC
N04038C9 0.8ISO AC	NB04038C8 0.8ISO AC
N06038C10 0.5ISO AC	NB06038C10 0.5ISO AC
N06045C10 0.75ISO AC	NB06045C10 0.75ISO AC
N06045C10 1.0ISO AC	NB06045C10 1.0ISO AC
N06045C12 20UN AC	NB06045C10 20UN AC
N06045C14 1.0ISO AC	NB06045C13 1.0ISO AC
	NB06045C16 1.0ISO AC
N06045C15 20UN AC	NB06045C14 20UN AC
N06045C16 0.75ISO AC	NB06045C16 0.75ISO AC
N06045C19 1.0ISO AC	NB06045C19 1.0ISO AC
N0604C11 28UN AC	NB0404C9 28UN AC
N06058C14 18UN AC	NB06058C13 18UN AC
N06058C20 18UN AC	NB06058C17 18UN AC
N0605C11 28UN AC	NB0605C10 28UN AC
N0606C12 1.0ISO AC	NB0606C13 1.0ISO AC
N0606C14 1.25ISO AC	NB0606C14 1.25ISO AC
N0606C14 24UN AC	NB0606C13 24UN AC

Part Number OLD	Part Number NEW
N0606C16 16UN AC	NB0606C16 16UN AC
N0606C19 1.25ISO AC	NB0606C18 1.25ISO AC
	NB0606C21 1.25ISO AC
N0606C23 16UN AC	NB0606C21 16UN AC
N0606C25 1.25ISO AC	NB0606C25 1.25ISO AC
N08075C17 1.5ISO AC	NB08075C17 1.5ISO AC
N08075C24 1.5ISO AC	NB08075C21 1.5ISO AC
	NB08075C27 1.5ISO AC
N08075C32 1.5ISO AC	NB08075C32 1.5ISO AC
N08076C21 24UN AC	NB08076C15 24UN AC
N0807C16 16UN AC	NB0606C16 16UN AC
N0807C23 16UN AC	NB0606C21 16UN AC
N0808C20 1.75ISO AC	NB0808C20 1.75ISO AC
N0808C20 14UN AC	NB0808C19 14UN AC
N0808C21 20UN AC	NB0808C18 20UN AC
N0808C22 13UN AC	NB0808C22 13UN AC
N0808C28 1.75ISO AC	NB0808C27 1.75ISO AC
N0808C28 14UN AC	NB0808C24 14UN AC
N0808C32 13UN AC	NB0808C28 13UN AC
N0808D16 1.0ISO AC	NB0808D17 1.0ISO AC
N10093C22 13UN AC	NB0808C22 13UN AC
N10093C32 13UN AC	NB0808C28 13UN AC
N1009C20 1.75ISO AC	NB1009C20 1.75ISO AC
N1009C28 1.75ISO AC	NB1009C27 1.75ISO AC
	NB1009C32 1.75ISO AC
N1009C37 1.75ISO AC	NB1009C37 1.75ISO AC
N1010C26 12UN AC	NB1010C24 12UN AC
N1010C27 2.0ISO AC	NB1010C23 2.0ISO AC
	NB1010C31 2.0ISO AC
N1010C28 11UN AC	NB1010C26 11UN AC
N1010C34 12UN AC	NB1010C30 12UN AC
N1010C39 2.0ISO AC	NB1010C37 2.0ISO AC
N1010C40 11UN AC	NB1010C35 11UN AC
N1010D21 1.5ISO AC	NB1010D23 1.5ISO AC
N1010D21 20UN AC	NB1010D21 20UN AC
N1010D26 18UN AC	NB1010D23 18UN AC
N12115C28 11UN AC	NB1010C26 11UN AC
N12115C40 11UN AC	NB1010C35 11UN AC
N1212C31 2.5ISO AC	NB1212C31 2.5ISO AC
N1212C34 10UN AC	NB1212C31 10UN AC

Part Number OLD	Part Number NEW
N1212C43 2.5ISO AC	NB1212C38 2.5ISO AC
	NB1212C48 2.5ISO AC
N1212C47 10UN AC	NB1212C41 10UN AC
N1212C51 2.0ISO AC	NB1212C51 2.0ISO AC
N1212D26 18UN AC	NB1212D26 18UN AC
N1212D27 1.5ISO AC	NB1212D29 1.5ISO AC
N1212D27 2.0ISO AC	NB1212D27 2.0ISO AC
N1212D31 16UN AC	NB1212D31 16UN AC
N1212D39 2.0ISO AC	NB1212D35 2.0ISO AC
	NB1212D43 2.0ISO AC
N1212E27 20UN AC	NB1212E28 20UN AC
N1414D33 2.5ISO AC	NB1414D33 2.5ISO AC
N1414D34 10UN AC	NB1212C31 10UN AC
N1414D47 10UN AC	NB1212C41 10UN AC
N1414D48 2.5ISO AC	NB1414D43 2.5ISO AC
	NB1615D53 2.5ISO AC
N1615C63 2.5ISO AC	NB1615C63 2.5ISO AC
N1616C38 9UN AC	NB1616C38 9UN AC
N1616C40 3.0ISO AC	NB1616C40 3.0ISO AC
N1616C42 8UN AC	NB1616C42 8UN AC
N1616C55 9UN AC	NB1616C49 9UN AC
N1616C58 3.0ISO AC	NB1616C52 3.0ISO AC
	NB1818C64 3.0ISO AC
N1616C61 8UN AC	NB1616C55 8UN AC
N1616E34 16UN AC	NB1616E35 16UN AC
N1616E37 14UN AC	NB1616E35 14UN AC
N1616E37 2.0ISO AC	NB1616E39 2.0ISO AC
N1616E41 12UN AC	NB1616E43 12UN AC
N1616F33 1.5ISO AC	NB1616F35 1.5ISO AC
N2020C50 3.5ISO AC	NB2020C50 3.5ISO AC
N2020C52 7UN AC	
N2020C71 3.5ISO AC	NB2020C64 3.5ISO AC
	NB2020C78 3.5ISO AC
N2020D43 3.0ISO AC	NB2020D46 3.0ISO AC
N2020D46 8UN AC	NB2020D49 8UN AC
N2020F41 2.0ISO AC	NB2020F43 2.0ISO AC
N2525C58 4.0ISO AC	NB2525C58 4.0ISO AC
N2525C61 6UN AC	
N2525C86 4.0ISO AC	NB2525C78 4.0ISO AC
N2525D58 3.0ISO AC	NB2525D61 3.0ISO AC
N2525F55 2.0ISO AC	NB2525F57 2.0ISO AC
ND08047B10 1.0ISO MG	
ND10065B14 1.25ISO MG	
ND12082B17 1.5ISO MG	
NF06023C7 0.5ISO AC	NF06023C6 0.5ISO AC
	NF06023C8 0.5ISO AC
NF06038C12 0.8ISO AC	NF06038C10 0.8ISO AC
	NF06038C13 0.8ISO AC
NF06038C9 0.8ISO AC	NF06038C8 0.8ISO AC
NF08045C14 1.0ISO AC	NF08045C13 1.0ISO AC
	NF08045C16 1.0ISO AC
NF1006C19 1.25ISO AC	NF1006C18 1.25ISO AC
	NF1006C21 1.25ISO AC
NF12075C24 1.5ISO AC	NF12075C21 1.5ISO AC
	NF12075C27 1.5ISO AC
NF1409C28 1.75ISO AC	NF1409C27 1.75ISO AC
	NF1409C32 1.75ISO AC
NK0606C14 1.25ISO AC	NBK0606C14 1.25ISO AC
NK0606C19 1.25ISO AC	NBK0606C18 1.25ISO AC

