

ThreadBurr for Internal Threading

AC

TiAlCN coated, Micrograin Carbide

Tolerance

The theoretical external diameter of the cutter is lasermarked on the tool.

Shank

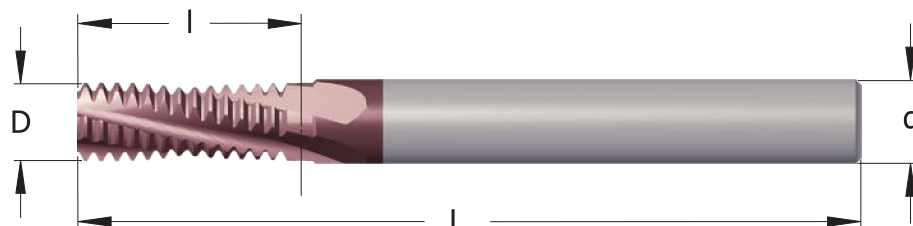
Cylindrical h6, DIN6535 HA

Flute

Between 12° and 18°

Field of application

Thread Milling of all types of steel



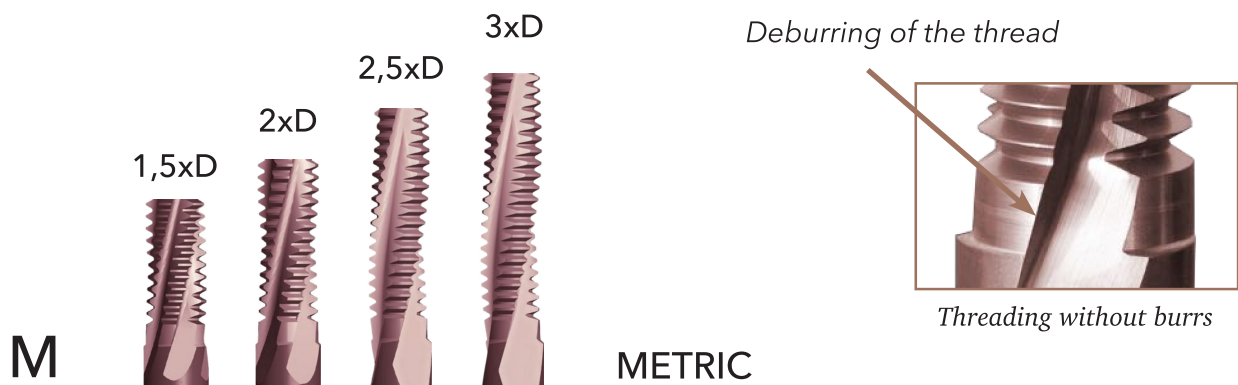
M

METRIC

Pitch mm	M coarse	M fine	Vib. free	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
0,4	M2 (1,5xD)			NB04015C3_0.4ISO_AC	4	1,5	3	3,4	50
0,4	M2 (2xD)			NB04015C4_0.4ISO_AC	4	1,5	3	4,6	50
0,45	M2,2 (1,5xD)			NB04016C3_0.45ISO_AC	4	1,65	3	3,82	50
0,45	M2,2 (2xD)		VF	NB04016C5_0.45ISO_AC	4	1,65	3	5,17	50
0,45	M2,5 (1,5xD)			NB04019C4_0.45ISO_AC	4	1,9	3	4,27	50
0,45	M2,5 (2xD)			NB04019C5_0.45ISO_AC	4	1,9	3	5,62	50
0,5	M3 (1,5xD)	≥ M3,5		NB04023C5_0.5ISO_AC	4	2,3	3	5,25	50
0,5	M3 (1,5xD)	≥ M3,5	VF	NB04023E5_0.5ISO_AC	4	2,3	5	5,25	50
0,5	M3 (2xD)	≥ M3,5		NB04023C6_0.5ISO_AC	4	2,3	3	6,75	50
0,5	M3 (2xD)	≥ M3,5	VF	NB04023D6_0.5ISO_AC	4	2,3	4	6,75	50
0,5	M3 (2,5xD)	≥ M3,5	VF	NB04023C8_0.5ISO_AC	4	2,3	3	8,25	50
0,5	M3 (1,5xD)	≥ M3,5		NB06023C5_0.5ISO_AC	6	2,3	3	5,25	63
0,5	M3 (2xD)	≥ M3,5		NB06023C6_0.5ISO_AC	6	2,3	3	6,75	63
0,5	M3 (2,5xD)	≥ M3,5	VF	NB06023C8_0.5ISO_AC	6	2,3	3	8,25	63
0,5		≥ M5		NB04038C10_0.5ISO_AC	4	3,8	3	10,75	50
0,5		≥ M5		NB06038C10_0.5ISO_AC	6	3,8	3	10,75	63
0,6	M3,5 (1,5xD)			NB04026C6_0.6ISO_AC	4	2,6	3	6,3	50
0,6	M3,5 (2xD)			NB04026C8_0.6ISO_AC	4	2,6	3	8,1	50
0,7	M4 (1,5xD)			NB0403C7_0.7ISO_AC	4	3	3	7,35	50
0,7	M4 (1,5xD)		VF	NB0403E7_0.7ISO_AC	4	3	5	7,35	50
0,7	M4 (2xD)			NB0403C8_0.7ISO_AC	4	3	3	8,75	50
0,7	M4 (2xD)		VF	NB0403D8_0.7ISO_AC	4	3	4	8,75	50
0,7	M4 (2,5xD)		VF	NB0403C10_0.7ISO_AC	4	3	3	10,85	50
0,7	M4 (1,5xD)			NB0603C7_0.7ISO_AC	6	3	3	7,35	63
0,7	M4 (2xD)			NB0603C8_0.7ISO_AC	6	3	3	8,75	63
0,7	M4 (2,5xD)		VF	NB0603C10_0.7ISO_AC	6	3	3	10,85	63
0,75	M4,5 (1,5xD)	≥ M5		NB04034C7_0.75ISO_AC	4	3,4	3	7,87	50
0,75	M4,5 (2xD)	≥ M5		NB04034C10_0.75ISO_AC	4	3,4	3	10,12	50
0,75		≥ M6		NB06045C10_0.75ISO_AC	6	4,5	3	10,87	63
0,75		≥ M6	VF	NB06045C16_0.75ISO_AC	6	4,5	3	16,87	63
0,75		≥ M6	VF	NB06048E10_0.75ISO_AC	6	4,8	5	10,87	63
0,8	M5 (1,5xD)			NB04038C8_0.8ISO_AC	4	3,8	3	8,4	50
0,8	M5 (1,5xD)		VF	NB04038E8_0.8ISO_AC	4	3,8	5	8,4	50
0,8	M5 (2xD)			NB04038C10_0.8ISO_AC	4	3,8	3	10,8	50
0,8	M5 (2xD)		VF	NB04038D10_0.8ISO_AC	4	3,8	4	10,8	50
0,8	M5 (2,5xD)		VF	NB04038C13_0.8ISO_AC	4	3,8	3	13,2	50
0,8	M5 (1,5xD)			NB06038C8_0.8ISO_AC	6	3,8	3	8,4	63
0,8	M5 (2xD)			NB06038C10_0.8ISO_AC	6	3,8	3	10,8	63
0,8	M5 (2,5xD)			NB06038C13_0.8ISO_AC	6	3,8	3	13,2	63
1	M6 (1,5xD)	≥ M8		NB06045C10_1.0ISO_AC	6	4,5	3	10,5	63
1	M6 (1,5xD)	≥ M8	VF	NB06045E10_1.0ISO_AC	6	4,5	5	10,5	63
1	M6 (2xD)	≥ M8		NB06045C13_1.0ISO_AC	6	4,5	3	13,5	63
1	M6 (2xD)	≥ M8	VF	NB06045D13_1.0ISO_AC	6	4,5	4	13,5	63
1	M6 (2,5xD)	≥ M8	VF	NB06045C16_1.0ISO_AC	6	4,5	3	16,5	63
1	M6 (3xD)	≥ M8	VF	NB06045C19_1.0ISO_AC	6	4,5	3	19,5	63
1		≥ M8		NB0606C10_1.0ISO_AC	6	6	3	10,5	63
1		≥ M8		NB0606C13_1.0ISO_AC	6	6	3	13,5	63
1		≥ M8	VF	NB0606E14_1.0ISO_AC	6	6	5	14,5	63

VF = Vibration-Free if you use the entire cutting length, [see page 6](#).

continue



Pitch mm	M coarse	M fine	Vib. free	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
1		≥ M10		NB0808D10_1.0ISO_AC	8	8	4	10,5	63
1		≥ M10		NB0808D13_1.0ISO_AC	8	8	4	13,5	63
1		≥ M10	VF	NB0808F16_1.0ISO_AC	8	8	6	16,5	63
1		≥ M10		NB0808D17_1.0ISO_AC	8	8	4	17,5	63
1		≥ M12		NB1010E14_1.0ISO_AC	10	10	5	14,5	76
1		≥ M12	VF	NB1010G17_1.0ISO_AC	10	10	7	17,5	76
1		≥ M12	VF	NB1010E19_1.0ISO_AC	10	10	5	19,5	76
1		≥ M14		NB1212F15_1.0ISO_AC	12	12	6	15,5	83
1		≥ M14	VF	NB1212H18_1.0ISO_AC	12	12	8	18,5	83
1		≥ M14	VF	NB1212F21_1.0ISO_AC	12	12	6	21,5	83
1,25	M8 (1,5xD)	≥ M10		NB0606C14_1.25ISO_AC	6	6	3	14,37	63
1,25	M8 (1,5xD)	≥ M10	VF	NB0606E14_1.25ISO_AC	6	6	5	14,37	63
1,25	M8 (2xD)	≥ M10		NB0606C18_1.25ISO_AC	6	6	3	18,12	63
1,25	M8 (2xD)	≥ M10	VF	NB0606D18_1.25ISO_AC	6	6	4	18,12	63
1,25	M8 (2,5xD)	≥ M10	VF	NB0606C21_1.25ISO_AC	6	6	3	21,87	63
1,25	M8 (3xD)	≥ M10	VF	NB0606C25_1.25ISO_AC	6	6	3	25,62	76
1,5	M10 (1,5xD)	≥ M12		NB08075C17_1.5ISO_AC	8	7,5	3	17,25	63
1,5	M10 (1,5xD)	≥ M12	VF	NB08075E17_1.5ISO_AC	8	7,5	5	17,25	63
1,5	M10 (2xD)	≥ M12		NB08075C21_1.5ISO_AC	8	7,5	3	21,75	76
1,5	M10 (2xD)	≥ M12	VF	NB08075D21_1.5ISO_AC	8	7,5	4	21,75	76
1,5	M10 (2,5xD)	≥ M12	VF	NB08075C27_1.5ISO_AC	8	7,5	3	27,75	76
1,5	M10 (3xD)	≥ M12	VF	NB08075C32_1.5ISO_AC	8	7,5	3	32,25	76
1,5		≥ M14		NB1010D17_1.5ISO_AC	10	10	4	17,25	76
1,5		≥ M14	VF	NB1010F20_1.5ISO_AC	10	10	6	20,25	76
1,5		≥ M14		NB1010D23_1.5ISO_AC	10	10	4	23,25	76
1,5		≥ M16		NB1212E15_1.5ISO_AC	12	12	5	15,75	83
1,5		≥ M16		NB1212E21_1.5ISO_AC	12	12	5	21,75	83
1,5		≥ M16	VF	NB1212G21_1.5ISO_AC	12	12	7	21,75	83
1,5		≥ M16	VF	NB1212E29_1.5ISO_AC	12	12	5	29,25	83
1,5		≥ M20		NB1616F18_1.5ISO_AC	16	16	6	18,75	89
1,5		≥ M20	VF	NB1616H24_1.5ISO_AC	16	16	8	24,75	89
1,5		≥ M20	VF	NB1616F26_1.5ISO_AC	16	16	6	26,25	89
1,5		≥ M20	VF	NB1616F35_1.5ISO_AC	16	16	6	35,25	100
1,75	M12 (1,5xD)			NB0808C20_1.75ISO_AC	8	8	3	20,12	76
1,75	M12 (2xD)		VF	NB0808C27_1.75ISO_AC	8	8	3	27,12	76
1,75	M12 (1,5xD)			NB1009C20_1.75ISO_AC	10	9	3	20,12	76
1,75	M12 (1,5xD)		VF	NB1009E20_1.75ISO_AC	10	9	5	20,12	76
1,75	M12 (2xD)			NB1009C27_1.75ISO_AC	10	9	3	27,12	76
1,75	M12 (2xD)		VF	NB1009D27_1.75ISO_AC	10	9	4	27,12	76
1,75	M12 (2,5xD)		VF	NB1009C32_1.75ISO_AC	10	9	3	32,37	100
1,75	M12 (3xD)		VF	NB1009C37_1.75ISO_AC	10	9	3	37,62	100
2	M14 (1,5xD)	≥ M18		NB1010C23_2.0ISO_AC	10	10	3	23	76
2	M14 (2xD)	≥ M18		NB1010C31_2.0ISO_AC	10	10	3	31	100
2	M14 (2,5xD)	≥ M18	VF	NB1010C37_2.0ISO_AC	10	10	3	37	100
2	M16 (1,5xD)	≥ M18		NB1212D27_2.0ISO_AC	12	12	4	27	83
2	M16 (1,5xD)	≥ M18	VF	NB1212E27_2.0ISO_AC	12	12	5	27	83
2	M16 (2xD)	≥ M18	VF	NB1212D35_2.0ISO_AC	12	12	4	35	100
2	M16 (2,5xD)	≥ M18	VF	NB1212D43_2.0ISO_AC	12	12	4	43	100
2	M16 (3xD)	≥ M18	VF	NB1212C51_2.0ISO_AC	12	12	3	51	100

