

PRODUCT OF THE MONTH SEPTEMBER

**35%
discount**

ON OUR
MILL-THREAD SOLID CARBIDE

Type MTB

Promotional code: **PDM26-09**



Product of the Month for September: Mill-Thread Solid Carbide Type MTB

Mill-Thread Solid Carbide Type MTB –
with axial cooling, perfect for blind holes

High-performance carbide grades:

MT7 – Ultra-fine-grain carbide with multi-layer TiAlN
coating (ISO K10–K20) – ideal for medium to high cutting
speeds, suitable for all materials.

Features:

- Smooth cutting action thanks to flutes
- Cutting diameter starting at 2.2 mm
- For through and blind hole threads
- Multi-layer coating for longer tool life
- Right-hand and left-hand threads available

Please specify in your order the article numbers of the chosen Mill-Thread Solid Carbide Type MTB and the promotional code: **PDM26-09**.



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

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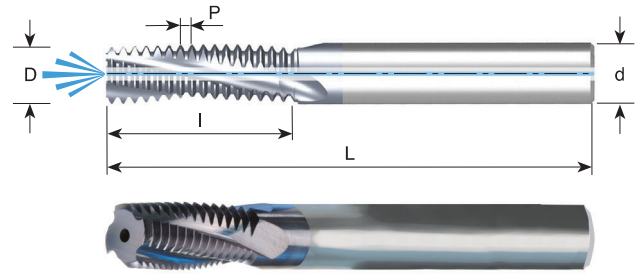
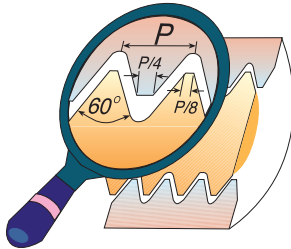
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ISO With internal coolant bore

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	I	L
0.5		M5	MTB 06038 C10 0.5 ISO	6	3.8	3	10.3	58
0.7	M4		MTB 06031 C7 0.7 ISO	6	3.1	3	7.4	58
0.75		M6, M8	MTB 06045 C10 0.75 ISO	6	4.5	3	10.1	58
0.75		M12, M14	MTB 1010 D24 0.75 ISO	10	10.0	4	24.4	73
0.8	M5		MTB 06038 C9 0.8 ISO	6	3.8	3	9.2	58
0.8	M5		MTB 0604 C13 0.8 ISO	6	4.0	3	13.2	58
1.0	M6		MTB 06046 C10 1.0 ISO	6	4.6	3	10.5	58
1.0	M6		MTB 06046 C14 1.0 ISO	6	4.6	3	14.5	58
1.0		M8	MTB 0606 C12 1.0 ISO	6	6.0	3	12.5	58
1.0		M10	MTB 0808 D16 1.0 ISO	8	8.0	4	16.5	64
1.0		M12	MTB 1010 D24 1.0 ISO	10	10.0	4	24.5	73
1.25	M8	M10	MTB 0606 C14 1.25 ISO	6	6.0	3	14.4	58
1.25	M8	M10	MTB 0606 C19 1.25 ISO	6	6.0	3	19.4	58
1.5	M10	M12	MTB 08078 C17 1.5 ISO	8	7.8	3	17.0	64
1.5	M10	M12	MTB 08078 C24 1.5 ISO	8	7.8	3	24.8	76
1.5		M14	MTB 1010 D21 1.5 ISO	10	10.0	4	21.8	73
1.5		M14-M18	MTB 1212 D26 1.5 ISO	12	12.0	4	26.3	84
1.5		M20	MTB 1616 F33 1.5 ISO	16	16.0	6	33.8	105
1.75	M12		MTB 1009 C20 1.75 ISO	10	9.0	3	20.1	73
1.75	M12		MTB 1009 C28 1.75 ISO	10	9.0	3	28.9	73
2.0	M14	M17	MTB 1010 C27 2.0 ISO	10	10.0	3	27.0	73
2.0	M14	M17	MTB 1211 D39 2.0 ISO	12	11.0	4	39.0	105
2.0	M16	M18, M20	MTB 12118 D27 2.0 ISO	12	11.8	4	27.0	84
2.0	M16	M18, M20	MTB 12118 D39 2.0 ISO	12	11.8	4	39.0	105
2.0		M26	MTB 2020 F41 2.0 ISO	20	20.0	6	41.0	105
2.5	M20		MTB 1615 E33 2.5 ISO	16	15.0	5	33.8	105
2.5	M20		MTB 1615 E48 2.5 ISO	16	15.0	5	48.8	105
3.0	M24	M28	MTB 2018 D40 3.0 ISO	20	18.0	4	40.5	105
3.0	M24	M28	MTB 2018 D58 3.0 ISO	20	18.0	4	58.5	120
3.0	M27	M28, M30	MTB 2020 D43 3.0 ISO	20	20.0	4	43.5	105

