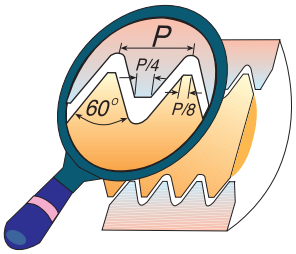
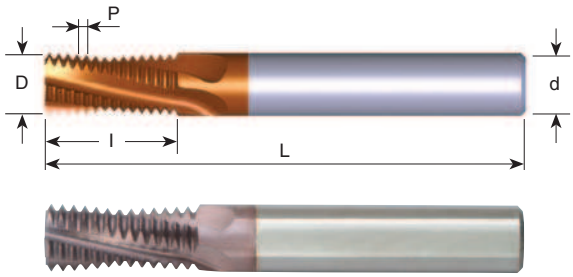
UN

Tools for Internal Thread





Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	l	L
40	5			MT06025C6 40 UN	6	2.5	3	6.0	58
32	8	10	12	MT06032C6 32 UN	6	3.2	3	6.8	58
28		1/4		MT0604C11 28 UN	6	4.0	3	11.3	58
28			7/16-1/2	MT0606C14 28 UN	6	6.0	3	14.1	58
24		5/16		MT0605C14 24 UN	6	5.0	3	14.3	58
24		3/8	9/16-5/8	MT0807C21 24 UN	8	7.0	3	20.6	64
20	1/4			MT06045C12 20 UN	6	4.5	3	12.1	58
20		7/16-1/2		MT0807C21 20 UN	8	7.0	3	21.0	64
20			3/4-1	MT1212E27 20 UN	12	12.0	5	27.3	84
18	5/16			MT0605C14 18 UN	6	5.0	3	14.8	58
18		9/16-5/8	$1^{1/8}$-$1^{5/8}$	MT1010D26 18 UN	10	10.0	4	26.1	73
16	3/8			MT0606C16 16 UN	6	6.0	3	16.7	58
16		3/4		MT1212D31 16 UN	12	12.0	4	31.0	84
14	7/16			MT0807C20 14 UN	8	7.0	3	20.9	64
14		7/8		MT1615E37 14 UN	16	15.0	5	37.2	105
13	1/2			MT0808C22 13 UN	8	8.0	3	22.5	64
12	9/16			MT1010C26 12 UN	10	10.0	3	26.5	73
12		$1\text{-}1^{1/2}$		MT1616E41 12 UN	16	16.0	5	41.3	105
11	5/8			MT1010C28 11 UN	10	10.0	3	28.9	73
10	3/4			MT1212C34 10 UN	12	12.0	3	34.3	84
9	7/8			MT1615C38 9 UN	16	15.0	3	38.1	105
8	1			MT1616C42 8 UN	16	16.0	3	42.9	105
7	$1^{1/8}$ -$1^{1/4}$			MT2020D45 7 UN	20	20.0	4	45.3	105

Order example: MT 1615E37 14UN MT7

For thread mills with coolant bore see following pages

For small thread mills see pages 106-107, 114

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%