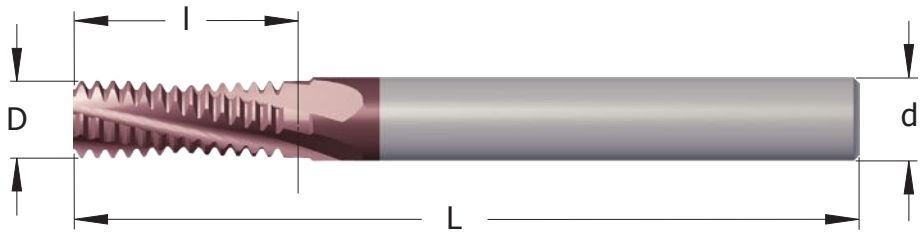
ThreadBurr for Internal Threading

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



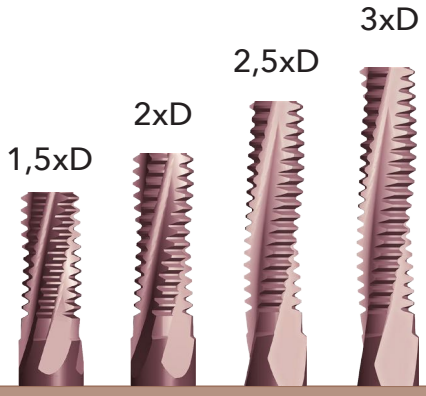
M

METRIC

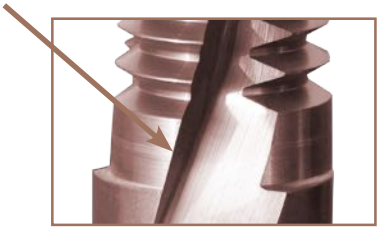
Pitch mm	M coarse	M fine	Vib. free	INTERNAL Part Number	d mm	D mm	Z flutes	l mm	L mm
0,4	M2 (1,5xD)			NB04015C3_0.4ISO_AC	4	1,5	3	3,4	50
0,4	M2 (2xD)			NB04015C4_0.4ISO_AC	4	1,5	3	4,6	50
0,45	M2,2 (1,5xD)			NB04016C3_0.45ISO_AC	4	1,65	3	3,82	50
0,45	M2,2 (2xD)		VF	NB04016C5_0.45ISO_AC	4	1,65	3	5,17	50
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.

SmiCut STS



Deburring of the thread



Threading without burrs

M METRIC

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.