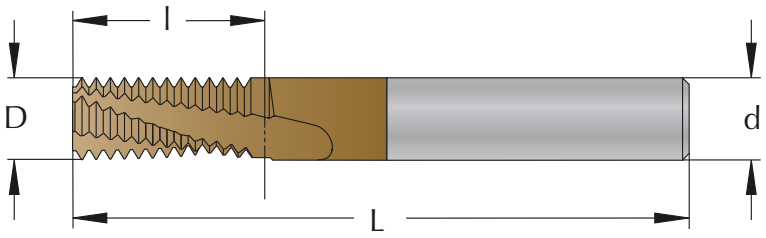
Part Number OLD	Part Number NEW
NK0606C25 1.25ISO AC	NBK0606C21 1.25ISO AC
NK08075C17 1.5ISO AC	
NK08075C24 1.5ISO AC	NBK08075C17 1.5ISO AC
	NBK08075C21 1.5ISO AC
NK08075C32 1.5ISO AC	NBK08075C27 1.5ISO AC
NK0808C20 1.75ISO AC	NBK08075C32 1.5ISO AC
NK0808C28 1.75ISO AC	NBK0808C20 1.75ISO AC
NK1009C20 1.75ISO AC	NBK0808C27 1.75ISO AC
NK1009C28 1.75ISO AC	NBK1009C20 1.75ISO AC
	NBK1009C27 1.75ISO AC
NK1009C37 1.75ISO AC	NBK1009C32 1.75ISO AC
NK1010C27 2.0ISO AC	NBK1009C37 1.75ISO AC
NK1010C39 2.0ISO AC	NBK1010C23 2.0ISO AC
NK1212C51 2.0ISO AC	NBK1010C31 2.0ISO AC
NK1212D27 2.0ISO AC	NBK1212C51 2.0ISO AC
NK1212D39 2.0ISO AC	NBK1212D27 2.0ISO AC
	NBK1212D35 2.0ISO AC
NK1414D48 2.5ISO AC	NBK1212D43 2.0ISO AC
	NBK1414D43 2.5ISO AC
NK1616C58 3.0ISO AC	NBK1615D53 2.5ISO AC
NK2020C71 3.5ISO AC	NBK1616C52 3.0ISO AC
NT0606C19 1.25ISO AC	NBK2020C64 3.5ISO AC
NT08075C24 1.5ISO AC	NBT0606C18 1.25ISO AC
NT0808C28 1.75ISO AC	NBT08075C21 1.5ISO AC
NT1009C28 1.75ISO AC	NBT0808C27 1.75ISO AC
NT1010C39 2.0ISO AC	NBT1009C27 1.75ISO AC
NT1212D39 2.0ISO AC	NBT1010C31 2.0ISO AC
X0606C11 27NPSF AC	NBT1212D35 2.0ISO AC
X0606C9 27NPT AC	XB0606C12 27NPSF AC
X0606C9 27NPTF AC	XB0606C10 27NPT AC
X0606C9 28BSPT AC	XB0606C10 27NPTF AC
X0606C9 28W AC	XB0606C10 28BSPT AC
X0808C14 18NPSF AC	XB0606C10 28W AC
X0808C14 18NPT AC	XB0808C16 18NPSF AC
X0808C14 18NPTF AC	XB0808C16 18NPT AC
X0808C14 19BSPT AC	XB0808C16 18NPTF AC
X0808C14 19W AC	XB0808C15 19BSPT AC
X0808C19 20PG AC	XB0808C15 19W AC
X1010C26 18PG AC	XB0808C21 20PG AC
X1010D20 19W AC	XB1010C27 18PG AC
X1212C24 11W AC	XB1010D22 19W AC
X1212D19 14BSPT AC	XB1212C26 11W AC
X1212D19 14W AC	XB1212D20 14BSPT AC
X1212D20 14NPSF AC	XB1212D20 14W AC
X1212D20 14NPT AC	XB1212D22 14NPSF AC
X1212D20 14NPTF AC	XB1212D22 14NPT AC
X1212D26 14W AC	XB1212D22 14NPTF AC
X1212D29 16PG AC	XB1212D28 14W AC
X1616D20 14NPT AC	XB1212D31 16PG AC
X1616D27 11.5NPSF AC	XB1616D22 14NPT AC
X1616D27 11.5NPT AC	XB1616D29 11.5NPSF AC
X1616D27 11.5NPTF AC	XB1616D29 11.5NPT AC
X1616D28 11BSPT AC	XB1616D29 11.5NPTF AC
X1616D38 11W AC	XB1616D31 11BSPT AC
X1616E26 14W AC	XB1616D40 11W AC
X2020D39 8NPT AC	XB1616E28 14W AC
X2020D39 8NPTF AC	XB2020D42 8NPT AC
X2020E47 11W AC	XB2020D42 8NPTF AC
	XB2020E49 11W AC

Solid Carbide Thread Mills

THREADBURR

TiAlCN

AC
TiAlCN coated
Micrograin Carbide
Tolerance: The theoretical external diameter of the cutter is lasermarked on the tool.
Shank: Cylindrical h6, DIN6535 HA
Flute: 15° right hand spiral
Field of application: Thread Milling of all types of steel