M

METRIC

Pitch mm	M coarse	M fine	Vib. free	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
2		≥ M20		NB1616E29_2.0ISO_AC	16	16	5	29	89
2		≥ M20	VF	NB1616E39_2.0ISO_AC	16	16	5	39	100
2		≥ M24	VF	NB2020F43_2.0ISO_AC	20	20	6	43	100
2		≥ M24		NB2020F57_2.0ISO_AC	20	20	6	57	120
2,5	M18 (1,5xD)			NB1212C31_2.5ISO_AC	12	12	3	31,25	100
2,5	M18 (2xD)		VF	NB1212C38_2.5ISO_AC	12	12	3	38,75	100
2,5	M18 (2,5xD)		VF	NB1212C48_2.5ISO_AC	12	12	3	48,75	100
2,5	M20 (1,5xD)			NB1414D33_2.5ISO_AC	14	14	4	33,75	89
2,5	M20 (1,5xD)		VF	NB1414E33_2.5ISO_AC	14	14	5	33,75	89
2,5	M20 (2xD)		VF	NB1414D43_2.5ISO_AC	14	14	4	43,75	100
2,5	M20 (2,5xD)		VF	NB1615D53_2.5ISO_AC	16	15	4	53,75	120
2,5	M20 (3xD)		VF	NB1615C63_2.5ISO_AC	16	15	3	63,75	120
3	M24 (1,5xD)	≥ M30		NB1616C40_3.0ISO_AC	16	16	3	40,5	100
3	M24 (2xD)	≥ M30	VF	NB1616C52_3.0ISO_AC	16	16	3	52,5	120
3	M24 (2,5xD)	≥ M30	VF	NB1818C64_3.0ISO_AC	18	18	3	64,5	130
3		≥ M30		NB2020D46_3.0ISO_AC	20	20	4	46,5	120
3		≥ M30	VF	NB2020D61_3.0ISO_AC	20	20	4	61,5	150
3,5	M30 (1,5xD)			NB2020C50_3.5ISO_AC	20	20	3	50,75	120
3,5	M30 (2xD)		VF	NB2020C64_3.5ISO_AC	20	20	3	64,75	150
3,5	M30 (2,5xD)		VF	NB2020C78_3.5ISO_AC	20	20	3	78,75	150
4	M36 (1,5xD)	≥ M42		NB2020C58_4.0ISO_AC	20	20	3	58	150

ThreadBurr for External Threading

M

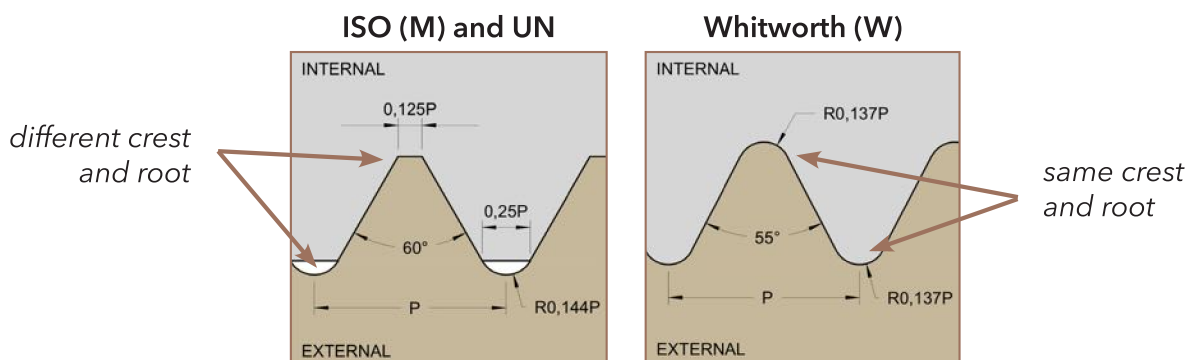
METRIC

Pitch mm	Vib. free	EXTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
1,0	VF	EB1010E21_1.0ISO_AC	10	10	5	21,5	76
1,5	VF	EB1212E26_1.5ISO_AC	12	12	5	26,25	83
2,0	VF	EB1616E35_2.0ISO_AC	16	16	5	35	100

Is it possible to use internal thread mills for external threads?

You can not use internal thread mills for external threads when threading Metrical (M) and Unified (UN) threads. They have different profile for internal and external. The internal thread has a bigger crest than root and for the external thread it is the opposite, the root is bigger than the crest.

Profiles such as W, BSPT, PG, NPT, NPTF and NPSF has the same crest as root and because of this it is possible for these profiles to use the same thread mill for internal and external threads.



ThreadBurr

AC

TiAlCN coated, Micrograin Carbide

Tolerance

The theoretical external diameter of the cutter is laser marked on the tool.

Shank

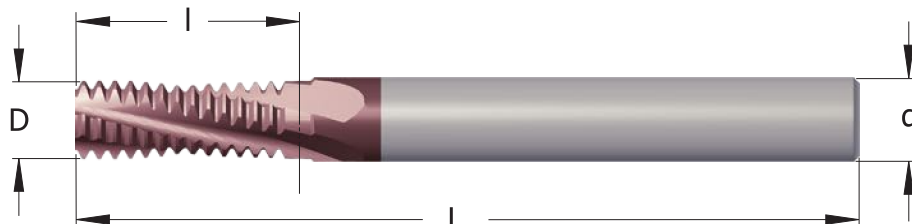
Cylindrical h6, DIN6535 HA

Flute

Between 12° and 18°

Field of application

Thread Milling of all types of steel



G/Rp

WHITWORTH PIPE THREAD

Pitch TPI	Standard	Vib. free	INTERNAL / EXTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
28	G 1/16 - 1/8		XB0606C10_28W_AC	6	6	3	10,43	63
28	G 1/16 - 1/8	VF	XB0606F10_28W_AC	6	6	6	10,43	63
28	G 1/8		XB0808D14_28W_AC	8	8	4	14,06	63
28	G 1/8	VF	XB0808G14_28W_AC	8	8	7	14,06	63
19	G 1/4 - 3/8		XB0808C15_19W_AC	8	8	3	15,37	63
19	G 1/4 - 3/8	VF	XB0808F15_19W_AC	8	8	6	15,37	63
19	G 1/4 - 3/8		XB1010D22_19W_AC	10	10	4	22,06	76
19	G 1/4 - 3/8	VF	XB1010F22_19W_AC	10	10	6	22,06	76
14	G 1/2 - 7/8		XB1212D20_14W_AC	12	12	4	20,86	83
14	G 1/2 - 7/8	VF	XB1212G20_14W_AC	12	12	7	20,86	83
14	G 1/2 - 7/8		XB1212D28_14W_AC	12	12	4	28,12	83
14	G 1/2 - 7/8		XB1616E28_14W_AC	16	16	5	28,12	89
14	G 1/2 - 7/8	VF	XB1616G28_14W_AC	16	16	7	28,12	89
11	G 1 - 1 1/2		XB1212C26_11W_AC	12	12	3	26,55	83
11	G 1 - 1 1/2	VF	XB1212E26_11W_AC	12	12	5	26,55	83
11	G 1 - 3	VF	XB1616D40_11W_AC	16	16	4	40,41	100
11	G ≥ 1	VF	XB2020E49_11W_AC	20	20	5	49,65	120

R/Rc

BSPT PIPE THREAD

Pitch TPI	Standard	Vib. free	INTERNAL / EXTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
28	Rc 1/16 - 1/8		XB0606C10_28BSPT_AC	6	6	3	10,43	63
28	Rc 1/8		XB0808D14_28BSPT_AC	8	8	4	14,06	63
19	Rc 1/4 - 3/8		XB0808C15_19BSPT_AC	8	8	3	15,37	63
19	Rc 1/4 - 3/8		XB1010D22_19BSPT_AC	10	10	4	22,06	76
14	Rc 1/2 - 7/8		XB1212D20_14BSPT_AC	12	12	4	20,86	83
11	Rc 1 - 2		XB1616D31_11BSPT_AC	16	16	4	31,17	89

PG

STEEL CONDUIT THREAD DIN 40430

Pitch TPI	Standard	Vib. free	INTERNAL / EXTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
20	Pg 7		XB0808C21_20PG_AC	8	8	3	20,96	63
18	Pg 9 - 16		XB1010C27_18PG_AC	10	10	3	27,52	76
16	Pg 21 - 48	VF	XB1212D31_16PG_AC	12	12	4	30,96	83

VF = Vibration-Free if you use the entire cutting length, [see page 6](#).W
(straight)BSPT
(tapered)

1°47'

How to know if I need W or BSPT?

Whitworth is a profile that is mainly used for pipe threads. When it is a straight thread it is W and when it is tapered BSPT.

G thread → W
 Rp thread → W
 Rc thread → BSPT
 R thread → BSPT

For more
 information
[see page 128.](#)

ThreadBurr for Internal Threading

AC

TiAlCN coated, Micrograin Carbide

Tolerance

The theoretical external diameter of the cutter is laser marked on the tool.

