

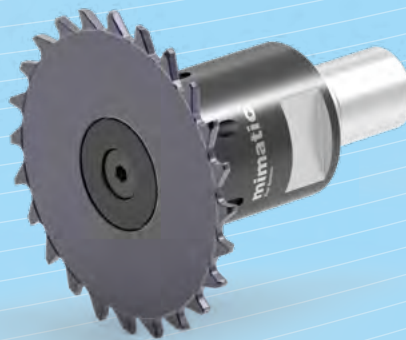
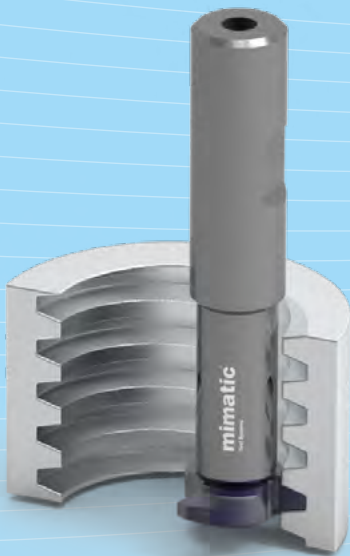
mimatic®

Tool Systems

Your Partner For Clever Tooling

Cutting Tools

- Thread milling
- Groove milling
- Gear milling
- Contour and radius milling
- Dovetail milling
- Sawing, cutting, slitting
- etc.



Manufacturer of Precision Tools Since 1974

Thread Milling



Systems for Circular Thread Milling

PolyMILL

Our bestseller system allows **threading** and/or **circlip grooving** in high precision.

The polygonal connection of insert and milling body improves the efficiency and precision of the process significantly:

- **Longer tool life**
- **Higher machining volume**
- **Higher feed rates**
- **Shorter processing times**
- **High stability**
- **High security at interrupted cutting**



TriMILL

Affordable and flexible system for short processing times and long tool lives.

- **Deep, true to gauge threads**
- **Accurate free-form contours**
- **Accurate grooving**

Bottom threads can be cut almost to the bottom without undercuts.

By using the same pitches, the storage and acquisition costs decrease also.



TrioCUT

Smooth cutting and **low cutting pressure** results in high surface quality and long tool lives. A **conical position of insert pocket** guarantees stability of the tool shaft. Further advantages are the **radially back ground thread profile**, extremely high wedge angle, a more stable cutting edge as well as a positive rake angle.

The optimum application area are fine threads and/or very short thread lengths.

- **Thread milling with undercut**
- **Thread milling**
- **Drill thread milling**



SolidCUT

Extensive range of solid carbide thread milling cutters.

- **Spiral-grooved grooves**
- **Soft cut**
- **Excellent surface qualities**
- **Also for thin-walled workpieces**
- **A tool for right- and left-hand threads**
- **Unbeatable in price / performance**



14,5 **15** **21** **26**

Multi tooth thread milling cutters, ideal for short thread, small gradient lengths and very rigid clamping of workpiece and cutter.



mimaticSTC

Sectional thread milling for high-quality large threads from M24.

STC-1 with 10 edges

Biggest advantage for any long threads from M24: A shorter process time compared to cutters with inserts and easier assembly.



Symbols

	Type designation		Thread standard
	Steel shaft without clamping surface		Thread with undercut (Trio-Cut)
	Steel shaft with Weldon clamping surface		for right- and left hand internal thread for left hand thread modify your NC-program!
	Solid carbide shaft without clamping surface		for right- and left hand external thread for left hand thread modify your NC-program!
	Solid carbide shaft with Weldon clamping surface		Full form thread milling
	Cutter with tightening thread		Partial form thread milling
	Smallest necessary bore-diameter		Point angle
	Internal coolant supply		Thread standard
	Number of inserts		

Short Descriptions

Alpha (α)	Point angle of milling insert	F	Width of trailing chamfer
A	Groove width	H _P	Insert height
A ₁	Basic width in the Groove	H _S	Slider height (Axial grooving tool)
B _{f6}	Insert holder width of axial grooving tool	L	Length of milling tool
B _{H7}	Groove width of axial grooving tool	L ₁	Clamping length of milling tool
B _w	Tool width of axial grooving tool	L ₂	Length of step milling head
C	Chamfer width	L _G	Usable thread length at the multi-tooth thread milling
D	Cutting diameter	L _{HA}	Holder length
d ₁	Milling body diameter (front)	L _{P1}	Insert height of milling body – edge
d ₂	Large diameter of milling body	L _{P2}	Insert height of edge – interfering contour
d _{g6}	Fitting face diameter of threaded milling tool	L _{PF}	Length of fitting face
D _{t6}	Shaft diameter of milling body (Arbor)	L _S	Shaft length – clamping length (Depth)
D _P	Flight circle of insert	M	Thread size
D _R	Nominal diameter of concave radius insert	P	Pitch
E	Width blank insert	R	Radius (general/common)