M Metric

Pitch mm	M coarse	M fine	INTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
0,4	M2 (1,5xD)		NB04015C3 0.4ISO AC	4	1,5	3	3,4	50
0,4	M2 (2xD)		NB04015C4 0.4ISO AC	4	1,5	3	4,6	50
0,45	M2,2 (1,5xD)		NB04016C3 0.45ISO AC	4	1,6	3	3,82	50
0,45	M2,2 (2xD)		NB04016C5 0.45ISO AC	4	1,6	3	5,17	50
0,45	M2,5 (1,5xD)		NB04019C4 0.45ISO AC	4	1,9	3	4,27	50
0,45	M2,5 (2xD)		NB04019C5 0.45ISO AC	4	1,9	3	5,62	50
0,5	M3 (1,5xD)	≥ M4	NB04023C5 0.5ISO AC	4	2,3	3	5,25	50
0,5	M3 (2xD)	≥ M4	NB04023C6 0.5ISO AC	4	2,3	3	6,75	50
0,5	M3 (2,5xD)	≥ M4	NB04023C8 0.5ISO AC	4	2,3	3	8,25	50
0,5	M3 (1,5xD)	≥ M4	NB06023C5 0.5ISO AC	6	2,3	3	5,25	63
0,5	M3 (2xD)	≥ M4	NB06023C6 0.5ISO AC	6	2,3	3	6,75	63
0,5	M3 (2,5xD)	≥ M4	NB06023C8 0.5ISO AC	6	2,3	3	8,25	63
0,5		≥ M5	NB04038C10 0.5ISO AC	4	3,8	3	10,75	50
0,5		≥ M5	NB06038C10 0.5ISO AC	6	3,8	3	10,75	63
0,6	M3,5 (1,5xD)		NB04026C6 0.6ISO AC	4	2,6	3	6,3	50
0,6	M3,5 (2xD)		NB04026C8 0.6ISO AC	4	2,6	3	8,1	50
0,7	M4 (1,5xD)		NB0403C7 0.7ISO AC	4	3	3	7,35	50
0,7	M4 (2xD)		NB0403C8 0.7ISO AC	4	3	3	8,75	50
0,7	M4 (2,5xD)		NB0403C10 0.7ISO AC	4	3	3	10,85	50
0,7	M4 (1,5xD)		NB0603C7 0.7ISO AC	6	3	3	7,35	63
0,7	M4 (2xD)		NB0603C8 0.7ISO AC	6	3	3	8,75	63
0,7	M4 (2,5xD)		NB0603C10 0.7ISO AC	6	3	3	10,85	63
0,75	M4,5 (1,5xD)		NB04034C7 0.75ISO AC	4	3,4	3	7,87	50
0,75	M4,5 (2xD)		NB04034C10 0.75ISO AC	4	3,4	3	10,12	50
0,75		≥ M6	NB06045C10 0.75ISO AC	6	4,5	3	10,87	63
0,75		≥ M6	NB06045C16 0.75ISO AC	6	4,5	3	16,87	63
0,8	M5 (1,5xD)		NB04038C8 0.8ISO AC	4	3,8	3	8,4	50
0,8	M5 (2xD)		NB04038C10 0.8ISO AC	4	3,8	3	10,8	50
0,8	M5 (2,5xD)		NB04038C13 0.8ISO AC	4	3,8	3	13,2	50
0,8	M5 (1,5xD)		NB06038C8 0.8ISO AC	6	3,8	3	8,4	63
0,8	M5 (2xD)		NB06038C10 0.8ISO AC	6	3,8	3	10,8	63
0,8	M5 (2,5xD)		NB06038C13 0.8ISO AC	6	3,8	3	13,2	63
1,0	M6 (1,5xD)	≥ M8	NB06045C10 1.0ISO AC	6	4,5	3	10,5	63
1,0	M6 (2xD)	≥ M8	NB06045C13 1.0ISO AC	6	4,5	3	13,5	63
1,0	M6 (2,5xD)	≥ M8	NB06045C16 1.0ISO AC	6	4,5	3	16,5	63
1,0	M6 (3xD)	≥ M8	NB06045C19 1.0ISO AC	6	4,5	3	19,5	63
1,0		≥ M8	NB0606C13 1.0ISO AC	6	6	3	13,5	63
1,0		≥ M10	NB0808D17 1.0ISO AC	8	8	4	17,5	63
1,0		≥ M14	NB1212F21 1.0ISO AC	12	12	6	21,5	83
1,25	M8 (1,5xD)	≥ M10	NB0606C14 1.25ISO AC	6	6	3	14,37	63
1,25	M8 (2xD)	≥ M10	NB0606C18 1.25ISO AC	6	6	3	18,12	63
1,25	M8 (2,5xD)	≥ M10	NB0606C21 1.25ISO AC	6	6	3	21,87	63
1,25	M8 (3xD)	≥ M10	NB0606C25 1.25ISO AC	6	6	3	25,62	76
1,5	M10 (1,5xD)	≥ M12	NB08075C17 1.5ISO AC	8	7,5	3	17,25	63
1,5	M10 (2xD)	≥ M12	NB08075C21 1.5ISO AC	8	7,5	3	21,75	76
1,5	M10 (2,5xD)	≥ M12	NB08075C27 1.5ISO AC	8	7,5	3	27,75	76

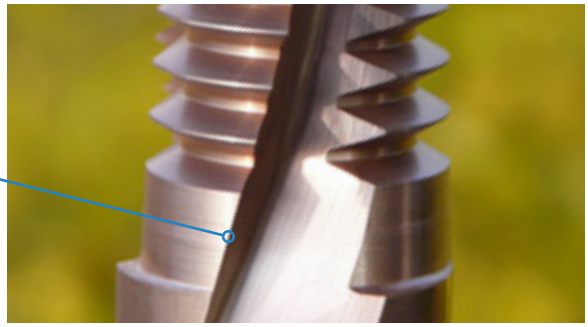
M Metric (Continue)