Shank

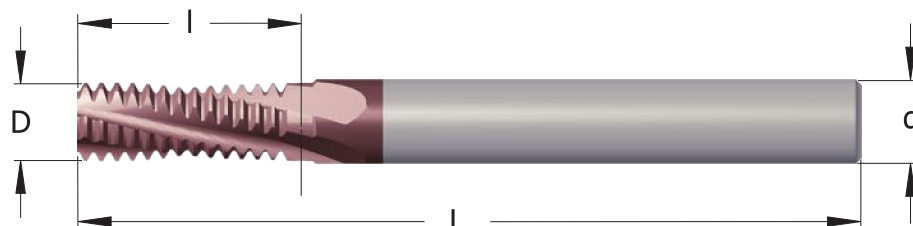
Cylindrical h6, DIN6535 HA

Flute

Between 12° and 18°

Field of application

Thread Milling of all types of steel

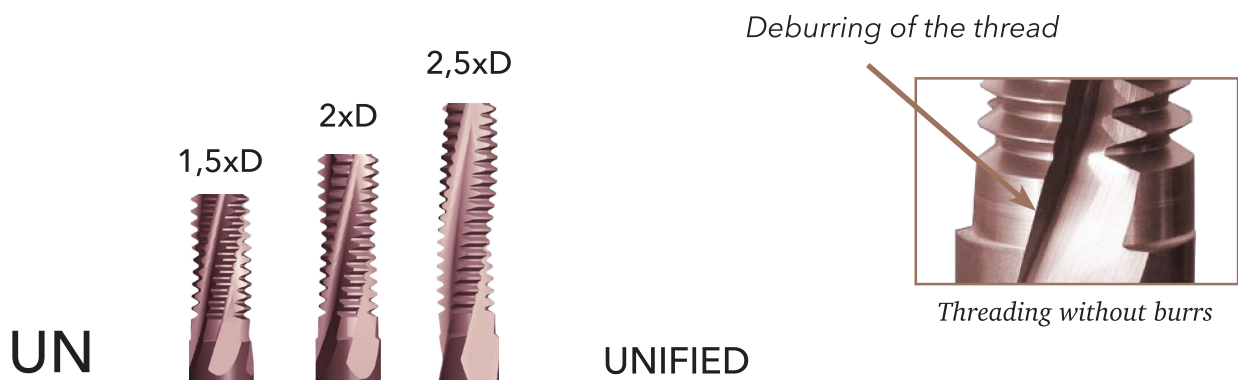


UN

UNIFIED

Pitch TPI	UNC	UNF	Vib. free	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
64		No. 2 (1,5xD)		NB04017C3_64UN_AC	4	1,7	3	3,77	50
64		No. 2 (2xD)		NB04017C5_64UN_AC	4	1,7	3	4,96	50
56	No. 2 (1,5xD)			NB04016C3_56UN_AC	4	1,6	3	3,86	50
56	No. 2 (2xD)		VF	NB04016C5_56UN_AC	4	1,6	3	5,22	50
56		No. 3 (1,5xD)		NB04019C4_56UN_AC	4	1,9	3	4,31	50
56		No. 3 (2xD)		NB04019C5_56UN_AC	4	1,9	3	5,67	50
48	No. 3 (1,5xD)			NB04019C4_48UN_AC	4	1,9	3	4,5	50
48	No. 3 (2xD)			NB04019C5_48UN_AC	4	1,9	3	5,56	50
48		No. 4 (1,5xD)		NB04021C5_48UN_AC	4	2,1	3	5,03	50
48		No. 4 (2xD)		NB04021C6_48UN_AC	4	2,1	3	6,61	50
44		No.5 (1,5xD)		NB04024C5_44UN_AC	4	2,4	3	5,48	50
44		No.5 (2xD)		NB04024C7_44UN_AC	4	2,4	3	7,22	50
40	No. 4 (1,5xD)			NB04021C5_40UN_AC	4	2,1	3	5,4	50
40	No. 4 (2xD)			NB04021C6_40UN_AC	4	2,1	3	6,67	50
40	No.5 (1,5xD)			NB04023C5_40UN_AC	4	2,3	3	5,4	50
40	No.5 (2xD)			NB04023C7_40UN_AC	4	2,3	3	7,3	50
40	No.5 (2,5xD)		VF	NB04023C8_40UN_AC	4	2,3	3	8,57	50
40		No.6 (1,5xD)		NB04026C6_40UN_AC	4	2,6	3	6,03	50
40		No.6 (2xD)		NB04026C8_40UN_AC	4	2,6	3	7,94	50
36		No.8 (1,5xD)		NB04031C7_36UN_AC	4	3,1	3	7,41	50
36		No.8 (2xD)		NB04031C9_36UN_AC	4	3,1	3	9,53	50
32	No.6 (1,5xD)			NB04025C6_32UN_AC	4	2,5	3	6,75	50
32	No.6 (2xD)		VF	NB04025C8_32UN_AC	4	2,5	3	8,33	50
32	No.6 (2,5xD)		VF	NB04025C10_32UN_AC	4	2,5	3	9,92	50
32	No.8 (1,5xD)			NB0403C7_32UN_AC	4	3	3	7,54	50
32	No.8 (2xD)			NB0403C9_32UN_AC	4	3	3	9,13	50
32	No.8 (2,5xD)		VF	NB0403C11_32UN_AC	4	3	3	11,51	50
32		No.10 (1,5xD)		NB04036C8_32UN_AC	4	3,6	3	8,33	50
32		No.10 (2xD)		NB04036C10_32UN_AC	4	3,6	3	10,72	50
32				NB0606D13_32UN_AC	6	6	4	13,1	63
28		No.12 (1,5xD)		NB0404C9_28UN_AC	4	4	3	9,52	50
28		No.12 (2xD)		NB0404C12_28UN_AC	4	4	3	12,25	50
28		1/4 (1,5xD)		NB0605C10_28UN_AC	6	5	3	10,43	63
28		1/4 (2xD)		NB0605C14_28UN_AC	6	5	3	14,06	63
28				NB0808D17_28UN_AC	8	8	4	17,69	63
24	No.10 (1,5xD)			NB04036C9_24UN_AC	4	3,6	3	9	50
24	No.10 (2xD)			NB04036C11_24UN_AC	4	3,6	3	11,11	50
24	No.10 (2,5xD)		VF	NB04036C13_24UN_AC	4	3,6	3	13,23	50
24	No.12 (1,5xD)			NB0404C10_24UN_AC	4	4	3	10,05	50
24	No.12 (2xD)			NB0404C12_24UN_AC	4	4	3	12,17	50
24	No.12 (2,5xD)		VF	NB0404C15_24UN_AC	4	4	3	15,35	50
24		5/16 (1,5xD)		NB0606C13_24UN_AC	6	6	3	13,23	63
24		5/16 (2xD)		NB0606C17_24UN_AC	6	6	3	17,46	63
24		3/8 (1,5xD)		NB08076C15_24UN_AC	8	7,6	3	15,35	63
24		3/8 (2xD)		NB08076C20_24UN_AC	8	7,6	3	20,64	76
20	1/4 (1,5xD)			NB06045C10_20UN_AC	6	4,5	3	10,8	63
20	1/4 (2xD)		VF	NB06045C14_20UN_AC	6	4,5	3	14,6	63
20	1/4 (2,5xD)		VF	NB06045C17_20UN_AC	6	4,5	3	17,15	63

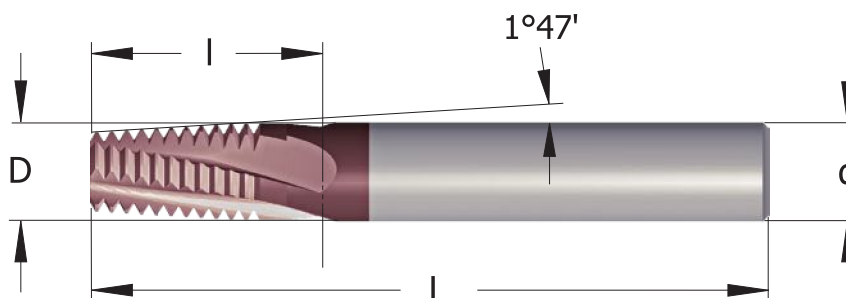
VF = Vibration-Free if you use the entire cutting length, [see page 6](#).



Pitch TPI	UNC	UNF	Vib. free	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
20		7/16 (1,5xD)		NB0808C18_20UN_AC	8	8	3	18,41	63
20		7/16 (2xD)		NB0808C23_20UN_AC	8	8	3	23,5	76
20		1/2 (1,5xD)		NB1010D21_20UN_AC	10	10	4	20,96	76
20		1/2 (2xD)	VF	NB1010D27_20UN_AC	10	10	4	27,31	76
20			VF	NB1212E28_20UN_AC	12	12	5	28,57	83
18	5/16 (1,5xD)			NB06058C13_18UN_AC	6	5,8	3	13,41	63
18	5/16 (2xD)			NB06058C17_18UN_AC	6	5,8	3	17,64	63
18	5/16 (2,5xD)		VF	NB06058C21_18UN_AC	6	5,8	3	21,87	63
18		9/16 (1,5xD)		NB1010D23_18UN_AC	10	10	4	23,28	76
18		9/16 (2xD)	VF	NB1010D30_18UN_AC	10	10	4	30,34	100
18		5/8 (1,5xD)		NB1212D26_18UN_AC	12	12	4	26,11	83
18		5/8 (2xD)	VF	NB1212D33_18UN_AC	12	12	4	33,16	100
16	3/8 (1,5xD)			NB0606C16_16UN_AC	6	6	3	16,67	63
16	3/8 (2xD)		VF	NB0606C21_16UN_AC	6	6	3	21,43	63
16	3/8 (2,5xD)		VF	NB0807C26_16UN_AC	8	7	3	26,19	76
16		3/4 (1,5xD)	VF	NB1212D31_16UN_AC	12	12	4	30,96	100
16		3/4 (2xD)	VF	NB1212D40_16UN_AC	12	12	4	40,48	100
16			VF	NB1616E35_16UN_AC	16	16	5	35,72	100
14	7/16 (1,5xD)			NB0808C19_14UN_AC	8	8	3	19,05	63
14	7/16 (2xD)			NB0808C24_14UN_AC	8	8	3	24,49	76
14	7/16 (2,5xD)		VF	NB0808C30_14UN_AC	8	8	3	29,94	76
14		7/8 (1,5xD)	VF	NB1616E35_14UN_AC	16	16	5	35,38	100
14		7/8 (2xD)	VF	NB1616E46_14UN_AC	16	16	5	46,26	120
13	1/2 (1,5xD)			NB0808C22_13UN_AC	8	8	3	22,47	76
13	1/2 (2xD)		VF	NB0808C28_13UN_AC	8	8	3	28,33	76
13	1/2 (2,5xD)		VF	NB10093C34_13UN_AC	10	9,3	3	34,19	100
12	9/16 (1,5xD)			NB1010C24_12UN_AC	10	10	3	24,34	76
12	9/16 (2xD)			NB1010C30_12UN_AC	10	10	3	30,69	100
12			VF	NB1616E43_12UN_AC	16	16	5	43,39	100
11	5/8 (1,5xD)			NB1010C26_11UN_AC	10	10	3	26,55	76
11	5/8 (2xD)		VF	NB1010C35_11UN_AC	10	10	3	35,79	100
11	5/8 (2,5xD)		VF	NB12117C42_11UN_AC	12	11,7	3	42,72	100
10	3/4 (1,5xD)			NB1212C31_10UN_AC	12	12	3	31,75	100
10	3/4 (2xD)		VF	NB1212C41_10UN_AC	12	12	3	41,91	100
9	7/8 (1,5xD)			NB1616C38_9UN_AC	16	16	3	38,1	100
9	7/8 (2xD)			NB1616C49_9UN_AC	16	16	3	49,39	120
8	1 (1,5xD)			NB1616C42_8UN_AC	16	16	3	42,86	100
8	1 (2xD)		VF	NB1616C55_8UN_AC	16	16	3	55,56	120
8			VF	NB2020D49_8UN_AC	20	20	4	49,21	120
7	1 1/8 - 1 1/4 (1,5xD)			NB2020C52_7UN_AC	20	20	3	52,61	120
6	1 3/8 - 1 1/2 (1,5xD)			NB2525C61_6UN_AC	25	25	3	61,38	130

