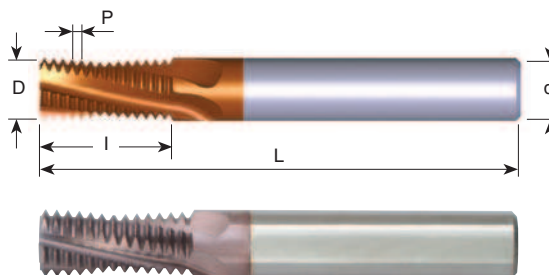
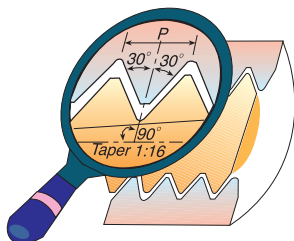


## NPT

Same Tool for Internal and External Thread

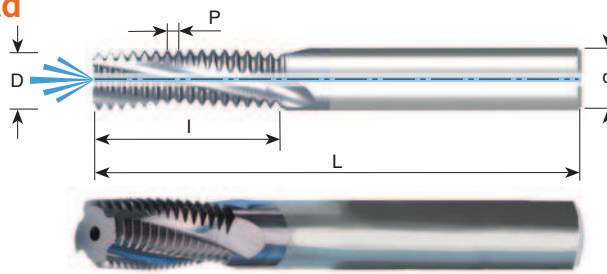


| Pitch<br>TPI | Standard   | Ordering Code      | d  | D    | No. of<br>Flutes | I    | L   |
|--------------|------------|--------------------|----|------|------------------|------|-----|
| 27           | 1/16 - 1/8 | MT0606C9 27 NPT    | 6  | 6.0  | 3                | 9.9  | 58  |
| 18           | 1/4-3/8    | MT0808C14 18 NPT   | 8  | 8.0  | 3                | 14.8 | 64  |
| 14           | 1/2-3/4    | MT1212D20 14 NPT   | 12 | 12.0 | 4                | 20.9 | 84  |
| 11.5         | 1-2        | MT1616D27 11.5 NPT | 16 | 16.0 | 4                | 27.6 | 105 |
| 8            | ≥ 2 1/2    | MT2020D39 8 NPT    | 20 | 20.0 | 4                | 39.7 | 105 |

Order example: MT 0808C14 18 NPT MT7

## NPT With internal coolant

Same Tool for Internal and External Thread



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

Order example: MTB 1010D16 18 NPT MT7

For thread mills with coolant through the flutes see next page  
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  |
| <b>P</b>     | 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 |
| <b>M</b>     | 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 |
| <b>K</b>     | 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 |
| <b>N</b>     | 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 |
| <b>S</b>     | 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%