Pitch mm	M coarse	M fine	INTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
1,5	M10 (3xD)	≥ M12	NB08075C32 1.5ISO AC	8	7,5	3	32,25	76
1,5		≥ M14	NB1010D23 1.5ISO AC	10	10	4	23,25	76
1,5		≥ M16	NB1212D29 1.5ISO AC	12	12	4	29,25	83
1,5		≥ M20	NB1616F35 1.5ISO AC	16	16	6	35,25	100
1,75	M12 (1,5xD)		NB0808C20 1.75ISO AC	8	8	3	20,12	76
1,75	M12 (2xD)		NB0808C27 1.75ISO AC	8	8	3	27,12	76
1,75	M12 (1,5xD)		NB1009C20 1.75ISO AC	10	9	3	20,12	76
1,75	M12 (2xD)		NB1009C27 1.75ISO AC	10	9	3	27,12	76
1,75	M12 (2,5xD)		NB1009C32 1.75ISO AC	10	9	3	32,37	100
1,75	M12 (3xD)		NB1009C37 1.75ISO AC	10	9	3	37,62	100
2,0	M14 (1,5xD)	≥ M18	NB1010C23 2.0ISO AC	10	10	3	23	76
2,0	M14 (2xD)	≥ M18	NB1010C31 2.0ISO AC	10	10	3	31	100
2,0	M14 (2,5xD)	≥ M18	NB1010C37 2.0ISO AC	10	10	3	37	100
2,0	M16 (1,5xD)	≥ M18	NB1212D27 2.0ISO AC	12	12	4	27	83
2,0	M16 (2xD)	≥ M18	NB1212D35 2.0ISO AC	12	12	4	35	100
2,0	M16 (2,5xD)	≥ M18	NB1212D43 2.0ISO AC	12	12	4	43	100
2,0	M16 (3xD)	≥ M18	NB1212C51 2.0ISO AC	12	12	3	51	100
2,0		≥ M20	NB1616E39 2.0ISO AC	16	16	5	39	100
2,0		≥ M24	NB2020F43 2.0ISO AC	20	20	6	43	100
2,0		≥ M30	NB2525F57 2.0ISO AC	25	25	6	57	130
2,5	M18 (1,5xD)		NB1212C31 2.5ISO AC	12	12	3	31,25	100
2,5	M18 (2xD)		NB1212C38 2.5ISO AC	12	12	3	38,75	100
2,5	M18 (2,5xD)		NB1212C48 2.5ISO AC	12	12	3	48,75	100
2,5	M20 (1,5xD)		NB1414D33 2.5ISO AC	14	14	4	33,75	89
2,5	M20 (2xD)		NB1414D43 2.5ISO AC	14	14	4	43,75	100
2,5	M20 (2,5xD)		NB1615D53 2.5ISO AC	16	15	4	53,75	120
2,5	M20 (3xD)		NB1615C63 2.5ISO AC	16	15	3	63,75	120
3,0	M24 (1,5xD)	≥ M30	NB1616C40 3.0ISO AC	16	16	3	40,5	100
3,0	M24 (2xD)	≥ M30	NB1616C52 3.0ISO AC	16	16	3	52,5	120
3,0	M24 (2,5xD)	≥ M30	NB1818C64 3.0ISO AC	18	18	3	64,5	130
3,0		≥ M30	NB2020D46 3.0ISO AC	20	20	4	46,5	120
3,0		≥ M33	NB2525D61 3.0ISO AC	25	25	4	61,5	130
3,5	M30 (1,5xD)		NB2020C50 3.5ISO AC	20	20	3	50,75	120
3,5	M30 (2xD)		NB2020C64 3.5ISO AC	20	20	3	64,75	150
3,5	M30 (2,5xD)		NB2020C78 3.5ISO AC	20	20	3	78,75	150
4,0	M36 (1,5xD)	≥ M42	NB2525C58 4.0ISO AC	25	25	3	58	130
4,0	M36 (2xD)	≥ M42	NB2525C78 4.0ISO AC	25	25	3	78	150

M Metric (External)

Pitch mm	EXTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
1,0	EB1010D21 1.0ISO AC	10	10	4	21,5	76
1,5	EB1212D26 1.5ISO AC	12	12	4	26,25	83
2,0	EB1616D35 2.0ISO AC	16	16	4	35	100

- Solid Carbide Thread Mills can be produced with pitches up to 6,0 mm (4TPI).



Solid Carbide Thread Mills

TiAlCN

UN Unified

Pitch TPI	UNC	UNF	INTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
44		No.5 (1,5xD)	NB04024C5 44UN AC	4	2,4	3	5,48	50
40	No.5 (1,5xD)		NB04023C5 40UN AC	4	2,3	3	5,40	50
40	No.5 (2xD)		NB04023C7 40UN AC	4	2,3	3	7,30	50
40		No.6 (1,5xD)	NB04026C6 40UN AC	4	2,6	3	6,03	50
36		No.8 (1,5xD)	NB04031C7 36UN AC	4	3,1	3	7,41	50
32	No.6 (1,5xD)		NB04025C6 32UN AC	4	2,5	3	6,75	50
32	No.6 (2xD)		NB04025C8 32UN AC	4	2,5	3	8,33	50
32	No.8 (1,5xD)		NB0403C7 32UN AC	4	3	3	7,54	50
32	No.8 (2xD)		NB0403C9 32UN AC	4	3	3	9,13	50
32		No.10 (1,5xD)	NB04036C8 32UN AC	4	3,6	3	8,33	50
28		No.12 (1,5xD)	NB0404C9 28UN AC	4	4	3	9,52	50
28		1/4 (1,5xD)	NB0605C10 28UN AC	6	5	3	10,43	63
24	No.10 (1,5xD)		NB04038C9 24UN AC	4	3,8	3	9,00	50
24	No.10 (2xD)		NB04038C11 24UN AC	4	3,8	3	11,11	50
24	No.12 (1,5xD)		NB0404C10 24UN AC	4	4	3	10,05	50
24	No.12 (2xD)		NB0404C12 24UN AC	4	4	3	12,17	50
24		5/16 (1,5xD)	NB0606C13 24UN AC	6	6	3	13,23	63
24		3/8 (1,5xD)	NB08076C15 24UN AC	8	7,6	3	15,35	63
20	1/4 (1,5xD)		NB06045C10 20UN AC	6	4,5	3	10,80	63
20	1/4 (2xD)		NB06045C14 20UN AC	6	4,5	3	14,60	63
20		7/16 (1,5xD)	NB0808C18 20UN AC	8	8	3	18,41	63
20		1/2 (1,5xD)	NB1010D21 20UN AC	10	10	4	20,96	76
20			NB1212E28 20UN AC	12	12	5	28,57	83
18	5/16 (1,5xD)		NB06058C13 18UN AC	6	5,8	3	13,41	63
18	5/16 (2xD)		NB06058C17 18UN AC	6	5,8	3	17,64	63
18		9/16 (1,5xD)	NB1010D23 18UN AC	10	10	4	23,28	76
18		5/8 (1,5xD)	NB1212D26 18UN AC	12	12	4	26,11	83
16	3/8 (1,5xD)		NB0606C16 16UN AC	6	6	3	16,67	63
16	3/8 (2xD)		NB0606C21 16UN AC	6	6	3	21,43	63
16		3/4 (1,5xD)	NB1212D31 16UN AC	12	12	4	30,96	100
16			NB1616E35 16UN AC	16	16	5	35,72	100
14	7/16 (1,5xD)		NB0808C19 14UN AC	8	8	3	19,05	63
14	7/16 (2xD)		NB0808C24 14UN AC	8	8	3	24,49	76
14		7/8 (1,5xD)	NB1616E35 14UN AC	16	16	5	35,38	100
13	1/2 (1,5xD)		NB0808C22 13UN AC	8	8	3	22,47	76
13	1/2 (2xD)		NB0808C28 13UN AC	8	8	3	28,33	76
12	9/16 (1,5xD)		NB1010C24 12UN AC	10	10	3	24,34	76
12	9/16 (2xD)		NB1010C30 12UN AC	10	10	3	30,69	100
12			NB1616E43 12UN AC	16	16	5	43,39	100
11	5/8 (1,5xD)		NB1010C26 11UN AC	10	10	3	26,55	76
11	5/8 (2xD)		NB1010C35 11UN AC	10	10	3	35,79	100
10	3/4 (1,5xD)		NB1212C31 10UN AC	12	12	3	31,75	100
10	3/4 (2xD)		NB1212C41 10UN AC	12	12	3	41,91	100
9	7/8 (1,5xD)		NB1616C38 9UN AC	16	16	3	38,1	100
9	7/8 (2xD)		NB1616C49 9UN AC	16	16	3	49,39	120
8	1 (1,5xD)		NB1616C42 8UN AC	16	16	3	42,86	100
8	1 (2xD)		NB1616C55 8UN AC	16	16	3	55,56	120
8			NB2020D49 8UN AC	20	20	4	49,21	120