Order example: MTB 08078 C17 1.5 ISO MT7

● First choice

○ Alternative

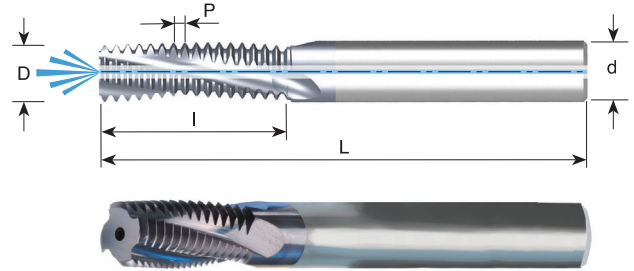
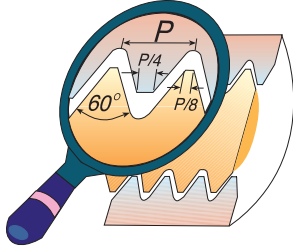
For thread mills with coolant through the flutes see next page

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



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	I	L
32	8	10	12	MTB 06032 C6 32 UN	6	3.2	3	6.8	58
32			5/16	MTB 0606 C14 32 UN	6	6.0	3	14.7	58
32			3/8	MTB 0808 D18 32 UN	8	8.0	4	18.7	64
28		1/4		MTB 0605 C11 28 UN	6	5.0	3	11.3	58
28		1/4		MTB 06052 C15 28 UN	6	5.2	3	15.0	58
28			7/16-1/2	MTB 0606 C14 28 UN	6	6.0	3	14.1	58
24		5/16		MTB 08066 C14 24 UN	8	6.6	3	14.3	64
24		3/8	9/16-5/8	MTB 0808 D21 24 UN	8	8.0	4	20.6	64
20	1/4			MTB 06047 C12 20 UN	6	4.7	3	12.1	58
20		7/16-1/2		MTB 0808 C21 20 UN	8	8.0	3	21.0	64
20		1/2		MTB 1010 D22 20 UN	10	10.0	4	22.3	73
20			3/4-1	MTB 1212 E27 20 UN	12	12.0	5	27.3	84
18	5/16			MTB 06056 C14 18 UN	6	5.6	3	14.8	58
18	5/16			MTB 0606 C20 18 UN	6	6.0	3	20.5	58
18		9/16-5/8	1 1/8-1 5/8	MTB 12113 D26 18 UN	12	11.3	4	26.1	84
16	3/8			MTB 08067 C16 16 UN	8	6.7	3	16.7	64
16	3/8			MTB 08074 C24 16 UN	8	7.4	3	24.6	64
16		3/4		MTB 1212 D31 16 UN	12	12.0	4	31.0	84
14	7/16			MTB 08077 C20 14 UN	8	7.7	3	20.9	64
14	7/16			MTB 10085 C28 14 UN	10	8.5	3	28.1	73
14		7/8		MTB 1616 E37 14 UN	16	16.0	5	37.2	105
13	1/2			MTB 10092 C22 13 UN	10	9.2	3	22.5	73
13	1/2			MTB 10098 D32 13 UN	10	9.8	4	32.2	73
12	9/16			MTB 12105 C26 12 UN	12	10.5	3	26.5	84
12	9/16			MTB 12116 D37 12 UN	12	11.6	4	37.0	84
12		1-1 1/2		MTB 1616 E41 12 UN	16	16.0	5	41.3	105
11	5/8			MTB 12114 C28 11 UN	12	11.4	3	28.9	84
11	5/8			MTB 1212 D38 11 UN	12	12.0	4	38.1	84
10	3/4			MTB 16144 D34 10 UN	16	14.4	4	34.3	105
10	3/4			MTB 16147 E49 10 UN	16	14.7	5	49.5	105
9	7/8			MTB 1616 C38 9 UN	16	16.0	3	38.1	105
8	1			MTB 20195 D42 8 UN	20	19.5	4	42.9	105
7	1 1/8 - 1 1/4			MTB 2020 D45 7 UN	20	20.0	4	45.3	105