Formula for Tool Lengths

$$L_{WKZ} = L_{GK} + L_1 + L_{P1} (+L_{P2})$$

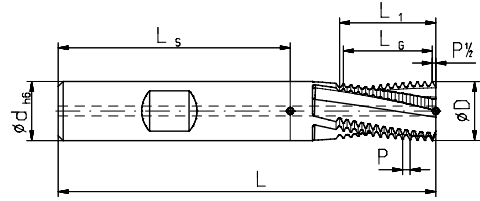
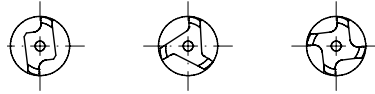
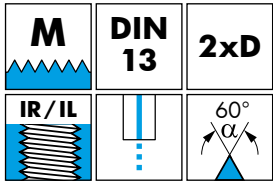
SolidCUT

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	Fixed dimension	1/4" - 1/2"	56
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	Fixed dimension	1/4" - 1/2"	57
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SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 166



Thread	P mm	D ^{±0,02} mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
										TINAMATIC	DIN 6535 Form HA	DIN 6535 Form HB
M3	0,5	2,4	42	7,0	6,5	14	4	2		168192		
M4	0,7	3,15	55	9,8	9,1	14	6	3		168195	168196	168197
M5	0,8	4,0	55	12,0	11,2	15	6	3		168198	168199	168200
M6	1,0	4,8	55	14,0	13	14	6	3		168201	168202	168203
M8	1,25	5,95	60	18,75	17,5	15	6	3	✓	168204	168205	168206
M10	1,5	7,95	70	22,5	21	15	8	3	✓	168207	168208	168209
M12	1,75	9,9	75	28,0	26,25	16	10	4	✓	168210	168211	168212
M14	2,0	11,6	85	32,0	30	16	12	4	✓	168213	168214	168215
M16	2,0	11,95	85	36,0	34	18	12	4	✓	168216	168217	168218
M18	2,5	13,95	90	42,5	40	17	14	4	✓	168219	168220	168221
M20	2,5	15,95	90	42,5	40	17	16	4	✓	168222	168223	168224

- Chamfer type
- Cutting Data see page 166

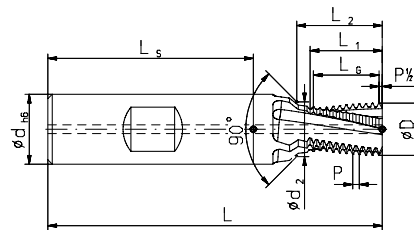
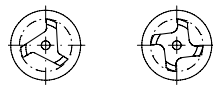


Figure 1:
Chamfer on the shank

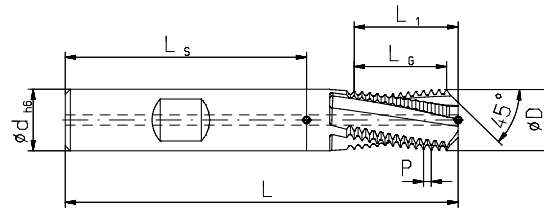
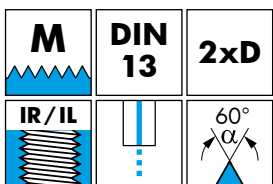
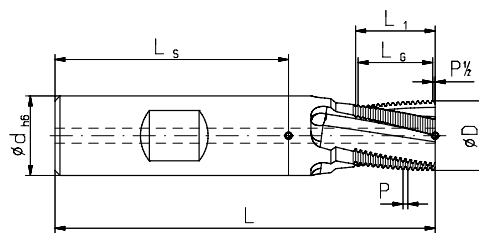
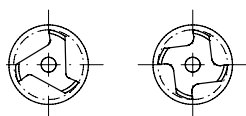
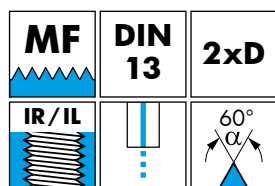