ThreadBurr

AC
TiAlCN coated, Micrograin Carbide
Tolerance
D 6,0 - 12,0 +0 / -0,030
D 16,0 - 20,0 +0 / -0,050
Shank
Cylindrical h6, DIN6535 HA
Flute
Between 12° and 18°
Field of application
Thread Milling of all types of steel



NPT

NPT PIPE THREAD

Pitch TPI	Standard	Vib. free	INTERNAL / EXTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
27	1/16 - 1/8		XB0606C10_27NPT_AC	6	6	3	10,82	63
27	1/16 - 1/8	VF	XB0606F10_27NPT_AC	6	6	6	10,82	63
18	1/4 - 3/8		XB0808C16_18NPT_AC	8	8	3	16,23	63
18	1/4 - 3/8	VF	XB0808F16_18NPT_AC	8	8	6	16,23	63
18	1/4 - 3/8		XB1010D16_18NPT_AC	10	10	4	16,23	76
14	1/2 - 3/4		XB1212D22_14NPT_AC	12	12	4	22,68	83
14	1/2 - 3/4	VF	XB1212F22_14NPT_AC	12	12	6	22,68	83
14	3/4		XB1616E22_14NPT_AC	16	16	5	22,68	89
11,5	1 - 2		XB1616D29_11.5NPT_AC	16	16	4	29,82	89
11,5	1 - 2	VF	XB1616F29_11.5NPT_AC	16	16	6	29,82	89
8	≥ 2 1/2		XB2020D42_8NPT_AC	20	20	4	42,86	100

NPTF

NPTF DRYSEAL PIPE THREAD

Pitch TPI	Standard	Vib. free	INTERNAL / EXTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
27	1/16 - 1/8		XB0606C10_27NPTF_AC	6	6	3	10,82	63
18	1/4 - 3/8		XB0808C16_18NPTF_AC	8	8	3	16,23	63
14	1/2 - 3/4		XB1212D22_14NPTF_AC	12	12	4	22,68	83
11,5	1 - 2		XB1616D29_11.5NPTF_AC	16	16	4	29,82	89
8	≥ 2 1/2		XB2020D42_8NPTF_AC	20	20	4	42,86	100

NPSF

NPSF PIPE THREAD

Pitch TPI	Standard	Vib. free	INTERNAL / EXTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
27	1/16 - 1/8		XB0606C12_27NPSF_AC	6	6	3	12,70	63
18	1/4 - 3/8		XB0808C16_18NPSF_AC	8	8	3	16,23	63
14	1/2 - 3/4		XB1212D22_14NPSF_AC	12	12	4	22,68	83
11,5	1		XB1616D29_11.5NPSF_AC	16	16	4	29,82	89

VF = Vibration-Free if you use the entire cutting length, [see page 6](#).

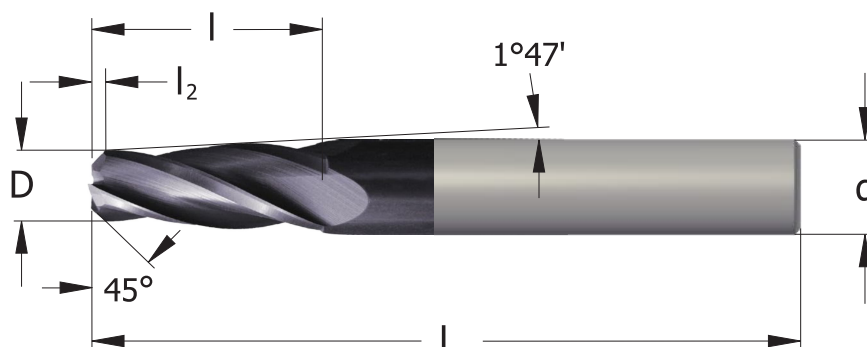
What is the difference between NPT, NPTF and NPSF?

NPT and NPTF are tapered threads. NPSF is a straight thread. Leakage can occur on NPT threads which means that a thread seal tape or other thread sealant has to be used to get a leak-free thread.

To solve the problem of leakage, NPTF has been developed. This thread create full contact between the external and internal thread and will make a press fit. No other product for sealing is needed.

Another variation of dryseal is NPSF which is used for internal threads and is made to fit an external NPTF thread.

FC
 TiAlN coated, Micrograin Carbide
Tolerance
 D 5,0 - 17,0 +0 / -0,050
Shank
 Cylindrical h6, DIN6535 HA
Flute
 30° right hand spiral
Field of application
 Before Thread Milling of
 NPT/NPTF/BSPT



D mm	d mm	Part Number	Z flutes	l mm	l ₂ mm	L mm
5	6	NPT0605D16_FC	4	16	1,0	63
8,5	10	NPT10085D24_FC	4	24	1,5	76
14	16	NPT1614D32_FC	4	32	2	89
17	20	NPT2017D48_FC	4	48	3	120

Do I need to premill a tapered hole before threading?

It is not necessary, but we strongly recommend it as there are two major advantages of premilling a tapered hole before threading.

1. Longer tool life of the thread mill.
2. Shorter machining time.

Without premilling you have to make the thread in one or two extra passes and reduce the feed, otherwise you will destroy the tool as the crest is very small on NPT and NPTF threads.

Chamfering of the thread

*Premilling of conical holes
result in longer tool life and
shorter machining time*



ThreadBurr with Internal Axial Coolant

AC

TiAlCN coated, Micrograin Carbide

Tolerance

The theoretical external diameter of the cutter is laser marked on the tool.

Shank

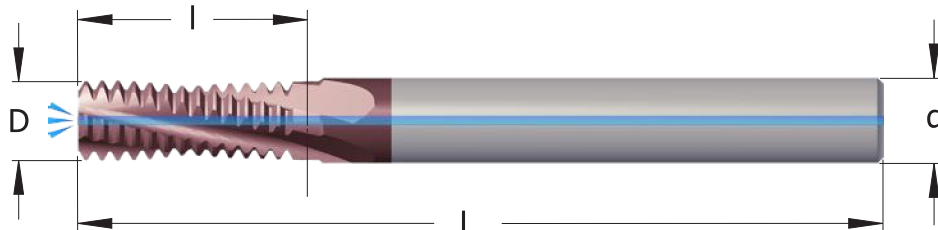
Cylindrical h6, DIN6535 HA

Flute

Between 12° and 18°

Field of application

Thread Milling of all types of steel



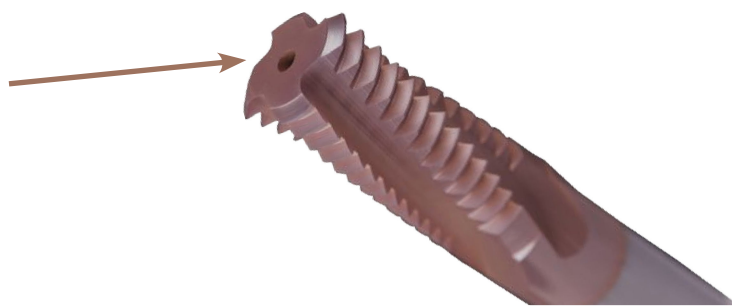
M

METRIC

Pitch mm	M coarse	M fine	Vib. free	INTERNAL Part Number	d mm	D mm	Z flutes	I mm	L mm
0,8	M5 (1,5xD)			NBK04038C8_0.8ISO_AC	4	3,8	3	8,4	50
0,8	M5 (2xD)			NBK04038C10_0.8ISO_AC	4	3,8	3	10,8	50
0,8	M5 (2,5xD)		VF	NBK04038C13_0.8ISO_AC	4	3,8	3	13,2	50
1,0	M6 (1,5xD)	≥ M8		NBK06045C10_1.0ISO_AC	6	4,5	3	10,5	63
1,0	M6 (2xD)	≥ M8		NBK06045C13_1.0ISO_AC	6	4,5	3	13,5	63
1,0	M6 (2,5xD)	≥ M8	VF	NBK06045C16_1.0ISO_AC	6	4,5	3	16,5	63
1,0		≥ M10		NBK0808D17_1.0ISO_AC	8	8	4	17,5	76
1,25	M8 (1,5xD)	≥ M10		NBK0606C14_1.25ISO_AC	6	6	3	14,37	63
1,25	M8 (2xD)	≥ M10		NBK0606C18_1.25ISO_AC	6	6	3	18,12	63
1,25	M8 (2,5xD)	≥ M10	VF	NBK0606C21_1.25ISO_AC	6	6	3	21,87	63
1,5	M10 (1,5xD)	≥ M12		NBK08075C17_1.5ISO_AC	8	7,5	3	17,25	76
1,5	M10 (2xD)	≥ M12		NBK08075C21_1.5ISO_AC	8	7,5	3	21,75	76
1,5	M10 (2,5xD)	≥ M12	VF	NBK08075C27_1.5ISO_AC	8	7,5	3	27,75	76
1,5	M10 (3xD)	≥ M12	VF	NBK08075C32_1.5ISO_AC	8	7,5	3	32,25	76
1,5		≥ M16	VF	NBK1212E29_1.5ISO_AC	12	12	5	29,25	100
1,5		≥ M20	VF	NBK1616F35_1.5ISO_AC	16	16	6	35,25	120
1,75	M12 (1,5xD)			NBK0808C20_1.75ISO_AC	8	8	3	20,12	76
1,75	M12 (2xD)		VF	NBK0808C27_1.75ISO_AC	8	8	3	27,12	76
1,75	M12 (1,5xD)			NBK1009C20_1.75ISO_AC	10	9	3	20,12	100
1,75	M12 (2xD)			NBK1009C27_1.75ISO_AC	10	9	3	27,12	100
1,75	M12 (2,5xD)		VF	NBK1009C32_1.75ISO_AC	10	9	3	32,37	100
1,75	M12 (3xD)		VF	NBK1009C37_1.75ISO_AC	10	9	3	37,62	100
2,0	M14 (1,5xD)	≥ M18		NBK1010C23_2.0ISO_AC	10	10	3	23	100
2,0	M14 (2xD)	≥ M18		NBK1010C31_2.0ISO_AC	10	10	3	31	100
2,0	M16 (1,5xD)	≥ M18		NBK1212D27_2.0ISO_AC	12	12	4	27	100
2,0	M16 (2xD)	≥ M18	VF	NBK1212D35_2.0ISO_AC	12	12	4	35	100
2,0	M16 (2,5xD)	≥ M18	VF	NBK1212D43_2.0ISO_AC	12	12	4	43	100
2,0	M16 (3xD)	≥ M18	VF	NBK1212C51_2.0ISO_AC	12	12	3	51	100
2,0		≥ M20	VF	NBK1616E39_2.0ISO_AC	16	16	5	39	120
2,5	M20 (1,5xD)			NBK1414D33_2.5ISO_AC	14	14	4	33,75	100
2,5	M20 (2xD)		VF	NBK1414D43_2.5ISO_AC	14	14	4	43,75	100
2,5	M20 (2,5xD)		VF	NBK1615D53_2.5ISO_AC	16	15	4	53,75	120
3,0	M24 (1,5xD)	≥ M30		NBK1616C40_3.0ISO_AC	16	16	3	40,5	120
3,0	M24 (2xD)	≥ M30	VF	NBK1616C52_3.0ISO_AC	16	16	3	52,5	120
3,5	M30 (1,5xD)			NBK2020C50_3.5ISO_AC	20	20	3	50,75	150
3,5	M30 (2xD)		VF	NBK2020C64_3.5ISO_AC	20	20	3	64,75	150

VF = Vibration-Free if you use the entire cutting length, [see page 6](#).

Internal Axial Coolant
is most suitable for
blind holes



AC

TiAlCN coated, Micrograin Carbide

Tolerance

The theoretical external diameter of the cutter is laser marked on the tool.

