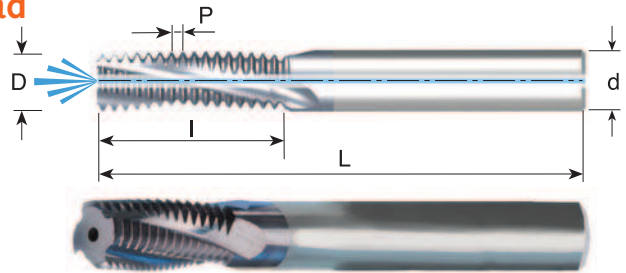


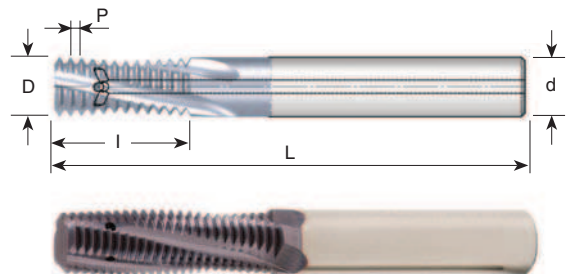
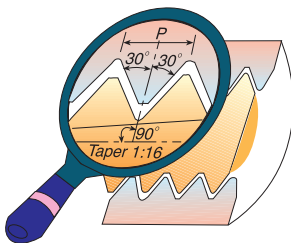
NPTF With internal coolant Same Tool for Internal and External Thread



Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTB08076C10 27 NPTF	8	7.6	3	10.8	64
18	1/4-3/8	MTB1010D16 18 NPTF	10	10.0	4	16.2	73
14	1/2-3/4	MTB16155D22 14 NPTF	16	15.5	4	22.7	105
11.5	1-2	MTB2020D29 11.5 NPTF	20	20.0	4	29.8	105
8	≥ 2 1/2	MTB2020D39 8 NPTF	20	20.0	4	39.7	105

Order example: MTB 16155D22 14 NPTF MT7

NPTF With internal coolant through the flutes Same Tool for Internal and External Thread



Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
27	1/8	MTZ08076C10 27NPTF	8	7.6	3	10.8	64
18	1/4-3/8	MTZ1010D16 18NPTF	10	10.0	4	16.2	73
14	1/2-3/4	MTZ16155D22 14NPTF	16	15.5	4	22.7	101

Order example: MTZ 1010D16 18 NPTF MT7

For conical preparation end mills see page 100

Mill-Thread Solid Carbide Grades, Speed and Feed Selection

MT, MTB, MTZ, EMT types

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										
			Ø2	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16	Ø20	Ø25
P	Low and Medium Carbon Steels <0.55%C	100-250	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18
	High Carbon Steels ≥0.55%C	110-180	0.02	0.03	0.03	0.05	0.06	0.07	0.08	0.09	0.10	0.12	0.15
	Alloy Steels, Treated Steels	90-160	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
M	Stainless Steels - Free Cutting	60-160	0.02	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.11
	Stainless Steels - Austenitic	60-120	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
	Cast Steels	130-170	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
K	Cast Iron	70-150	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18
N	Aluminium ≤10%Si, Copper	150-350	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18
	Aluminium ≥10% Si	100-250	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
	Synthetics, Duroplastics, Thermoplastics	100-400	0.05	0.06	0.07	0.08	0.10	0.11	0.12	0.14	0.15	0.18	0.22
S	Nickel Alloys, Titanium Alloys	20- 80	0.02	0.02	0.02	0.03	0.03	0.03	0.03	0.04	0.04	0.04	0.05

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