Figure 2:
Chamfer on the face

Thread	P mm	D ^{±0,02} mm	L mm	L1 mm	L2 mm	Lg mm	Number of teeth	dh6 mm	d2 mm	Number of edges	Internal coolant	Fig.	Order No.		
													TINAMATIC	DIN 6535 Form HA	DIN 6535 Form HB
M3	0,5	2,4	42	7,0	7,6	6,5	14	4	3,3	2		1	190812	NEW	-
M4	0,7	3,15	55	9,80	11,03	9,1	14	6	4,3	3		1	186833		186834
M5	0,8	4,00	62	12,70	13,35	11,2	15	8	5,3	3		1	171556		171565
M6	1,0	4,80	62	14,00	15,55	13	14	8	6,3	3		1	171557		171566
M8	1,25	6,50	74	18,75	20,60	17,5	15	10	8,3	3	✓	1	171558		171567
M10	1,5	7,95	80	22,50	24,80	21	15	12	10,3	3	✓	1	171559		171568
M12	1,75	9,90	90	28,00	30,60	26,25	16	14	12,3	4	✓	1	171560		171569
M14	2,0	11,60	100	32,00	34,85	30	16	16	14,3	4	✓	1	171561		171570
M16	2,0	11,95	90	37,60		34	18	12		4	✓	2	171562		171571
M18	2,5	13,95	110	37,50	41,40	40	17	20	18,3	4	✓	1	171563		171572
M20	2,5	15,95	100	44,00		40	17	16		4	✓	2	171564		171573

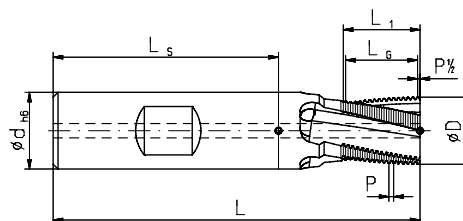
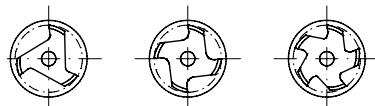
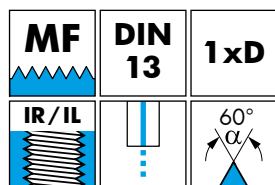
SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 166



Thread	P mm	D ^{±0,02} mm	L mm	L1 mm	LG mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
										TINAMATIC		
										DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
M5x0,5	0,5	4,0	55	11,5	11	23	6	3		168225	168226	168227
M6x0,75	0,75	4,8	55	14,25	13,5	19	6	3		168228	168229	168230
M8x1	1,0	5,95	60	19,0	18	19	6	3	✓	168231	168232	168233
M10x1	1,0	7,95	70	21,0	20	21	8	3	✓	193058	on request NEW	on request NEW
M10x1,25	1,25	7,95	70	21,5	20	17	8	3	✓	168234	168235	168236
M12x1	1,0	9,9	75	27,0	26	27	10	4	✓	168237	168238	168239
M12x1,25	1,25	9,9	75	27,5	26,25	22	10	4	✓	168240	168241	168242
M12x1,5	1,5	9,9	75	27,0	25,5	18	10	4	✓	168243	168244	168245
M14x1	1,0	11,6	85	31,0	30	31	12	4	✓	168246	168247	168248
M14x1,25	1,25	11,6	85	31,25	30	25	12	4	✓	200257 NEW	200258 NEW	200259 NEW
M14x1,5	1,5	11,6	85	31,5	30	21	12	4	✓	168249	168250	168251
M16x1,5	1,5	11,95	85	34,5	33	23	12	4	✓	168252	168253	168254
M18x1,5	1,5	13,95	90	42,0	40,5	28	14	4	✓	168255	168256	168257
M20x1,5	1,5	15,95	90	42,0	40,5	28	16	4	✓	168258	168259	168260

- Universal type
- Cutting Data see page 166



Thread from	P mm	D ^{±0,02} mm	L mm	L1 mm	LG mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.		
										TINAMATIC		
										DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
M10	0,5	7,95	70	12	11,5	24	8	3	✓	170779	170780	170781
M11	0,75	7,95	70	12	11,25	16	8	3	✓	170782	170783	170784
M12	1,0	9,95	75	16	15	16	10	4	✓	170785	170786	170787
M14	1,0	11,95	85	20	19	20	12	4	✓	170791	170792	170793
M18	1,0	15,95	90	25	24	25	16	5	✓	170800	170801	170802
M22	1,0	19,95	110	32	31	32	20	5	✓	170812	170813	170814
M14	1,5	9,95	75	16	15	11	10	4	✓	170788	170789	170790
M16	1,5	11,95	85	20	19,5	14	12	4	✓	170794	170795	170796
M20	1,5	15,95	90	25	24	17	16	5	✓	170803	170804	170805
M24	1,5	19,95	110	32	31,5	22	20	5	✓	170815	170816	170817
M16	2,0	11,95	85	20	18	10	12	4	✓	170797	170798	170799
M20	2,0	15,95	90	25	24	13	16	5	✓	170806	170807	170808
M24	2,0	19,95	110	32	30	16	20	5	✓	170818	170819	170820
M24	3,0	15,95	90	27	24	9	16	5	✓	170809	170810	170811
M27	3,0	19,95	110	32	30	11	20	5	✓	170821	170822	170823

SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 166

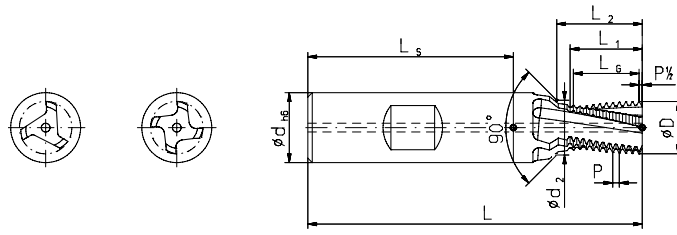


Figure 1:
Chamfer on the shank

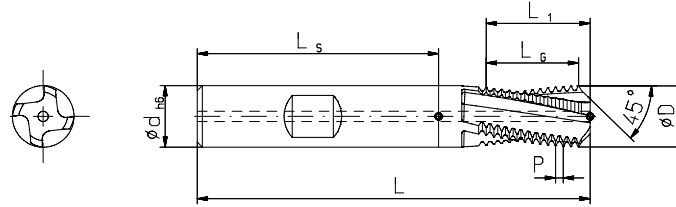
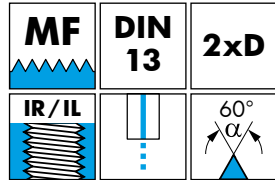
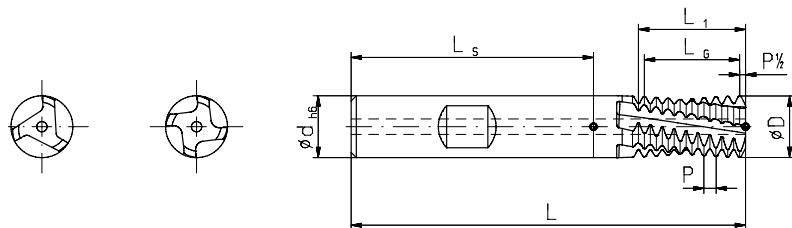
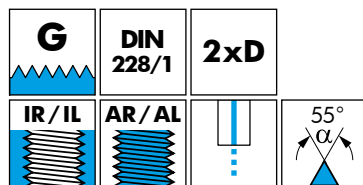


Figure 2:
Chamfer on the face

Thread	P mm	D ^{+0,02} mm	L mm	L ₁ mm	L ₂ mm	L _G mm	Number of teeth	d _{h6} mm	d ₂ mm	Number Internal of edges	Internal coolant	Fig.	Order No.	
													TINAMATIC	
M8x1	1,0	5,95	74	19	21	18	19	10	8,3	3	✓	1	171574	172376
M10x1	1,0	8,0	80	22	23,95	21	22	12	10,3	3	✓	1	171575	172377
M10x1,25	1,25	7,95	80	22,5	24,6	21,25	18	12	10,3	3	✓	1	171576	172378
M12x1	1,0	9,9	90	27	29	26	27	14	12,3	4	✓	1	171577	172379
M12x1,25	1,25	9,9	90	27,5	29,6	26,25	22	14	12,3	4	✓	1	171578	172380
M12x1,5	1,5	9,9	90	27	29,25	25,5	18	14	12,3	4	✓	1	171579	172381
M14x1	1,0	11,6	100	31	33,15	30	31	16	14,3	4	✓	1	171580	172382
M14x1,5	1,5	11,6	100	31,5	33,9	30	21	16	14,3	4	✓	1	171581	172383
M16x1,5	1,5	11,95	90	36,05		33	23	12		4	✓	2	171582	172384
M18x1,5	1,5	14,0	110	39	42,2	37,5	26	20	18,3	4	✓	1	171583	172385
M20x1,5	1,5	15,95	100	45,05		42	29	16		4	✓	2	171584	172386