- Kyocera Unimerco can deliver Solid Carbide Thread Mills with pitches up to 6,0 mm (4TPI).

G Whitworth Pipe Thread

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
28	G 1/8	XB0606C10 28W AC	6	6	3	10,43	63
19	G 1/4 - 3/8	XB0808C15 19W AC	8	8	3	15,37	63
19	G 1/4 - 3/8	XB1010D22 19W AC	10	10	4	22,06	76
14	G 1/2 - 7/8	XB1212D20 14W AC	12	12	4	20,86	83
14	G 1/2 - 7/8	XB1212D28 14W AC	12	12	4	28,12	83
14	G 1/2 - 7/8	XB1616E28 14W AC	16	16	5	28,12	100
11	G 1 - 1 1/2	XB1212C26 11W AC	12	12	3	26,55	83
11	G 1 - 3	XB1616D40 11W AC	16	16	4	40,41	100
11	G ≥ 1	XB2020E49 11W AC	20	20	5	49,65	120

BSPT BSPT Pipe Thread

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
28	Rc 1/8	XB0606C10 28BSPT AC	6	6	3	10,43	63
19	Rc 1/4 - 3/8	XB0808C15 19BSPT AC	8	8	3	15,37	63
14	Rc 1/2 - 7/8	XB1212D20 14BSPT AC	12	12	4	20,86	83
11	Rc 1-2	XB1616D31 11BSPT AC	16	16	4	31,17	100

PG Steel Conduit Thread DIN 40430

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
20	Pg 7	XB0808C21 20PG AC	8	8	3	20,96	63
18	Pg 9-16	XB1010C27 18PG AC	10	10	3	27,52	76
16	Pg 21-48	XB1212D31 16PG AC	12	12	4	30,96	83

NPT NPT Pipe Thread

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
27	1/16 - 1/8	XB0606C10 27NPT AC	6	6	3	10,82	63
18	1/4 - 3/8	XB0808C16 18NPT AC	8	8	3	16,23	63
14	1/2 - 3/4	XB1212D22 14NPT AC	12	12	4	22,68	83
14	3/4	XB1616D22 14NPT AC	16	16	4	22,86	100
11,5	1-2	XB1616D29 11.5NPT AC	16	16	4	29,82	100
8	≥ 2 1/2	XB2020D42 8NPT AC	20	20	4	42,86	100

NPTF NPTF Dryseal Pipe Thread

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
27	1/16 - 1/8	XB0606C10 27NPTF AC	6	6	3	10,82	63
18	1/4 - 3/8	XB0808C16 18NPTF AC	8	8	3	16,23	63
14	1/2 - 3/4	XB1212D22 14NPTF AC	12	12	4	22,68	83
11,5	1-2	XB1616D29 11.5NPTF AC	16	16	4	29,82	100
8	≥ 2 1/2	XB2020D42 8NPTF AC	20	20	4	42,86	100

NPSF NPSF Pipe Thread

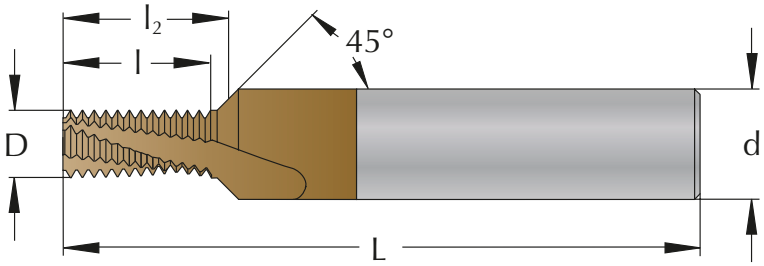
Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
27	1/16 - 1/8	XB0606C12 27NPSF AC	6	6	3	12,70	63
18	1/4 - 3/8	XB0808C16 18NPSF AC	8	8	3	16,23	63
14	1/2 - 3/4	XB1212D22 14NPSF AC	12	12	4	22,68	83
11,5	1	XB1616D29 11.5NPSF AC	16	16	4	29,82	100

Solid Carbide Thread Mills

WITH CHAMFER

TiAlCN

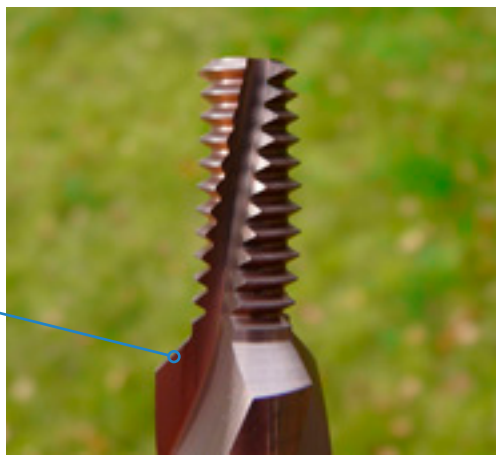
AC
TiAlCN coated
Micrograin Carbide
Tolerance: The theoretical external diameter of the cutter is lasermarked on the tool.
Shank: Cylindrical h6, DIN6535 HA
Flute: 15° right hand spiral
Field of application: Thread Milling of all types of steel



