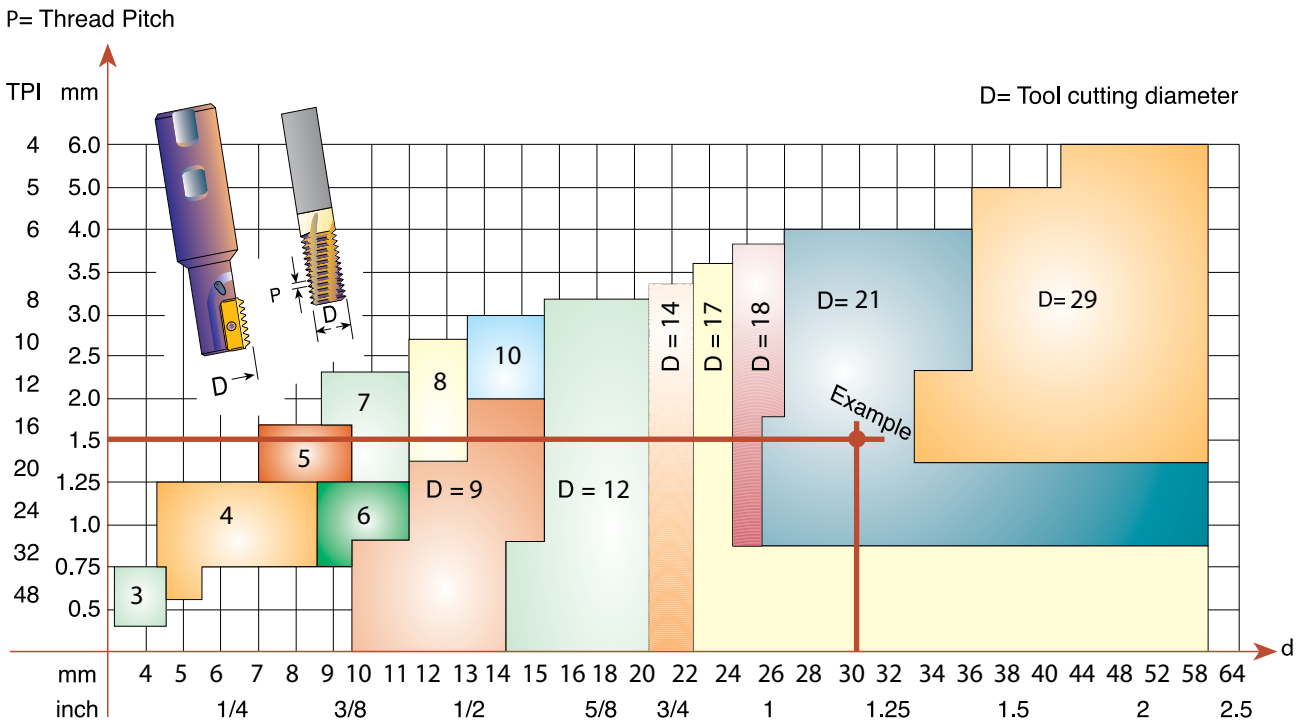


Tool Selection

For indexable and solid carbide Mill Threads

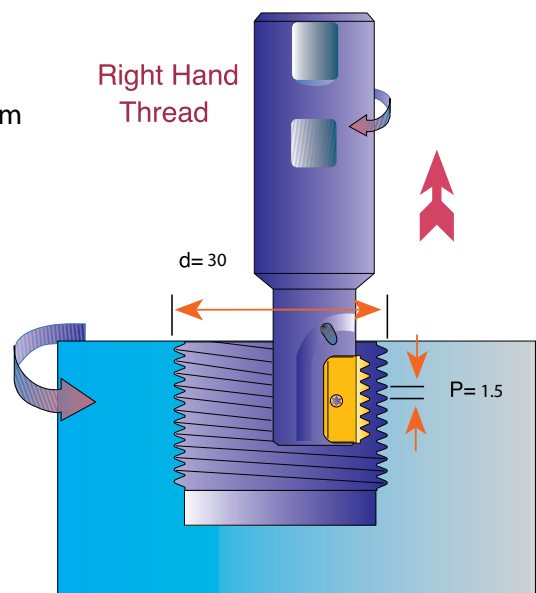
The following chart provides a fairly accurate visual selection tool for Internal Threading. The chart is suitable for the following thread forms: ISO, UN, WHIT, NPT, NPTF, BSPT and PG.



Any tool with a small cutting diameter can produce larger diameter threads.

Example: Internal thread M30 x 1.5:
Find a Milling Tool to produce d=30 Internal right hand ISO thread with a thread pitch P=1.5 mm.
As can be seen from the chart above, the two red lines intersect at a selected tool with a cutting diameter of D=21 mm

Chosen toolholder: SR0021 H21
Insert: 21 I 1.5 ISO MT7



If you need assistance, please call your local distributor and ask for help in selecting the appropriate tool as well as for a CNC program to suit your CNC milling machine.