Order example: MTB 1212 D31 16 UN MT7

● First choice

○ Alternative

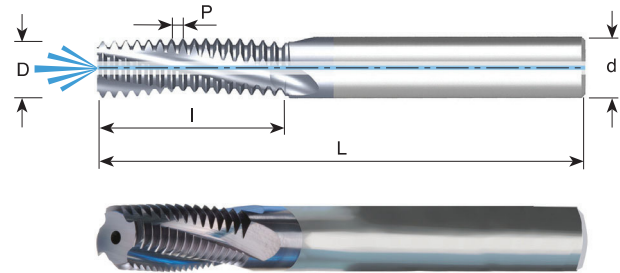
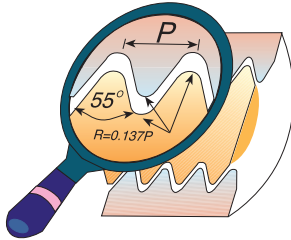
For thread mills with coolant through the flutes see next page

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



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

Same Tool for Internal and External Thread



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

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

Order example: MTB 1010 D16 19 W MT7

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



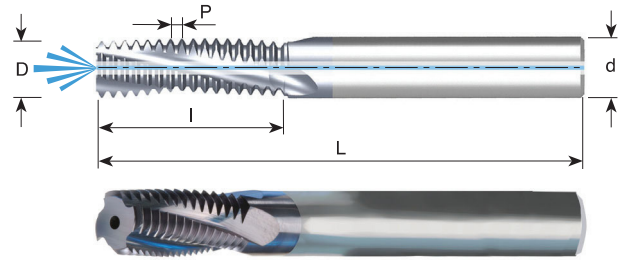
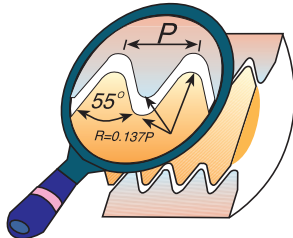
TOOL FINDER & CUTTING DATA

Mill-Thread Solid Carbide



Whitworth With internal coolant bore

Same Tool for Internal and External Thread



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

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

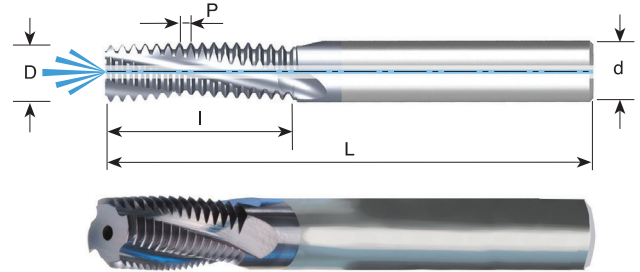
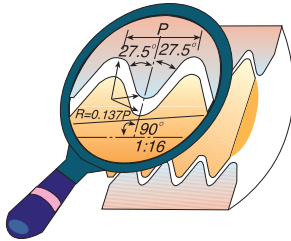
Order example: MTB 06046 C13 20 W MT7



TOOL FINDER & CUTTING DATA

BSPT With internal coolant bore

Same Tool for Internal and External Thread



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

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

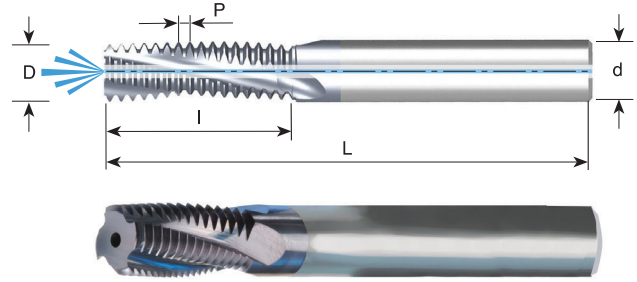
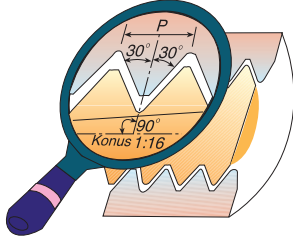
Order example: MTB 08078 C14 28 BSPT MT7



TOOL FINDER & CUTTING DATA

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	I	L
27	1/8	MTB 08076 C10 27 NPT	8	7.6	3	10.8	64
18	1/4-3/8	MTB 1010 D16 18 NPT	10	10.0	4	16.2	73
14	1/2-3/4	MTB 16155 D22 14 NPT	16	15.5	4	22.7	105
11.5	1-2	MTB 2020 D29 11.5 NPT	20	20.0	4	29.8	105
8	≥2 1/2	MTB 2020 D39 8 NPT	20	20.0	4	39.7	105