Shank

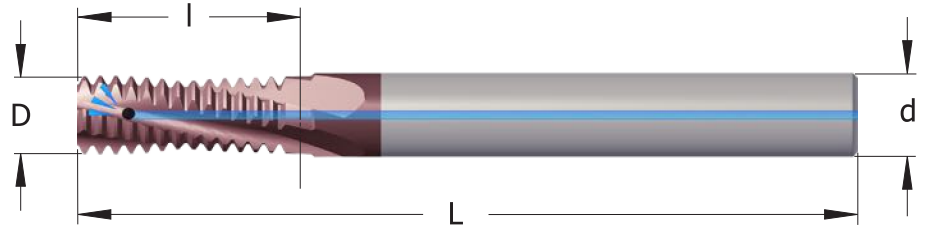
Cylindrical h6, DIN6535 HA

Flute

Between 12° and 18°

Field of application

Thread Milling of all types of steel

**M****METRIC**

Pitch mm	M coarse	M fine	Vib. free	INTERNAL Part Number	d mm	D mm	Z flutes	I mm	L mm
1,0		≥ M10		NBT0808D17_1.0ISO_AC	8	8	4	17,5	76
1,25	M8 (2xD)	≥ M10		NBT0606C18_1.25ISO_AC	6	6	3	18,12	76
1,5	M10 (2xD)	≥ M12		NBT08075C21_1.5ISO_AC	8	7,5	3	21,75	76
1,5		≥ M16	VF	NBT1212E29_1.5ISO_AC	12	12	5	29,25	100
1,75	M12 (2xD)		VF	NBT0808C27_1.75ISO_AC	8	8	3	27,12	76
1,75	M12 (2xD)			NBT1009C27_1.75ISO_AC	10	9	3	27,12	100
2,0	M14 (2xD)	≥ M18		NBT1010C31_2.0ISO_AC	10	10	3	31	100
2,0	M16 (2xD)	≥ M18	VF	NBT1212D35_2.0ISO_AC	12	12	4	35	100
2,0		≥ M20	VF	NBT1616E39_2.0ISO_AC	16	16	5	39	100

G/Rp**WHITWORTH PIPE THREAD**

Pitch TPI	Standard	Vib. free	INTERNAL / EXTERNAL Part Number	d mm	D mm	Z flutes	I mm	L mm
28	G 1/16 - 1/8		XBT0606C10_28W_AC	6	6	3	10,43	76
19	G 1/4 - 3/8		XBT1010D22_19W_AC	10	10	4	22,06	100
14	G 1/2 - 7/8		XBT1212D28_14W_AC	12	12	4	28,12	100
11	G 1 - 3	VF	XBT1616D40_11W_AC	16	16	4	40,41	100

VF = Vibration-Free if you use the entire cutting length, [see page 6](#).

Internal Radial Coolant
is most suitable for
through holes

Is it necessary to use a tool with Internal Coolant?

Most people use tools without Coolant as the price is lower and it is possible to use external Coolant with these tools. The carbide is solid to the center of the tool, making it a stronger tool with less risk for breakage.

In some cases when you have problems with chips you may want to use a tool with Internal Coolant as these tools get the Coolant where you exactly want it and with higher pressure.

- Internal Axial Coolant (NBK) is most suitable for blind holes.
- Internal Radial Coolant (NBT) is most suitable for through holes.



SOLID CARBIDE THREAD MILLS

with One Tooth, partial profile

AC / LC

TiAlCN / AlCrN coated
Micrograin Carbide

Tolerance

D 0,3 - 6,0 +0 / -0,020

D 7,0 - 12,0 +0 / -0,030

Shank

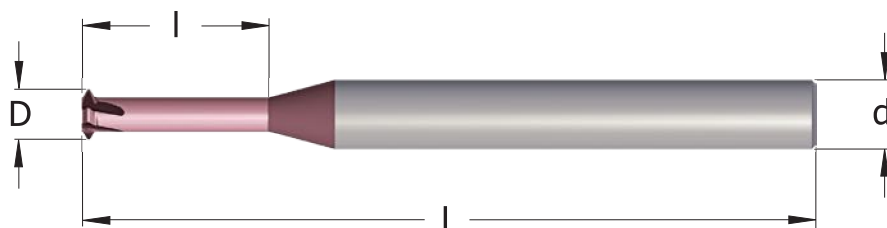
Cylindrical h6, DIN6535 HA

Flute

15° right hand spiral

Field of application

Thread Milling of all types of steel



60°

PARTIAL PROFILE 60°

M coarse	M pitch mm	UNC	UNF	UN pitch TPI	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
M0,5 (2xD)	0,125		No. 0000	160	NS03003C1.3_P60_LC	3	0,37	3	1,3	39
M0,6 (2xD)	0,15				NS03004C1.5_P60_LC	3	0,44	3	1,5	39
M0,8 (2xD)	0,2		No. 000	120	NS03005C2.0_P60_LC	3	0,58	3	2	39
M0,8 (3xD)	0,2		No. 000	120	NS03005C2.7_P60_LC	3	0,58	3	2,7	39
M1 (2xD)	0,2 - 0,25				NS03007C2.5_P60_LC	3	0,72	3	2,5	39
M1 (3xD)	0,2 - 0,25				NS03007C3.2_P60_LC	3	0,72	3	3,2	39
M1,2 (2xD)	0,2 - 0,25		No. 00	95	NS03009C2.9_P60_LC	3	0,92	3	2,9	39
M1,2 (3xD)	0,2 - 0,25		No. 00	95	NS03009C3.9_P60_LC	3	0,92	3	3,9	39
M1,4 (2xD)	0,2 - 0,3				NS03010C3.3_P60_LC	3	1,06	3	3,3	39
M1,4 (3xD)	0,2 - 0,3				NS03010C4.4_P60_LC	3	1,06	3	4,4	39
M1,6 (2xD)	0,2 - 0,35		No. 0	80	NS03012D3.6_P60_LC	3	1,2	4	3,6	39
M1,6 (3xD)	0,2 - 0,35		No. 0	80	NS03012D5.1_P60_LC	3	1,2	4	5,1	39
M1,8 (2xD)	0,35 - 0,4	No. 1	No. 1	72 - 64	NS03014D4.2_P60_LC	3	1,4	4	4,2	39
M1,8 (3xD)	0,35 - 0,4	No. 1	No. 1	72 - 64	NS03014D5.6_P60_LC	3	1,4	4	5,6	39
M2 (2xD)	0,4		No. 2	64	NS03015D4.6_P60_LC	3	1,55	4	4,6	39
M2 (3xD)	0,4		No. 2	64	NS03015D6.2_P60_LC	3	1,55	4	6,2	39
M2 (2xD)	0,35 - 0,4		No. 2	64	NS04015D4_P60_AC	4	1,5	4	4,4	50
M2 (3xD)	0,35 - 0,4		No. 2	64	NS04015D6_P60_AC	4	1,5	4	6,4	50
M2,2 (2xD)	0,45	No. 2		56	NS04016D5_P60_AC	4	1,65	4	5	50
M2,2 (3xD)	0,45	No. 2		56	NS04016D7_P60_AC	4	1,65	4	7,1	50
M2,5 (2xD)	0,45 - 0,5	No. 3	No. 3 - 4	56 - 48	NS04019D5_P60_AC	4	1,9	4	5,5	50
M2,5 (3xD)	0,45 - 0,5	No. 3	No. 3 - 4	56 - 48	NS04019D8_P60_AC	4	1,9	4	8	50
		No. 4		40	NS04021D6_P60_AC	4	2,1	4	6,4	50
		No. 4		40	NS04021D9_P60_AC	4	2,1	4	9,2	50
M3 (2xD)	0,5 - 0,6	No. 5	No. 5	44 - 40	NS04023D6_P60_AC	4	2,3	4	6,5	50
M3 (3xD)	0,5 - 0,6	No. 5	No. 5	44 - 40	NS04023D9_P60_AC	4	2,3	4	9,5	50
M3,5 (2xD)	0,5 - 0,75	No. 6	No. 6	40 - 32	NS04026D7_P60_AC	4	2,6	4	7,6	50
M3,5 (3xD)	0,5 - 0,75	No. 6	No. 6	40 - 32	NS04026D11_P60_AC	4	2,6	4	11,1	50
M4 (2xD)	0,7 - 0,75	No. 8	No. 8	36 - 32	NS0403D9_P60_AC	4	3	4	9	50
M4 (3xD)	0,7 - 0,75	No. 8	No. 8	36 - 32	NS0403D13_P60_AC	4	3	4	13	50
M4,5 (2xD)	0,75 - 1,0	No. 10	No. 10	32 - 24	NS04036D10_P60_AC	4	3,6	4	10	50
M4,5 (3xD)	0,75 - 1,0	No. 10	No. 10	32 - 24	NS04036D14_P60_AC	4	3,6	4	14,3	50
M5 (2xD)	0,75 - 1,0	No. 12	No. 12 - 1/4	32 - 24	NS0404D11_P60_AC	4	4	4	11	50
M5 (3xD)	0,75 - 1,0	No. 12	No. 12 - 1/4	32 - 24	NS0404D16_P60_AC	4	4	4	16	50
M6 (2xD)	1,0 - 1,25	1/4	5/16 - 3/8	24 - 20	NS06045D13_P60_AC	6	4,5	4	13	63
M6 (3xD)	1,0 - 1,25	1/4	5/16 - 3/8	24 - 20	NS06045D19_P60_AC	6	4,5	4	19	76
M8 (2xD)	1,25	5/16	7/16 - 1/2	20 - 18	NS0606E17_P60_AC	6	6	5	17,3	63
M8 (3xD)	1,25	5/16	7/16 - 1/2	20 - 18	NS0606E25_P60_AC	6	6	5	25,3	76
M10 (2xD)	1,5	3/8	9/16 - 3/4	18 - 16	NS08075E22_P60_AC	8	7,5	5	22	63
M10 (3xD)	1,5	3/8	9/16 - 3/4	18 - 16	NS08075E32_P60_AC	8	7,5	5	32	76
M12 (2xD)	1,75	7/16 - 1/2	7/8	14 - 13	NS1009E26_P60_AC	10	9	5	26	76
M12 (3xD)	1,75	7/16 - 1/2	7/8	14 - 13	NS1009E38_P60_AC	10	9	5	38	100
M14 (2xD)	2,0	9/16	≥ 1	12	NS1010E30_P60_AC	10	10	5	30	76
M14 (3xD)	2,0	9/16	≥ 1	12	NS1010E44_P60_AC	10	10	5	44	100
M16 (2xD)	2,0	5/8	≥ 1	12 - 11	NS1212F34_P60_AC	12	12	6	34	83
M16 (3xD)	2,0	5/8	≥ 1	12 - 11	NS1212F50_P60_AC	12	12	6	50	100

