

SOLID CARBIDE THREAD MILLS

ThreadBurr with Internal Radial Coolant



AC

TiAlCN coated
Micrograin Carbide

Tolerance

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

Shank

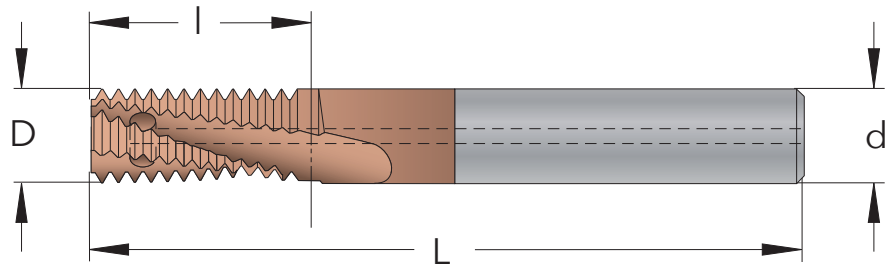
Cylindrical h6, DIN6535 HA

Flute

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	No. of Flutes	l 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	NBT1212E29_1.5ISO_AC	12	12	5	29,25	100
1,75	M12 (2xD)		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	NBT1212D35_2.0ISO_AC	12	12	4	35	100
2,0		≥ M20	NBT1616E39_2.0ISO_AC	16	16	5	39	100

G/Rp

WHITWORTH PIPE THREAD

Pitch TPI	Standard	INTERNAL / EXTERNAL Part Number	d mm	D mm	No. of Flutes	l 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	XBT1616D40_11W_AC	16	16	4	40,41	100

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) should be used for blind holes.
- Internal Radial Coolant (NBT) should be used for through holes.