M Metric

Pitch mm	M coarse	INTERNAL Part Number	d mm	D mm	Cutting edges	l mm	l_2 mm	L mm
0,5	M3 (1,5xD)	NF06023C5 0.5ISO AC	6	2,3	3	5,25	5,85	63
0,5	M3 (2xD)	NF06023C6 0.5ISO AC	6	2,3	3	6,75	7,35	63
0,5	M3 (2,5xD)	NF06023C8 0.5ISO AC	6	2,3	3	8,25	8,85	63
0,5	M3 (3xD)	NF06023C9 0.5ISO AC	6	2,3	3	9,75	10,35	63
0,7	M4 (1,5xD)	NF0603C7 0.7ISO AC	6	3	3	7,35	8,2	63
0,7	M4 (2xD)	NF0603C8 0.7ISO AC	6	3	3	8,75	9,6	63
0,7	M4 (2,5xD)	NF0603C10 0.7ISO AC	6	3	3	10,85	11,7	63
0,7	M4 (3xD)	NF0603C12 0.7ISO AC	6	3	3	12,95	13,8	63
0,8	M5 (1,5xD)	NF06038C8 0.8ISO AC	6	3,8	3	8,4	9,4	63
0,8	M5 (2xD)	NF06038C10 0.8ISO AC	6	3,8	3	10,8	11,8	63
0,8	M5 (2,5xD)	NF06038C13 0.8ISO AC	6	3,8	3	13,2	14,2	63
0,8	M5 (3xD)	NF06038C16 0.8ISO AC	6	3,8	3	16,4	17,4	63
1,0	M6 (1,5xD)	NF08045C10 1.0ISO AC	8	4,5	3	10,5	11,75	63
1,0	M6 (2xD)	NF08045C13 1.0ISO AC	8	4,5	3	13,5	14,75	63
1,0	M6 (2,5xD)	NF08045C16 1.0ISO AC	8	4,5	3	16,5	17,75	63
1,25	M8 (1,5xD)	NF1006C14 1.25ISO AC	10	6	3	14,37	16	76
1,25	M8 (2xD)	NF1006C18 1.25ISO AC	10	6	3	18,12	19,75	76
1,25	M8 (2,5xD)	NF1006C21 1.25ISO AC	10	6	3	21,87	23,5	76
1,5	M10 (1,5xD)	NF12075C17 1.5ISO AC	12	7,5	3	17,25	19,25	83
1,5	M10 (2xD)	NF12075C21 1.5ISO AC	12	7,5	3	21,75	23,75	83
1,5	M10 (2,5xD)	NF12075C27 1.5ISO AC	12	7,5	3	27,75	29,75	83
1,75	M12 (1,5xD)	NF1409C20 1.75ISO AC	14	9	3	20,12	22,5	89
1,75	M12 (2xD)	NF1409C27 1.75ISO AC	14	9	3	27,12	29,5	89
1,75	M12 (2,5xD)	NF1409C32 1.75ISO AC	14	9	3	32,37	34,75	89

Chamfering of the thread

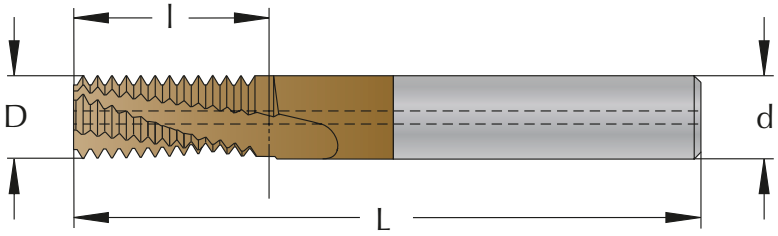


Solid Carbide Thread Mills

THREADBURR WITH INTERNAL COOLANT

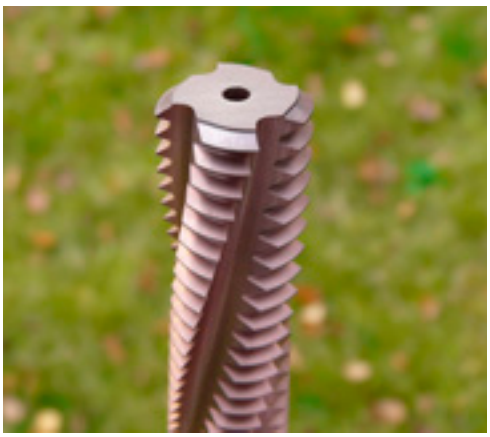
TiAlCN

AC
TiAlCN coated
Micrograin Carbide
Tolerance: The theoretical external diameter of the cutter is lasermarked on the tool.
Shank: Cylindrical h6, DIN6535 HA
Flute: 15° right hand spiral
Field of application: Thread Milling of all types of steel



M Metric

Pitch mm	M coarse	M fine	INTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
1,25	M8 (1,5xD)	≥ M10	NBK0606C14 1.25ISO AC	6	6	3	14,37	63
1,25	M8 (2xD)	≥ M10	NBK0606C18 1.25ISO AC	6	6	3	18,12	63
1,25	M8 (2,5xD)	≥ M10	NBK0606C21 1.25ISO AC	6	6	3	21,87	63
1,5	M10 (1,5xD)	≥ M12	NBK08075C17 1.5ISO AC	8	7,5	3	17,25	76
1,5	M10 (2xD)	≥ M12	NBK08075C21 1.5ISO AC	8	7,5	3	21,75	76
1,5	M10 (2,5xD)	≥ M12	NBK08075C27 1.5ISO AC	8	7,5	3	27,75	76
1,5	M10 (3xD)	≥ M12	NBK08075C32 1.5ISO AC	8	7,5	3	32,25	76
1,75	M12 (1,5xD)		NBK0808C20 1.75ISO AC	8	8	3	20,12	76
1,75	M12 (2xD)		NBK0808C27 1.75ISO AC	8	8	3	27,12	76
1,75	M12 (1,5xD)		NBK1009C20 1.75ISO AC	10	9	3	20,12	100
1,75	M12 (2xD)		NBK1009C27 1.75ISO AC	10	9	3	27,12	100
1,75	M12 (2,5xD)		NBK1009C32 1.75ISO AC	10	9	3	32,37	100
1,75	M12 (3xD)		NBK1009C37 1.75ISO AC	10	9	3	37,62	100
2,0	M14 (1,5xD)	≥ M18	NBK1010C23 2.0ISO AC	10	10	3	23	100
2,0	M14 (2xD)	≥ M18	NBK1010C31 2.0ISO AC	10	10	3	31	100
2,0	M16 (1,5xD)	≥ M18	NBK1212D27 2.0ISO AC	12	12	4	27	100
2,0	M16 (2xD)	≥ M18	NBK1212D35 2.0ISO AC	12	12	4	35	100
2,0	M16 (2,5xD)	≥ M18	NBK1212D43 2.0ISO AC	12	12	4	43	100
2,0	M16 (3xD)	≥ M18	NBK1212C51 2.0ISO AC	12	12	3	51	100
2,5	M20 (1,5xD)		NBK1414D33 2.5ISO AC	14	14	4	33,75	100
2,5	M20 (2xD)		NBK1414D43 2.5ISO AC	14	14	4	43,75	100
2,5	M20 (2,5xD)		NBK1615D53 2.5ISO AC	16	15	4	53,75	120
3,0	M24 (1,5xD)	≥ M30	NBK1616C40 3.0ISO AC	16	16	3	40,5	120
3,0	M24 (2xD)	≥ M30	NBK1616C52 3.0ISO AC	16	16	3	52,5	120
3,5	M30 (1,5xD)		NBK2020C50 3.5ISO AC	20	20	3	50,75	150
3,5	M30 (2xD)		NBK2020C64 3.5ISO AC	20	20	3	64,75	150

