

# CARBIDE THREAD MILLS



**Spiral Fluted  
Solid Carbide  
Thread Mills  
TiAlN Coating**



- Free cutting 30 degree helix for quiet, chatter-free cuts and excellent tool life
- All tools feature thread lengths of 1.5 x nominal thread diameter for excellent versatility
- Optimized shank lengths ensure a stable, chatter free cut
- Sub-micro grain substrate with cobalt for excellent wear resistance combined with outstanding edge toughness

## APPLICATION

Non-Ferrous  
Carbon Steel  
Stainless Steel

**INCH  
METRIC**

RECOMMENDED USEABLE

### Unified Threads

Thread Diameter	TPI	Thread Form	No. of Flutes	Cut Diameter	OAL	Cut Length	Shank Diameter	EDP
1/4	20	UNC	3	0.160	1.978	0.400	0.250	52002
5/16	18	UNC	3	0.208	2.078	0.500	0.250	52008
3/8	16	UNC	3	0.246	2.141	0.563	0.250	52007
7/16	14	UNC	3	0.310	2.620	0.714	0.375	52010
1/2	13	UNC	3	0.350	2.756	0.850	0.375	52001
9/16	12	UNC	3	0.370	2.822	0.916	0.375	52012
5/8	11	UNC	4	0.448	3.141	1.000	0.500	52009
3/4	10	UNC	4	0.567	3.090	1.200	0.625	52006
7/8	9	UNC	4	0.621	3.836	1.571	0.625	52011
1	8	UNC	4	0.620	3.765	1.500	0.625	52005
1-1/4	7	UNC	4	0.745	4.266	1.875	0.750	52004
1-1/2	6	UNC	4	0.745	4.641	2.250	0.750	52003
1/4	28	UNF	3	0.177	1.971	0.393	0.250	53002
3/8	24	UNF	3	0.246	2.078	0.500	0.250	53005
1/2	20	UNF	3	0.334	2.706	0.800	0.375	53001
5/8	18	UNF	4	0.444	3.141	1.000	0.500	53006
3/4	16	UNF	4	0.614	3.765	1.500	0.625	53004
7/8	14	UNF	4	0.621	3.836	1.571	0.625	53007
1	12	UNF	4	0.621	3.765	1.500	0.625	53003

### ISO/Metric Threads

Thread Diameter	Pitch	Thread Form	No. of Flutes	Cut Diameter	OAL	Cut Length	Shank Diameter	EDP
M6	1.00	ISO	3	0.160	2.011	0.433	0.250	50009
M10	1.25	ISO	3	0.240	2.267	0.689	0.250	50001
M12	1.75	ISO	3	0.338	2.733	0.827	0.375	50002
M14	1.50	ISO	3	0.280	2.556	0.650	0.375	50003
M16	2.00	ISO	3	0.468	3.165	1.024	0.500	50004
M20	2.50	ISO	4	0.590	3.643	1.378	0.625	50005
M24	3.00	ISO	4	0.621	3.800	1.535	0.625	50006
M30	3.50	ISO	4	0.745	4.044	1.653	0.750	50007
M36	4.00	ISO	4	0.745	4.280	1.889	0.750	50008

### Pipe Threads

Thread Diameter	TPI	Thread Form	No. of Flutes	Cut Diameter	OAL	Length of Cut	Shank Diameter	EDP
1/8	27	NPT	3	0.300	2.276	0.370	0.375	51003
1/4	18	NPT	3	0.371	2.276	0.555	0.375	51002
1/2	14	NPT	4	0.621	3.053	0.788	0.625	51001
1	11.5	NPT	4	0.620	3.309	1.044	0.625	51004
2-1/2	8	NPT	4	0.745	4.141	1.750	0.750	51005

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