Order example: MTB 1010 D16 18 NPT MT7

For thread mills with coolant through the flutes see next page

For conical preparation end mills see page B08-23

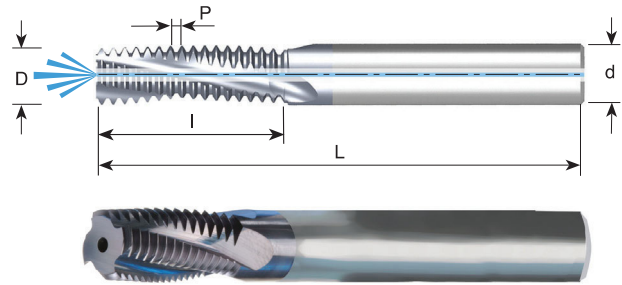
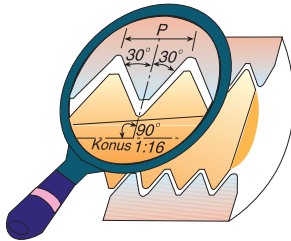
● First choice ○ Alternative



TOOL FINDER & CUTTING DATA

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	I	L
27	1/8	MTB 08076 C10 27 NPTF	8	7.6	3	10.8	64
18	1/4-3/8	MTB 1010 D16 18 NPTF	10	10.0	4	16.2	73
14	1/2-3/4	MTB 16155 D22 14 NPTF	16	15.5	4	22.7	105
11.5	1-2	MTB 2020 D29 11.5 NPTF	20	20.0	4	29.8	105
8	≥ 2 1/2	MTB 2020 D39 8 NPTF	20	20.0	4	39.7	105

Order example: MTB 16155 D22 14 NPTF MT7



TOOL FINDER & CUTTING DATA

For conical preparation end mills see page B08-23

● First choice

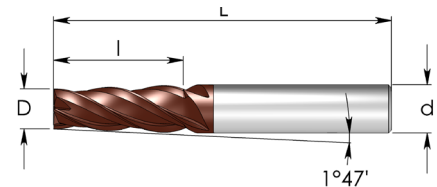
○ Alternative

Solid Carbide Tapered End Mills

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

Advantages:

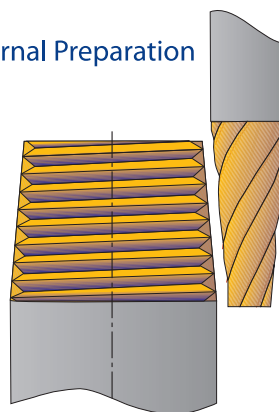
- * Increases the tool life of mill thread cutters and indexable inserts.
- * Equal and uniform load along the cutting edge of the mill thread cutter.
- * Shorter machining time during the mill thread operation, due to the tapered preparation.
- * Same tool for internal and external preparation.



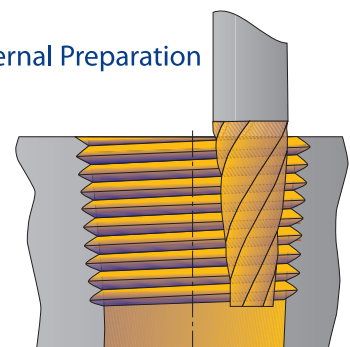
Ordering Code	d	D	I	L	No. of Flutes	Size
SC0652D12	6	5.2	12	58	4	NPT 1/16" - 1/8" NPTF 1/16" - 1/8" BSPT 1/16" - 1/8"
SC1085D24	10	8.5	24	73	4	NPT 1/4" - 1" NPTF 1/4" - 1" BSPT 1/4" - 1"
SC1210D32	12	10	32	84	4	NPT 1/4" - 3" NPTF 1/4" - 3" BSPT 1/4" - 3"

Order example: SC 1085 D24 MT7
Carbide grade: MT7

External Preparation

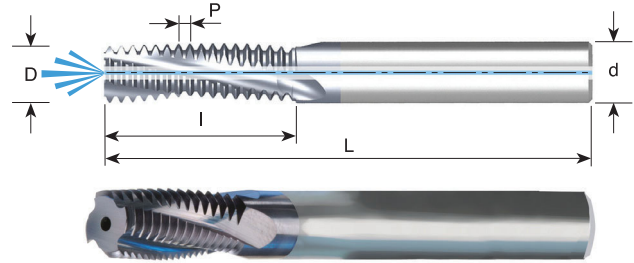
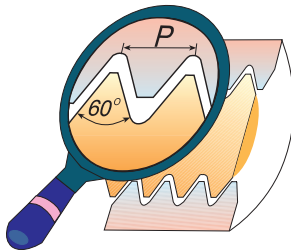