SOLID CARBIDE THREAD MILLS

with One Tooth, full profile



LC

AlCrN coated

Micrograin Carbide

Tolerance

D 0,3 - 6,0 +0 / -0,020

Shank

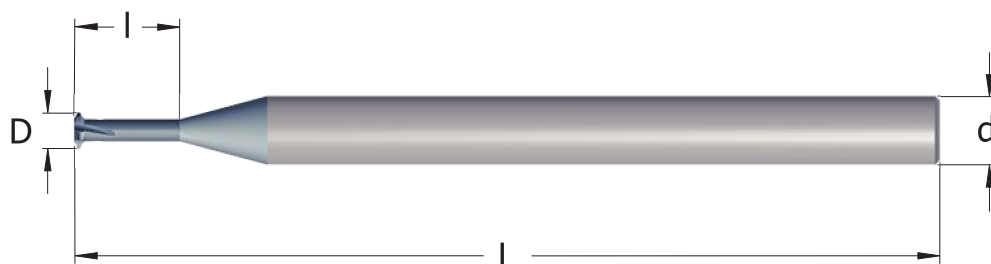
Cylindrical h6, DIN6535 HA

Flute

15° right hand spiral

Field of application

Thread Milling of all types of steel



M

METRIC

Pitch mm	M coarse	M fine	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
0,25	M1 (2xD)	≥ M1,4	NS03007C2_0.25ISO_LC	3	0,72	3	2,5	39
0,25	M1 (3xD)	≥ M1,4	NS03007C3_0.25ISO_LC	3	0,72	3	3,5	39
0,25	M1,2 (2xD)	≥ M1,4	NS03009C2_0.25ISO_LC	3	0,92	3	2,9	39
0,25	M1,2 (3xD)	≥ M1,4	NS03009C3_0.25ISO_LC	3	0,92	3	3,9	39
0,3	M1,4 (2xD)		NS03010C3_0.3ISO_LC	3	1,06	3	3,3	39
0,3	M1,4 (3xD)		NS03010C4_0.3ISO_LC	3	1,06	3	4,4	39
0,35	M1,6 (2xD)	≥ M2	NS03012D3_0.35ISO_LC	3	1,2	4	3,6	39
0,35	M1,6 (3xD)	≥ M2	NS03012D5_0.35ISO_LC	3	1,2	4	5,1	39
0,35	M1,8 (2xD)	≥ M2	NS03014D4_0.35ISO_LC	3	1,4	4	4,2	39
0,35	M1,8 (3xD)	≥ M2	NS03014D5_0.35ISO_LC	3	1,4	4	5,6	39
0,4	M2 (2xD)		NS03015D4_0.4ISO_LC	3	1,55	4	4,7	39
0,4	M2 (3xD)		NS03015D6_0.4ISO_LC	3	1,55	4	6,2	39

Partial Profile vs Full Profile

With a Partial Profile tool it is possible to do different pitches and profiles as the tool only has One Tooth and a profile that is designed to suite several threads.

Some producers make these tools with a very small crest and large profile height to be able to do as many different threads as possible. The disadvantage with this is that the crest will be fragile and the tool diameter small which result in short tool life and tool breakage. Because of this SmiCut produce the Partial Profile thread mills with a more limited area of use.

Full Profile tools will make a thread with higher quality and with these tools it is not so important to drill the exactly correct diameter before threading. Full Profile tools are recommended as first choice.

One Tooth vs Two Teeth

One Tooth has lower cutting forces and Two teeth has longer tool life.

One Tooth is mainly used for extremely small threads and when Two Teeth is not available, for example UN profiles. Two Teeth tools are recommended as first choice.



Thread Milling
from M0,5



with Two Teeth

AC

TiAlCN coated, Micrograin Carbide

Tolerance

The theoretical external diameter of the cutter is laser marked on the tool.

Shank

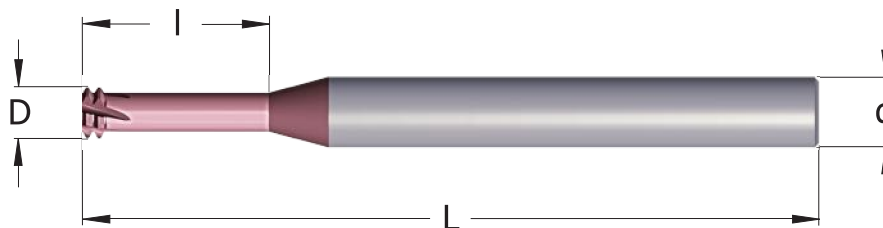
Cylindrical h6, DIN6535 HA

Flute

15° right hand spiral

Field of application

Thread Milling of all types of steel



M

METRIC

Pitch mm	M coarse	M fine	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
0,4	M2 (2xD)		NM04015D4_0.4ISO_AC	4	1,5	4	4,4	50
0,4	M2 (3xD)		NM04015D6_0.4ISO_AC	4	1,5	4	6,4	50
0,45	M2,2 (2xD)		NM04016D5_0.45ISO_AC	4	1,65	4	5,0	50
0,45	M2,2 (3xD)		NM04016D7_0.45ISO_AC	4	1,65	4	7,1	50
0,45	M2,5 (2xD)		NM04019D5_0.45ISO_AC	4	1,9	4	5,5	50
0,45	M2,5 (3xD)		NM04019D8_0.45ISO_AC	4	1,9	4	8	50
0,5	M3 (2xD)	≥ M3,5	NM04023E6_0.5ISO_AC	4	2,3	5	6,5	50
0,5	M3 (3xD)	≥ M3,5	NM04023E9_0.5ISO_AC	4	2,3	5	9,5	50
0,6	M3,5 (2xD)		NM04026E7_0.6ISO_AC	4	2,6	5	7,6	50
0,6	M3,5 (3xD)		NM04026E11_0.6ISO_AC	4	2,6	5	11,1	50
0,7	M4 (2xD)		NM0403E9_0.7ISO_AC	4	3	5	9	50
0,7	M4 (3xD)		NM0403E13_0.7ISO_AC	4	3	5	13	50
0,75	M4,5 (2xD)	≥ M5	NM04034E10_0.75ISO_AC	4	3,4	5	10	50
0,75	M4,5 (3xD)	≥ M5	NM04034E14_0.75ISO_AC	4	3,4	5	14,3	50
0,8	M5 (2xD)		NM04038E11_0.8ISO_AC	4	3,8	5	11	50
0,8	M5 (3xD)		NM04038E16_0.8ISO_AC	4	3,8	5	16	50
1,0	M6 (2xD)	≥ M8	NM06045E13_1.0ISO_AC	6	4,5	5	13	63
1,0	M6 (3xD)	≥ M8	NM06045E19_1.0ISO_AC	6	4,5	5	19	76
1,25	M8 (2xD)	≥ M10	NM0606E17_1.25ISO_AC	6	6	5	17,3	63
1,25	M8 (3xD)	≥ M10	NM0606E25_1.25ISO_AC	6	6	5	25,3	76
1,5	M10 (2xD)	≥ M12	NM08075E22_1.5ISO_AC	8	7,5	5	22	63
1,5	M10 (3xD)	≥ M12	NM08075E32_1.5ISO_AC	8	7,5	5	32	76
1,75	M12 (2xD)		NM1009E26_1.75ISO_AC	10	9	5	26	76
1,75	M12 (3xD)		NM1009E38_1.75ISO_AC	10	9	5	38	100
2,0	M14 (2xD)	≥ M18	NM1010E30_2.0ISO_AC	10	10	5	30	76
2,0	M14 (3xD)	≥ M18	NM1010E44_2.0ISO_AC	10	10	5	44	100
2,0	M16 (2xD)	≥ M18	NM1212F34_2.0ISO_AC	12	12	6	34	83
2,0	M16 (3xD)	≥ M18	NM1212F50_2.0ISO_AC	12	12	6	50	100

When should I use Two Teeth Thread Mills?

The first choice for thread milling is always ThreadBurr, NB-tools. They have the full thread length and deburr the entrance of the thread in the same operation.

In some cases when it is difficult to achieve good results, the NM-tools with Two Teeth can be a solution as the cutting forces are lower. For example, long threads and materials that are difficult to machine.

With NM-tools you make several passes axially instead of one, even so the machining time will not be so much longer as you can increase the feed and the tool has more flutes than the NB-tools.

Available from
Ø1,5 to Ø12 mm



AC

TiAlCN coated, Micrograin Carbide

Tolerance

The theoretical external diameter of the cutter is laser marked on the tool.

Shank

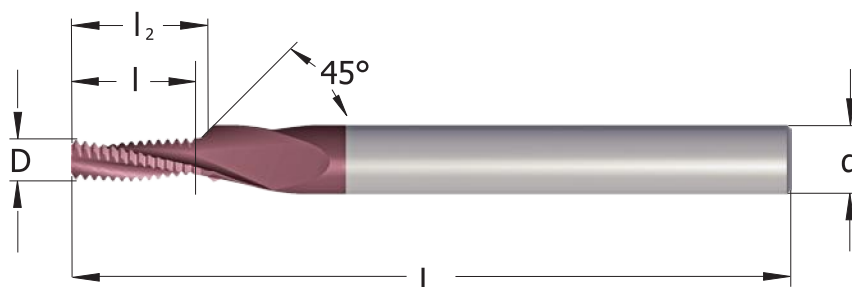
Cylindrical h6, DIN6535 HA

Flute

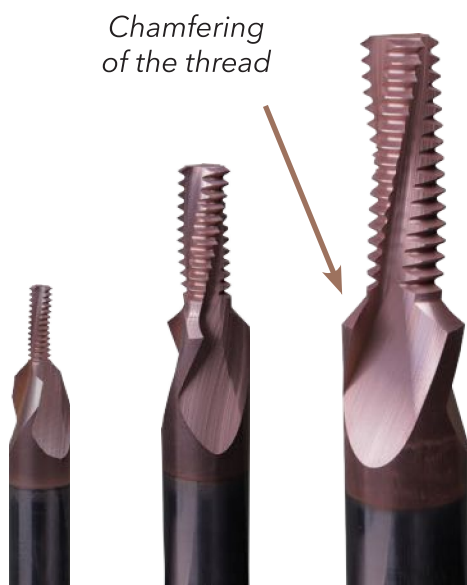
Between 12° and 18°

Field of application

Thread Milling of all types of steel

**M****METRIC**

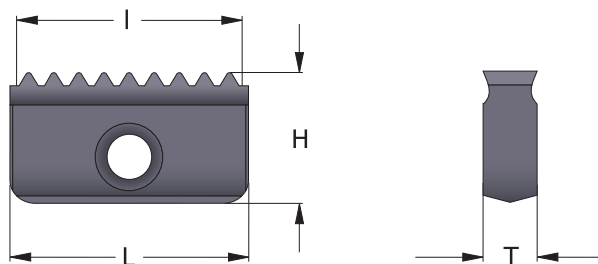
Pitch mm	M coarse	Vib. free	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	l ₂ mm	L mm
0,5	M3 (1,5xD)		NF06023C5_0.5ISO_AC	6	2,3	3	5,25	5,85	63
0,5	M3 (2xD)		NF06023C6_0.5ISO_AC	6	2,3	3	6,75	7,35	63
0,5	M3 (2,5xD)	VF	NF06023C8_0.5ISO_AC	6	2,3	3	8,25	8,85	63
0,5	M3 (3xD)	VF	NF06023C9_0.5ISO_AC	6	2,3	3	9,75	10,35	63
0,7	M4 (1,5xD)		NF0603C7_0.7ISO_AC	6	3	3	7,35	8,2	63
0,7	M4 (2xD)		NF0603C8_0.7ISO_AC	6	3	3	8,75	9,6	63
0,7	M4 (2,5xD)	VF	NF0603C10_0.7ISO_AC	6	3	3	10,85	11,7	63
0,7	M4 (3xD)	VF	NF0603C12_0.7ISO_AC	6	3	3	12,95	13,8	63
0,8	M5 (1,5xD)		NF06038C8_0.8ISO_AC	6	3,8	3	8,4	9,4	63
0,8	M5 (2xD)		NF06038C10_0.8ISO_AC	6	3,8	3	10,8	11,8	63
0,8	M5 (2,5xD)	VF	NF06038C13_0.8ISO_AC	6	3,8	3	13,2	14,2	63
0,8	M5 (3xD)	VF	NF06038C16_0.8ISO_AC	6	3,8	3	16,4	17,4	63
1,0	M6 (1,5xD)		NF08045C10_1.0ISO_AC	8	4,5	3	10,5	11,75	63
1,0	M6 (2xD)		NF08045C13_1.0ISO_AC	8	4,5	3	13,5	14,75	63
1,0	M6 (2,5xD)	VF	NF08045C16_1.0ISO_AC	8	4,5	3	16,5	17,75	63
1,25	M8 (1,5xD)		NF1006C14_1.25ISO_AC	10	6	3	14,37	16	76
1,25	M8 (2xD)		NF1006C18_1.25ISO_AC	10	6	3	18,12	19,75	76
1,25	M8 (2,5xD)	VF	NF1006C21_1.25ISO_AC	10	6	3	21,87	23,5	76
1,5	M10 (1,5xD)		NF12075C17_1.5ISO_AC	12	7,5	3	17,25	19,25	83
1,5	M10 (2xD)		NF12075C21_1.5ISO_AC	12	7,5	3	21,75	23,75	83
1,5	M10 (2,5xD)	VF	NF12075C27_1.5ISO_AC	12	7,5	3	27,75	29,75	83
1,75	M12 (1,5xD)		NF1409C20_1.75ISO_AC	14	9	3	20,12	22,5	89
1,75	M12 (2xD)		NF1409C27_1.75ISO_AC	14	9	3	27,12	29,5	89
1,75	M12 (2,5xD)	VF	NF1409C32_1.75ISO_AC	14	9	3	32,37	34,75	89

VF = Vibration-Free if you use the entire cutting length, [see page 6](#).**Do I have to chamfer the thread?**

The answer is yes if it is on the drawing and you do not have the authority to change it.