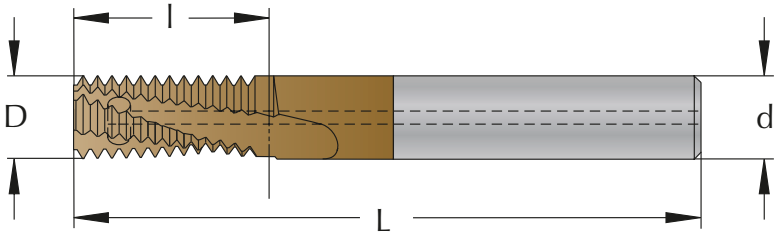


Solid Carbide Thread Mills

THREADBURR WITH INTERNAL RADIAL COOLANT

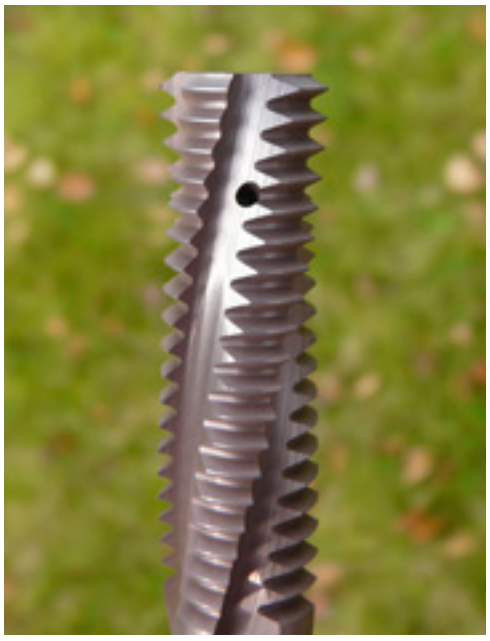
TiAlCN

AC
TiAlCN coated
Micrograin Carbide
Tolerance: The theoretical external diameter of the cutter is lasermarked on the tool.
Shank: Cylindrical h6, DIN6535 HA
Flute: 15° right hand spiral
Field of application: Thread Milling of all types of steel



M Metric

Pitch mm	M coarse	M fine	INTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
1,25	M8 (2xD	≥ M10	NBT0606C18 1.25ISO AC	6	6	3	18,12	76
1,5	M10 (2xD)	≥ M12	NBT08075C21 1.5ISO AC	8	7,5	3	21,75	76
1,75	M12 (2xD)		NBT0808C27 1.75ISO AC	8	8	3	27,12	76
1,75	M12 (2xD)		NBT1009C27 1.75ISO AC	10	9	3	27,12	100
2,0	M14 (2xD)	≥ M18	NBT1010C31 2.0ISO AC	10	10	3	31	100
2,0	M16 (2xD)	≥ M18	NBT1212D35 2.0ISO AC	12	12	4	35	100

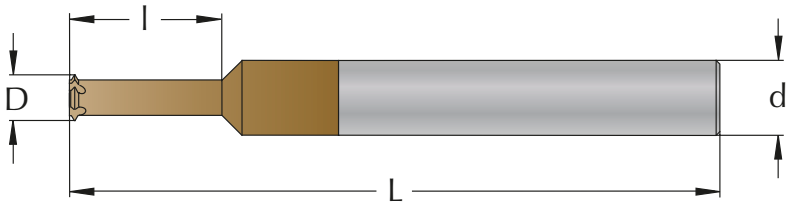


Solid Carbide Thread Mills

MICRO, ONE TOOTH

TiAlCN

AC
TiAlCN coated
Micrograin Carbide
Tolerance: D 1,0 - 4,0 +0 / -0,050
Shank: Cylindrical h6, DIN6535 HA
Flute: 15° right hand spiral
Field of application: Thread Milling of all types of steel



60° Partial Profile 60°

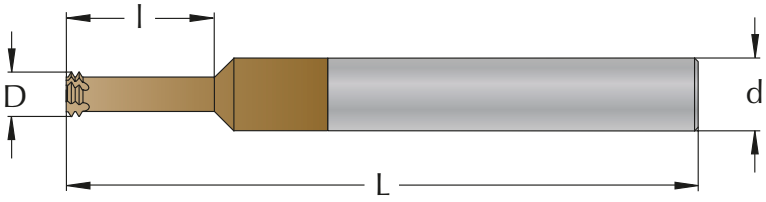
M coarse	M fine	UNC UNF		INTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
M2-M2,2	M1,8-M2	No.2	(1,5xD)	NS03015C3.8 P60 AC	3	1,5	3	3,8	39
M2-M2,2	M1,8-M2	No.2	(2,25xD)	NS03015C5.4 P60 AC	3	1,5	3	5,4	39
M2,5	M2,2	No.3	(1,5xD)	NS03019C4.3 P60 AC	3	1,9	3	4,3	39
M2,5	M2,2	No.3	(2,25xD)	NS03019C6.2 P60 AC	3	1,9	3	6,2	39
	M2,5	No.4	(1,5xD)	NS03021C4.9 P60 AC	3	2,1	3	4,9	39
	M2,5	No.4	(2,25xD)	NS03021C7.1 P60 AC	3	2,1	3	7,1	39
M3		No.5	(1,5xD)	NS03023C5.4 P60 AC	3	2,3	3	5,4	39
M3		No.5	(2,25xD)	NS03023C7.8 P60 AC	3	2,3	3	7,8	39
M3,5	M3	No.6	(1,5xD)	NS03026C6.1 P60 AC	3	2,6	3	6,1	39
M3,5	M3	No.6	(2,25xD)	NS03026C8.7 P60 AC	3	2,6	3	8,7	39
M4	M3,5-M4	No.8	(1,5xD)	NS0303C7.1 P60 AC	3	3	3	7,1	39
M4	M3,5-M4	No.8	(2,25xD)	NS0303C10.2 P60 AC	3	3	3	10,2	39
M4,5	M4,5	No.10	(1,5xD)	NS04036C8.3 P60 AC	4	3,6	3	8,3	50
M4,5	M4,5	No.10	(2,25xD)	NS04036C12.0 P60 AC	4	3,6	3	12,0	50
M5-M6	M5-M6	No.12	(1,5xD)	NS0404C10.0 P60 AC	4	4	3	10,0	50
M5-M6	M5-M6	No.12	(2,25xD)	NS0404C14.5 P60 AC	4	4	3	14,5	50

