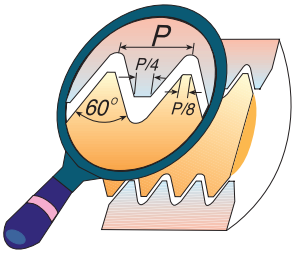
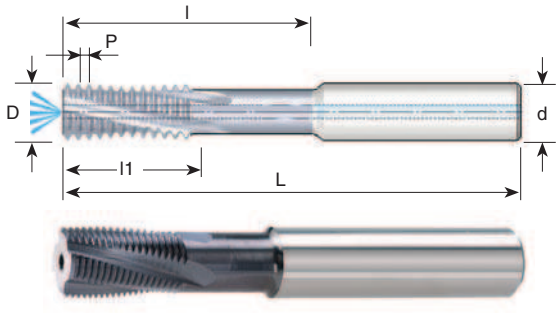
ISO With relieved neck and internal coolant bore

Tools for Internal Thread





Pitch mm	M fine	Ordering Code	d	D	No. of Flutes	l1	l	L
1.0	∅≥ 12	MTQ1010D32 1.0 ISO	10	10.0	4	18.0	32.0	73
1.0	∅≥ 14	MTQ1212D38 1.0 ISO	12	12.0	4	21.0	38.0	84
1.0	∅≥ 18	MTQ1616F45 1.0 ISO	16	16.0	6	26.0	45.0	105
1.5	∅≥ 13	MTQ1010D30 1.5 ISO	10	10.0	4	18.0	30.0	73
1.5	∅≥ 15	MTQ1212D34 1.5 ISO	12	12.0	4	19.5	34.5	84
1.5	∅≥ 19	MTQ1616F43 1.5 ISO	16	16.0	6	25.5	43.5	105
1.5	∅≥ 23	MTQ2020F60 1.5 ISO	20	20.0	6	36.0	60.0	105
2.0	∅≥ 16	MTQ1212D42 2.0 ISO	12	12.0	4	24.0	42.0	84
2.0	∅≥ 20	MTQ1616E45 2.0 ISO	16	16.0	5	26.0	45.0	105
2.0	∅≥ 24	MTQ2020F56 2.0 ISO	20	20.0	6	34.0	56.0	105
3.0	∅≥ 22	MTQ1616D45 3.0 ISO	16	16.0	4	30.0	45.0	105
3.0	∅≥ 26	MTQ2020E54 3.0 ISO	20	20.0	5	33.0	54.0	105
3.5	∅≥ 26	MTQ2020D45 3.5 ISO	20	20.0	4	28.0	45.5	105
4.0	∅≥ 31	MTQ2525D64 4.0 ISO	25	25.0	4	40.0	64.0	160

Order example: MTQ 1010D30 1.5 ISO MT7

Thread mills with relieved neck and internal coolant for milling medium and large threads on relatively deep work pieces.

Carbide grade: MT7

- To perform medium and large threads on relatively deep work pieces.
- To use overhang according to the application.
- To perform deep threads at the bottom of the application.

Advantages

- Provides high rigidity and stability (anti-vibrations).
- Accomplishes deep threads in one pass.
- Relatively low cutting forces due to short cutting length which enables reduction of the radial in feed required.
- Threads length up to 3D.

For small thread mills see pages 105 & 113

MTQ type

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO Standard	Material	Cutting Speed m/min	Feed mm/tooth					
			Ø10	Ø12	Ø14	Ø16	Ø20	Ø25
P	Low and Medium Carbon Steels <0.55%C	100-250	0.06	0.07	0.07	0.08	0.10	0.12
	High Carbon Steels ≥0.55%C	110-180	0.05	0.05	0.06	0.07	0.09	0.10
	Alloy Steels, Treated Steels	90-160	0.03	0.04	0.04	0.05	0.06	0.07
M	Stainless Steels - Free Cutting	60-160	0.04	0.04	0.05	0.06	0.06	0.08
	Stainless Steels - Austenitic	60- 120	0.04	0.04	0.04	0.05	0.06	0.07
	Cast Steels	130-170	0.03	0.04	0.04	0.05	0.06	0.07
K	Cast Iron	70-150	0.06	0.07	0.07	0.08	0.10	0.12
N	Aluminium ≤10%Si, Copper	150-350	0.06	0.07	0.07	0.08	0.10	0.12
	Aluminium ≥10% Si	100-250	0.03	0.04	0.04	0.05	0.06	0.07
	Synthetics, Duroplastics, Thermoplastics	100-400	0.08	0.09	0.10	0.11	0.13	0.15
S	Nickel Alloys, Titanium Alloys	20- 80	0.02	0.02	0.02	0.03	0.03	0.03

For cutters with long cutting length reduce feed rate by 40%