

with Chamfer

AC

TiAlCN coated, Micrograin Carbide

Tolerance

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

Shank

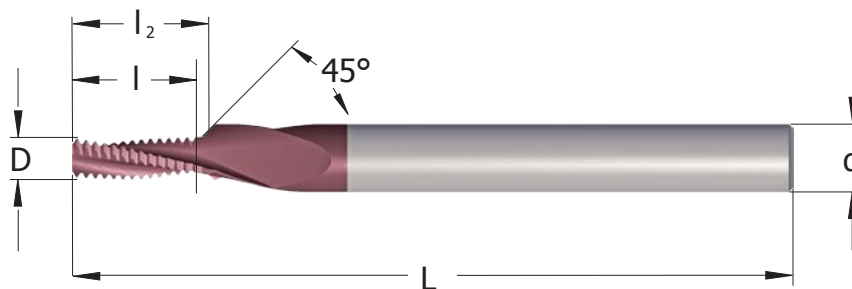
Cylindrical h6, DIN6535 HA

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.