In practical terms, it is not necessary as the thread mills from SmiCut (ThreadBurr) deburr the entrance of the thread in the same operation as it is milling the thread.

First choice is, try to avoid the unnecessary chamfering operation. Second choice is, use NF-tools to make the chamfer and the thread with the same tool.



M

METRIC

Pitch mm	M coarse	M fine	INTERNAL Part Number	I mm	L mm	T mm	H mm	Cutting Edges
0,5		≥ M13	14I_0.5ISO_FC	14	14	3,1	7,5	2
1,0		≥ M14	14I_1.0ISO_FC	14	14	3,1	7,5	2
1,0		≥ M22	21I_1.0ISO_FC	21	21	4,7	12	2
1,5		≥ M16	14I_1.5ISO_FC	13,5	14	3,1	7,5	2
1,5		≥ M22	21I_1.5ISO_FC	21	21	4,7	12	2
1,5		≥ M33	30I_1.5ISO_FC	30	30	5,5	16	2
2,0	M16	≥ M18	14I_2.0ISO_FC	14	14	3,1	7,5	2
2,0		≥ M22	21I_2.0ISO_FC	20	21	4,7	12	2
2,0		≥ M33	30I_2.0ISO_FC	30	30	5,5	16	2
2,0		≥ M56	40I_2.0ISO_FC	40	40	6,3	20	2
2,5	M18-M22		14I_2.5ISO_FC	12,5	14	3,1	7,5	2
3,0	M24	≥ M30	21I_3.0ISO_FC	21	21	4,7	12	2
3,0		≥ M36	30I_3.0ISO_FC	30	30	5,5	16	2
3,0		≥ M56	40I_3.0ISO_FC	39	40	6,3	20	2
3,5	M30-M33		21I_3.5ISO_FC	21	21	4,7	12	2
4,0	M36-M39	≥ M42	30I_4.0ISO_FC	28	30	5,5	16	2
4,0		≥ M60	40I_4.0ISO_FC	40	40	6,3	20	2
4,5	M42-M45		30I_4.5ISO_FC	27	30	5,5	16	2
5,0	M48-M52		30I_5.0ISO_FC	30	30	5,5	16	2
5,5	M56-M60		30I_5.5ISO_FC	27,5	30	5,5	16	2
6,0	M64-M68	≥ M72	40I_6.0ISO_FC	36	40	6,3	20	2

G/Rp

WHITWORTH PIPE THREAD

Pitch TPI	Norm	INTERNAL / EXTERNAL Part Number	I mm	L mm	T mm	H mm	Cutting Edges
19	G 3/8	14X_19W_FC	13,37	14	3,1	7,5	2
14	G 1/2 - 5/8	14X_14W_FC	12,7	14	3,1	7,5	2
14	G 5/8 - 7/8	21X_14W_FC	19,96	21	4,7	12	2
11	G 1	14X_11W_FC	13,85	14	3,1	7,5	1
11	G 1	21X_11W_FC	20,78	21	4,7	12	2
11	G 1 1/8	30X_11W_FC	30,02	30	5,5	16	2
11	G ≥ 2	40X_11W_FC	39,25	40	6,3	20	2

R/Rc

BSPT PIPE THREAD

Pitch TPI	Norm	INTERNAL / EXTERNAL Part Number	I mm	L mm	T mm	H mm	Cutting Edges
19	Rc 3/8	14X_19BSPT_FC	13,37	14	3,1	7,5	1
14	Rc 1/2	14X_14BSPT_FC	12,7	14	3,1	7,5	1
14	Rc 3/4	21X_14BSPT_FC	19,96	21	4,7	12	1
11	Rc 1	21X_11BSPT_FC	20,78	21	4,7	12	1
11	Rc 1 1/8	30X_11BSPT_FC	30,02	30	5,5	16	1
11	Rc ≥ 2	40X_11BSPT_FC	39,25	40	6,3	20	1

PG

STEEL CONDUIT THREAD DIN 40430

Pitch TPI	Norm	INTERNAL / EXTERNAL Part Number	I mm	L mm	T mm	H mm	Cutting Edges
18	Pg 9 - 16	14X_18PG_FC	14,11	14	3,1	7,5	2
18	Pg 13,5 - 16	21X_18PG_FC	21	21	4,7	12	2
16	Pg 21 - 48	21X_16PG_FC	20,64	21	4,7	12	2
16	Pg 29 - 48	30X_16PG_FC	30	30	5,5	16	2

UN

UNIFIED

Pitch TPI	UNC	UNF	UNEF	INTERNAL Part Number	I mm	L mm	T mm	H mm	Cutting Edges
32				14I_32UN_FC	13,49	14	3,1	7,5	2
28				14I_28UN_FC	13,61	14	3,1	7,5	2
24			9/16 - 5/8	14I_24UN_FC	13,75	14	3,1	7,5	2
20			3/4 - 1	14I_20UN_FC	13,97	14	3,1	7,5	2
20			7/8 - 1	21I_20UN_FC	20,32	21	4,7	12	2
20				30I_20UN_FC	29,21	30	5,5	16	2
18		5/8	1 1/16 - 1 11/16	14I_18UN_FC	14,11	14	3,1	7,5	2
18			1 1/16 - 1 11/16	21I_18UN_FC	21,17	21	4,7	12	2
18			1 1/4 - 1 11/16	30I_18UN_FC	29,63	30	5,5	16	2
16		3/4		14I_16UN_FC	12,7	14	3,1	7,5	2
16				21I_16UN_FC	20,64	21	4,7	12	2
16				30I_16UN_FC	30,16	30	5,5	16	2
16				40I_16UN_FC	39,69	40	6,3	20	2
14		7/8		14I_14UN_FC	12,7	14	3,1	7,5	2
14		7/8		21I_14UN_FC	19,96	21	4,7	12	2
12		1-1 1/2		14I_12UN_FC	12,7	14	3,1	7,5	2
12		1-1 1/2		21I_12UN_FC	21,12	21	4,7	12	2
12		1 3/8 - 1 1/2		30I_12UN_FC	29,63	30	5,5	16	2
12				40I_12UN_FC	40,22	40	6,3	20	2
10	3/4			14I_10UN_FC	12,7	14	3,1	7,5	2
8	1			21I_8UN_FC	19,05	21	4,7	12	2
8				30I_8UN_FC	28,57	30	5,5	16	2
8				40I_8UN_FC	38,1	40	6,3	20	2
7	1 1/8 - 1 1/4			21I_7UN_FC	21,77	21	4,7	12	2
6	1 1/2			30I_6UN_FC	29,63	30	5,5	16	2
6				40I_6UN_FC	38,1	40	6,3	20	2
5	1 3/4			30I_5UN_FC	30,48	30	5,5	16	1
4	3 - 4			40I_4UN_FC	38,1	40	6,3	20	2

NPT

NPT PIPE THREAD

Pitch TPI	Norm	INTERNAL / EXTERNAL Part Number	I mm	L mm	T mm	H mm	Cutting Edges
18	3/8	14X_18NPT_FC	12,7	14	3,1	7,5	1
14	1/2 - 5/8	14X_14NPT_FC	12,7	14	3,1	7,5	1
14	3/4 - 7/8	21X_14NPT_FC	19,96	21	4,7	12	1
11,5	1	21X_11.5NPT_FC	19,88	21	4,7	12	1
11,5	1 1/4 - 2	30X_11.5NPT_FC	28,71	30	5,5	16	1
8	≥ 2 1/2	30X_8NPT_FC	28,58	30	5,5	16	1
8	≥ 2 1/2	40X_8NPT_FC	38,1	40	6,3	20	1

NPTF

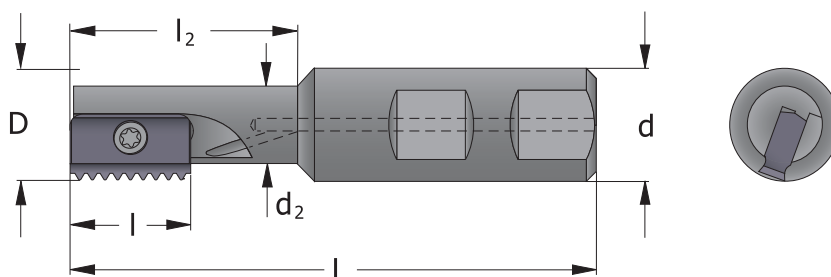
NPTF DRYSEAL PIPE THREAD

Pitch TPI	Norm	INTERNAL / EXTERNAL Part Number	I mm	L mm	T mm	H mm	Cutting Edges
18	3/8	14X_18NPTF_FC	12,7	14	3,1	7,5	1
14	1/2 - 5/8	14X_14NPTF_FC	12,7	14	3,1	7,5	1
14	3/4 - 7/8	21X_14NPTF_FC	19,96	21	4,7	12	1
11,5	1	21X_11.5NPTF_FC	19,88	21	4,7	12	1
11,5	1 1/4 - 2	30X_11.5NPTF_FC	28,71	30	5,5	16	1
8	≥ 2 1/2	30X_8NPTF_FC	28,58	30	5,5	16	1
8	≥ 2 1/2	40X_8NPTF_FC	38,1	40	6,3	20	1

- Part number with I is for internal thread profile.
- Part number with X is for in- and external thread profile.
- For external profile indicate E instead of I. The price is 10% higher for E.

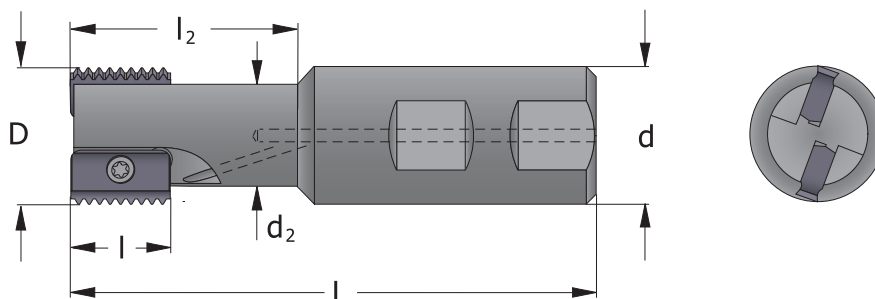
THREAD MILLING TOOLHOLDERS

Shank Toolholders with One Pocket



D mm	d mm	d ₂ mm	Part Number	l mm	l ₂ mm	L mm	No. of Inserts
12	20	8,9	SR0012F14	14	20	75	1
14,5	20	11,2	SR0014H14	14	25	85	1
17	20	13,4	SR0017H14	14	30	85	1
18	20	14,4	SR0018H21	21	30	85	1
21	20	16,5	SR0021H21	21	40	94	1
25	20	-	SR0025K21	21	-	125	1
29	25	22,4	SR0029J30	30	50	110	1
31	25	-	SR0031M30	30	-	150	1
38	32	-	SR0038M30	30	-	150	1
48	40	35	SR0048M40	40	78	153	1
48	40	-	SR0048R40	40	-	210	1

Shank Toolholders with Two Pockets



D mm	d mm	d ₂ mm	Part Number	l mm	l ₂ mm	L mm	No. of Inserts
20	20	16	SR0020H14-2	14	41	93	2
30	25	24	SR0030J21-2	21	52	108	2
40	32	30	SR0040L30-2	30	70	130	2
50	40	38	SR0050M40-2	40	78	153	2

When should I use Thread Milling Inserts?