Solid Carbide Thread Mills

MICRO, TWO TEETH

TiAlCN

AC
TiAlCN coated
Micrograin Carbide
Tolerance: The theoretical external diameter of the cutter is lasermarked on the tool.
Shank: Cylindrical h6, DIN6535 HA
Flute: 15° right hand spiral
Field of application: Thread Milling of all types of steel



M Metric

Pitch mm	M coarse	INTERNAL Part Number	d mm	D mm	Cutting edges	l mm	L mm
0,4	M2 (1,5xD)	NM03015C3 0.4ISO AC	3	1,5	3	3,4	39
0,4	M2 (2,25xD)	NM03015C5 0.4ISO AC	3	1,5	3	5	39
0,45	M2,2 (1,5xD)	NM03016C3 0.45ISO AC	3	1,6	3	3,8	39
0,45	M2,2 (2,25xD)	NM03016C5 0.45ISO AC	3	1,6	3	5,4	39
0,45	M2,5 (1,5xD)	NM03019C4 0.45ISO AC	3	1,9	3	4,2	39
0,45	M2,5 (2,25xD)	NM03019C6 0.45ISO AC	3	1,9	3	6,1	39
0,5	M3 (1,5xD)	NM03023C5 0.5ISO AC	3	2,3	3	5	39
0,5	M3 (2,25xD)	NM03023C7 0.5ISO AC	3	2,3	3	7,3	39
0,6	M3,5 (1,5xD)	NM03026C6 0.6ISO AC	3	2,6	3	6	39
0,6	M3,5 (2,25xD)	NM03026C8 0.6ISO AC	3	2,6	3	8,5	39
0,7	M4 (1,5xD)	NM0303C7 0.7ISO AC	3	3	3	7	39
0,7	M4 (2,25xD)	NM0303C10 0.7ISO AC	3	3	3	10	39
0,8	M5 (1,5xD)	NM04038C9 0.8ISO AC	4	3,8	3	9	50
0,8	M5 (2,25xD)	NM04038C12 0.8ISO AC	4	3,8	3	12,1	50
1,0	M6 (1,5xD)	NM06045C10 1.0ISO AC	6	4,5	3	10	63
1,0	M6 (2,25xD)	NM06045C14 1.0ISO AC	6	4,5	3	14,5	63
1,25	M8 (1,5xD)	NM0606C14 1.25ISO AC	6	6	3	14	63
1,25	M8 (2,25xD)	NM0606C19 1.25ISO AC	6	6	3	19,3	63

Corporate Motto: "Respect the Divine and Love People"

敬天愛人

Preserve the spirit to work fairly and honorably,
respecting people, our work, our company
and our global community.

THE NEW VALUE FRONTIER

KYOCERA

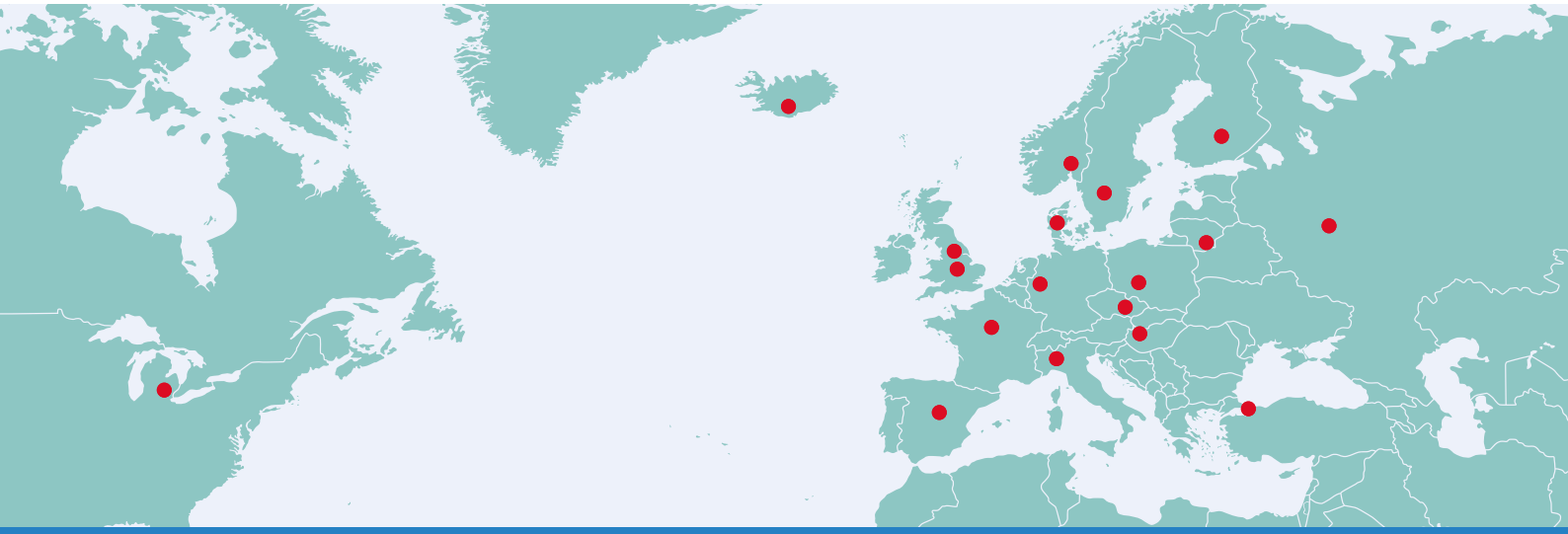
"The New Value Frontier" reflects Kyocera's commitment to continuously creating new value at the cutting edge of technology. The global Kyocera Group develops unique technologies and applies its vision to create valuable products that the markets continually seek.

Industrial tooling solutions

Kyocera Unimerco is a global manufacturer and distributor, providing standard and customized cutting tool solutions as well as know-how and optimization guidance for the manufacturing industry.

The company was founded in 1964 and has since expanded into 17 countries, with more than 700 employees.
Today the company is part of the Japan-based Kyocera Corporation.

In 1998 the Sheffield branch was established. It is specialised in supplying the industrial market with inserts, standard tools and related tooling solutions.



KYOCERA

www.kyocera-unimerco.co.uk

101 Attercliffe Road | UK-Sheffield S4 7WW | Tel. 01142 788787 | uksales@kyocera-unimerco.com