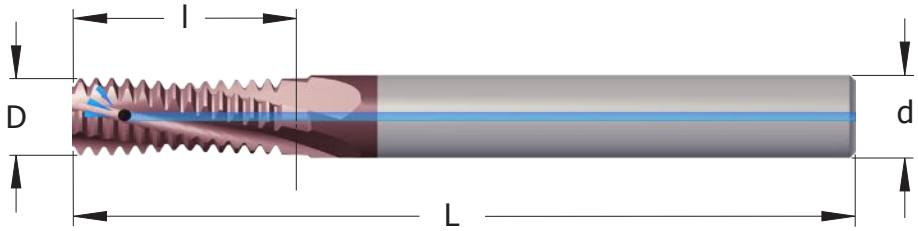
ThreadBurr with Internal Radial Coolant

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
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
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	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	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 gets 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.