Internal Preparation



NPS With internal coolant bore

Same Tool for Internal and External Thread - Inch Shank



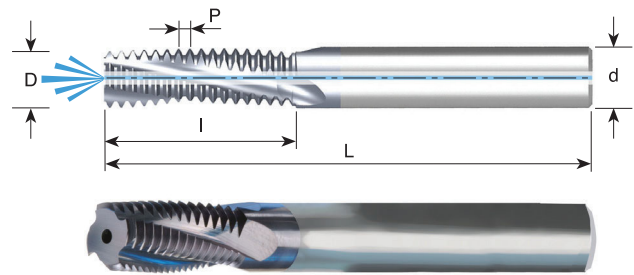
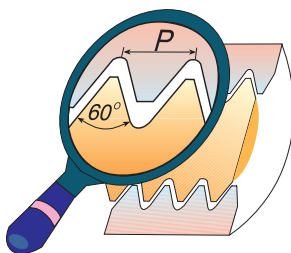
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

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

Order example: MTB 0375 D06 18 NPS MT7

NPSF With internal coolant bore

Same Tool for Internal and External Thread - Inch Shank



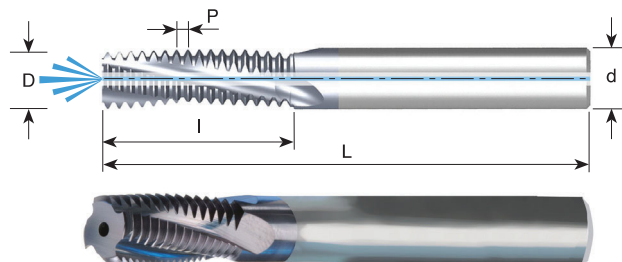
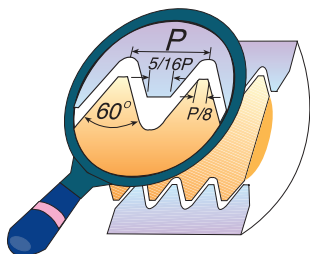
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

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

Order example: MTB 0312 C04 27 NPSF MT7

MJ With internal coolant bore

Tools for internal thread



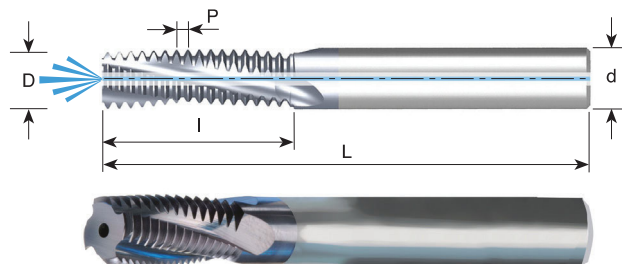
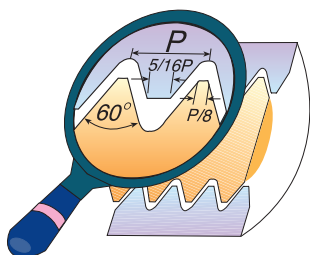
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

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

Order example: MTB 06048 D12 1.0 MJ MT7

UNJ With internal coolant bore

Tools for internal thread



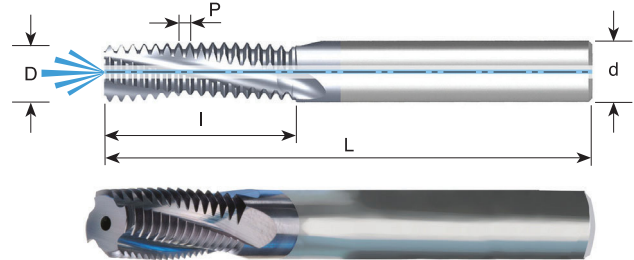
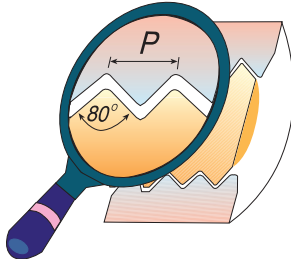
Grade	P	M	K	N	S	H
MT7	●	●	●	○	●	≤47 HRc

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

Order example: MTB 0606 C16 18 UNJ MT7

PG DIN 40430 - With internal coolant bore

Same Tool for Internal and External Thread



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

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

Order example: MTB 1212 D20 18 PG MT7

● First choice ○ Alternative



TOOL FINDER & CUTTING DATA

Please specify in your order the article numbers of the chosen Mill-Thread Solid Carbide Type MTB and the promotional code: **PDM26-09**.