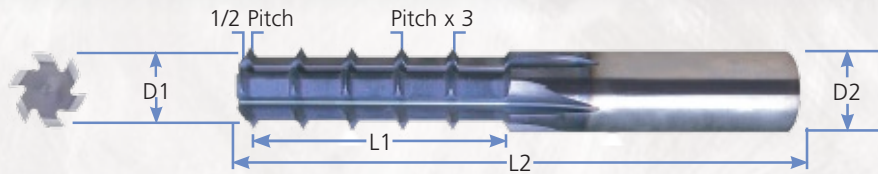


## Solid Carbide Thread Mills

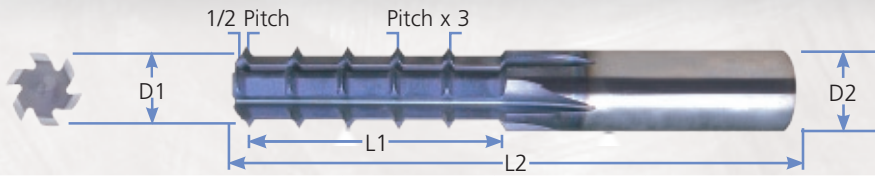


### UN Internal Threads T3 Extra Long Length

Min. Size	TIN	TLN	Pitch	Flutes	D2	D1	L2	L1
# 4 - 40	0270900	0378900	40	3	0.125	0.080	1.65	0.336
# 6 - 32	0270901	0378901	32	3	0.125	0.085	1.65	0.375
# 8 - 32	0270902	0378902	32	3	0.125	0.120	1.65	0.492
# 12 - 28	0270913	0378913	28	3	0.187	0.160	2.37	0.750
1/4" - 28	0270914	0378914	28	3	0.250	0.180	2.90	0.750
# 10 - 24	0270921	0378921	24	3	0.125	0.120	1.50	0.375
# 12 - 24	0270915	0378915	24	3	0.187	0.140	2.56	0.625
5/16" - 24	0270916	0378916	24	3	0.250	0.200	2.75	0.958
3/8" - 24	0270920	0378920	24	5	0.250	0.240	2.95	1.000
1/4" - 20	0270903	0378903	20	3	0.187	0.160	2.56	0.750
7/16" - 20	0270917	0378917	20	5	0.312	0.310	3.35	1.200
5/16" - 18	0270904	0378904	18	3	0.250	0.200	2.95	0.937
3/8" - 16	0270905	0378905	16	5	0.250	0.240	2.95	1.125
7/16" - 14	0270906	0378906	14	5	0.312	0.310	3.35	1.286
1/2" - 13	0270907	0378907	13	5	0.312	0.310	3.35	1.500
9/16" - 12	0270908	0378908	12	5	0.375	0.370	3.35	1.687
3/4" - 12	0270918	0378918	12	5	0.500	0.470	3.94	2.000
5/8" - 11	0270909	0378909	11	5	0.500	0.437	4.35	1.909
3/4" - 10	0270910	0378910	10	5	0.500	0.470	3.94	2.250
7/8" - 9	0270911	0378911	9	6	0.625	0.620	5.13	2.333
1" - 8	0270912	0378912	8	6	0.625	0.620	4.10	1.875
1-1/8" - 7	0270919	0378919	7	6	0.625	0.620	4.10	2.000

Min. Size: This is the smallest internal major thread diameter a tool of specific pitch and cutting diameter can produce. Any internal mill can be used to produce larger thread diameters as long as the L1 dimension exceeds the required length of full thread. Good machining practices dictate selecting a tool having sufficient mass to mill the desired pitch, thus reducing deflection and premature tool failure.

## Solid Carbide Thread Mills



### ISO Metric Straight Flute Internal TLN Coated - Extra Long Length

Min. Size	SKU	Pitch	L2	L1	D2	D1	Flutes
M4	78950	0,70 ISO-T3	42	12,60	3,0	2,60	3
M5	78951	0,80 ISO-T3	47	16,80	4,0	3,60	3
M6	78952	1,00 ISO-T3	60	18,00	6,0	4,00	3
M8	78953	1,25 ISO-T3	65	26,25	6,0	5,00	3
M10	78954	1,50 ISO-T3	72	31,50	6,0	5,90	5
M12	78955	1,75 ISO-T3	86	36,75	8,0	7,90	5
M14	78956	2,00 ISO-T3	95	42,00	10,0	9,90	5
M16	78957	2,00 ISO-T3	115	48,00	12,0	11,00	5
M20	78958	2,50 ISO-T3	115	80,00	12,0	11,90	5

## Suggested Speeds And Feeds

### Tool Shank Diameter and number of flutes Cutting Speed and Feed per Tooth

Material	Class	4mm	6mm	8mm	10mm	12mm	16mm
		3	3	3	4	4	5
1. Steel	Plain and Low Carbon to 22 HRc	185 0,075	185 0,075	185 0,100	185 0,125	185 0,125	185 0,150
2. Medium Carbon & Alloy Steels	Carbon and Alloys to 32 HRc	175 0,025	175 0,050	175 0,075	175 0,075	175 0,075	175 0,125
3. Medium Carbon & Alloy Steels	Carbon and Alloys 32 HRc to 42 HRc	160 0,075	160 0,075	160 0,100	160 0,125	160 0,125	160 0,150
4. Stainless Steels	Austentic	160 0,025	160 0,025	160 0,038	160 0,038	160 0,050	160 0,075
5. Stainless Steels	Martensitic	165 0,025	165 0,025	165 0,038	165 0,038	165 0,050	165 0,075
6. Stainless Steels	Precipitation Hardening	90 0,025	90 0,025	90 0,025	90 0,038	90 0,038	90 0,050
7. Nickel	Nickel Base Aloys	36 0,012	36 0,012	36 0,025	36 0,025	36 0,038	36 0,050
8. Titanium	Titanium Alloys	30 0,012	30 0,012	30 0,025	30 0,025	30 0,038	30 0,050
9. Cast Iron	Gray, Malleable & Ductile	185 0,025	185 0,038	185 0,038	185 0,050	185 0,075	185 0,100
10. Non-Ferrous	Low Si Cast & Aluminum	500 0,050	500 0,050	500 0,075	500 0,075	500 0,100	500 0,150