We recommend Solid Carbide Thread Mills as the first choice because they are much more efficient tools. In most cases, they will result in a lower cost per thread.

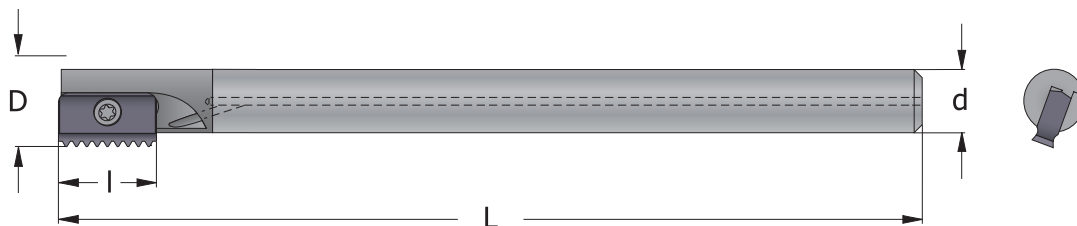
However, the advantage of an Indexable Thread Milling Cutter is that you can use inserts with different pitches and profiles on the same cutter body. This can be a good alternative if you only need to make a few threads.

- Solid Carbide Thread Mills are available up to 4,0 mm pitch.
- Thread Milling Inserts are available up to 6,0 mm pitch.



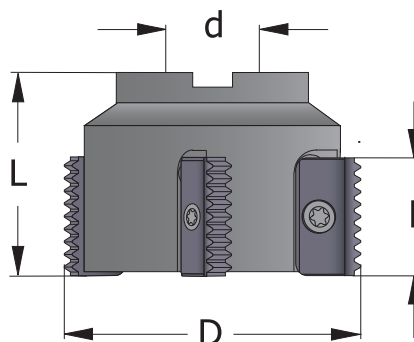
THREAD MILLING TOOLHOLDERS

Shank Toolholders in Carbide



D mm	d mm	Part Number	l mm	L mm	No. of Inserts
13	10	SR0013J14C	14	150	1
15	12	SR0015K14C	14	175	1
21	16	SR0021M21C	21	200	1
27	20	SR0027S30C	30	260	1
33	25	SR0033T30C	30	270	1

Face Mill Cutters

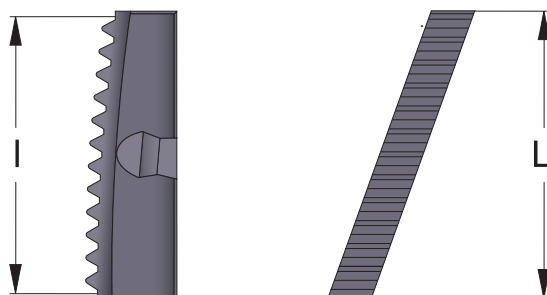


D mm	d mm	Part Number	l mm	L mm	No. of Inserts
63	22	SR0063C21-5	21	50	5
63	22	SR0063C30-4	30	50	4
80	27	SR0080D30-4	30	55	4
100	32	SR0100D30-4	30	60	4
80	27	SR0080D40-4	40	65	4
100	32	SR0100E40-4	40	70	4

Spare Parts

Insert mm	Screw to insert	Torx key
14	S14	K14
21	S21	K21
30	S30	K30
40	S40	K40

Spiral Fluted



M

METRIC

Pitch mm	M fine	INTERNAL Part Number	l mm	L mm	Cutting Edges
1,0	≥ M27	H23I_1.0ISO_FC	27	27	1
1,5	≥ M27	H23I_1.5ISO_FC	27	27	1
1,5	≥ M36	H32I_1.5ISO_FC	31,5	32	1
1,5	≥ M52	H45I_1.5ISO_FC	36	37	1
1,5	≥ M68	H63I_1.5ISO_FC	37,5	38	1
2,0	≥ M27	H23I_2.0ISO_FC	26	27	1
2,0	≥ M36	H32I_2.0ISO_FC	32	32	1
2,0	≥ M52	H45I_2.0ISO_FC	36	37	1
2,0	≥ M68	H63I_2.0ISO_FC	38	38	1
3,0	≥ M30	H23I_3.0ISO_FC	27	27	1
3,0	≥ M39	H32I_3.0ISO_FC	30	32	1
3,0	≥ M52	H45I_3.0ISO_FC	36	37	1
3,0	≥ M72	H63I_3.0ISO_FC	36	38	1
3,5	≥ M30	H23I_3.5ISO_FC	24,5	27	1
4,0	≥ M36	H23I_4.0ISO_FC	24	27	1
4,0	≥ M42	H32I_4.0ISO_FC	32	32	1
4,0	≥ M56	H45I_4.0ISO_FC	36	37	1
4,0	≥ M72	H63I_4.0ISO_FC	36	38	1
4,5	≥ M42	H32I_4.5ISO_FC	31,5	32	1
5,0	≥ M48	H32I_5.0ISO_FC	30	32	1
5,5	≥ M56	H45I_5.5ISO_FC	33	37	1
6,0	≥ M64	H45I_6.0ISO_FC	36	37	1
6,0	≥ M80	H63I_6.0ISO_FC	36	38	1

G/Rp

WHITWORTH PIPE THREAD

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	l mm	L mm	Cutting Edges
14	G ≥ 7/8	H23X_14W_FC	25,4	27	1
11	G ≥ 1	H23X_11W_FC	25,4	27	1
11	G ≥ 1 1/8	H32X_11W_FC	30,02	32	1
11	G ≥ 1 3/4	H45X_11W_FC	36,95	37	1
11	G ≥ 2 1/2	H63X_11W_FC	36,95	38	1

R/Rc

BSPT PIPE THREAD

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	l mm	L mm	Cutting Edges
11	Rc ≥ 1	H23X_11BSPT_FC	25,4	27	1
11	Rc ≥ 1 1/8	H32X_11BSPT_FC	30,02	32	1
11	Rc ≥ 1 3/4	H45X_11BSPT_FC	36,95	37	1
11	Rc ≥ 2 1/2	H63X_11BSPT_FC	36,95	38	1

NPT

NPT PIPE THREAD

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	l mm	L mm	Cutting Edges
11,5	1 - 2	H23X_11.5NPT_FC	26,5	27	1
11,5	1 1/4 - 2	H32X_11.5NPT_FC	30,92	32	1
11,5	2	H45X_11.5NPT_FC	35,34	37	1
8	2 1/2	H45X_8NPT_FC	34,93	37	1
8	3	H63X_8NPT_FC	38,1	38	1

NPTF

NPTF PIPE THREAD

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	l mm	L mm	Cutting Edges
11,5	1 - 2	H23X_11.5NPTF_FC	26,5	27	1
11,5	1 1/4 - 2	H32X_11.5NPTF_FC	30,92	32	1

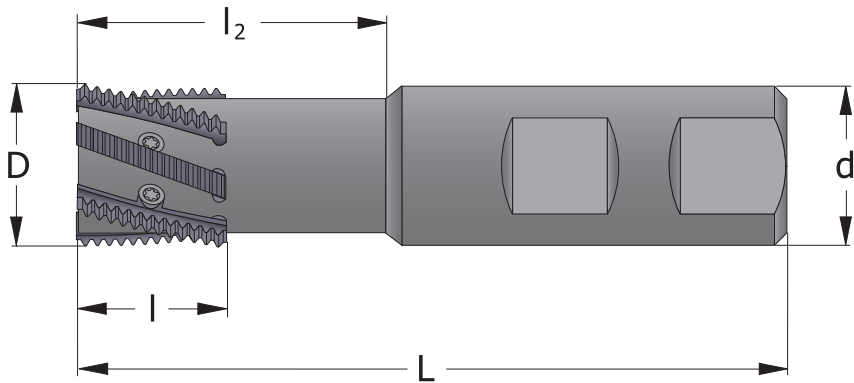
UN

UNIFIED

Pitch TPI	Standard	INTERNAL Part Number	l mm	L mm	Cutting Edges
24	≥ 1	H23I_24UN_FC	26,46	27	1
20	≥ 1 1/16	H23I_20UN_FC	26,67	27	1
20	≥ 1 3/8	H32I_20UN_FC	31,75	32	1
18	≥ 1 1/16	H23I_18UN_FC	26,81	27	1
18	≥ 1 3/8	H32I_18UN_FC	31,04	32	1
16	≥ 1 1/8	H23I_16UN_FC	26,99	27	1
16	≥ 1 1/2	H32I_16UN_FC	31,75	32	1
16	≥ 2	H45I_16UN_FC	36,51	37	1
16	≥ 2 5/8	H63I_16UN_FC	38,1	38	1
12	≥ 1 1/8	H23I_12UN_FC	25,4	27	1
12	≥ 1 1/2	H32I_12UN_FC	31,75	32	1
12	≥ 2	H45I_12UN_FC	35,98	37	1
12	≥ 2 3/4	H63I_12UN_FC	38,1	38	1
8	≥ 1 1/8	H23I_8UN_FC	25,4	27	1
8	≥ 1 1/2	H32I_8UN_FC	31,75	32	1
8	≥ 2 1/8	H45I_8UN_FC	34,93	37	1
8	≥ 2 3/4	H63I_8UN_FC	38,1	38	1
7	≥ 1 1/4	H23I_7UN_FC	25,4	27	1
6	≥ 1 5/8	H32I_6UN_FC	29,63	32	1
6	≥ 2 1/8	H45I_6UN_FC	33,97	37	1
6	≥ 2 7/8	H63I_6UN_FC	38,1	38	1
5	≥ 1 3/4	H32I_5UN_FC	30,48	32	1

THREAD MILLING TOOLHOLDERS

Spiral Fluted Shank Toolholders



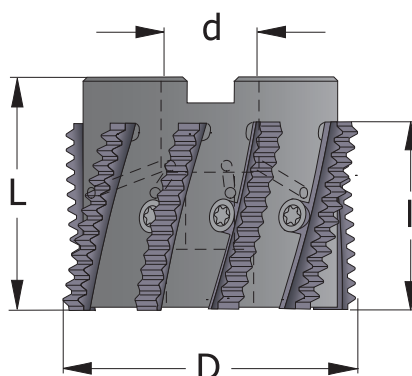
D mm	d mm	Part Number	l mm	l_2 mm	L mm	No. of Inserts
23	25	SRH23-2	27	50	110	2
23	25	SRH23M-2	27	75	150	2
32	32	SRH32-5	32	60	130	5
32	32	SRH32P-5	32	90	180	5
45	32	SRH45-6	37	-	130	6

*Spiral fluted for
efficient machining*



THREAD MILLING TOOLHOLDERS

Spiral Fluted Face Mill Cutters



D mm	d mm	Part Number	l mm	L mm	No. of Inserts
32	16	SRH32-5M	32	52	5
45	22	SRH45-6M	37	60	6
63	22	SRH63-9	38	50	9

Spare Parts

Insert mm	Screw to insert	Torx key
H23	S23	K21
H32	S32	K22
H45	S45	K40
H63	S63	K40