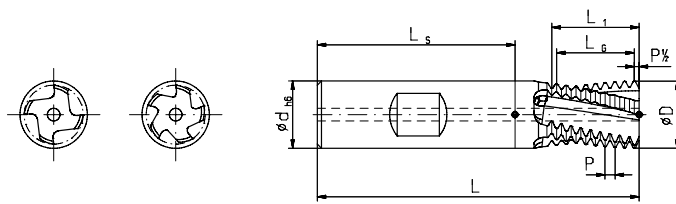
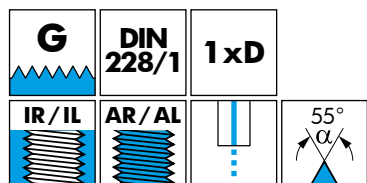
- Fixed dimension type
- Cutting Data see page 166



Thread	P mm	Pitch/"	D ^{+0,02} mm	L mm	L ₁ mm	L _G mm	Number of teeth	d _{h6} mm	Number Internal of edges	Internal coolant	Order No.		
											TINAMATIC		
G 1/16"	0,907	28	5,95	60	16,33	15,42	18	6	3	✓	196157 NEW	on request NEW	on request NEW
G 1/8"	0,907	28	7,95	70	20,8	20,86	24	8	3	✓	168371	168372	168373
G 1/4"	1,337	19	9,9	75	28,0	26,74	21	10	4	✓	168374	168375	168376
G 3/8"	1,337	19	13,95	90	41,45	40,11	31	14	4	✓	168377	168378	168379
G 1/2"	1,814	14	15,95	90	43,5	41,72	24	16	4	✓	168380	168381	168382

SolidCUT Solid Carbide Circular Thread Milling Cutter

- Universal type
- Cutting Data see page 166



Thread from	P mm	Pitch/"	D ^{±0,02} mm	L mm	L1 mm	LG mm	Number of teeth	dh6 mm	Number of edges	Internal coolant	Order No.	
											TINAMATIC	
											DIN 6535 Form HA	DIN 6535 Form HB
G 1/4 - 3/8"	1,337	19	9,95	75	16,0	14,71	12	10	4	✓	186224	187865
G 1/2 - 7/8"	1,814	14	15,95	90	25,4	23,58	14	16	5	✓	186225	187866
> G 1"	2,309	11	19,95	110	32,3	30,02	14	20	5	✓	183759	177967

- Chamfer type
- Cutting Data see page 166

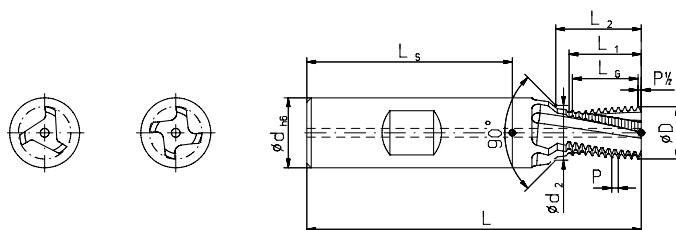


Figure 1: Chamfer on the shank

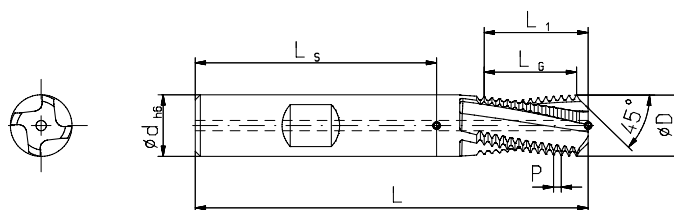
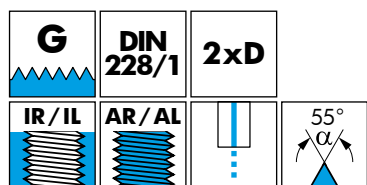
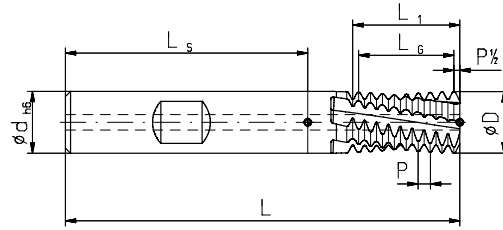
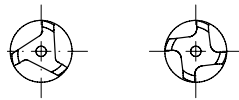
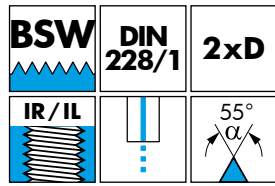


Figure 2: Chamfer on the face

Thread	P mm	Pitch/"	D ^{±0,02} mm	L mm	L1 mm	L2 mm	LG mm	Number of teeth	dh6 mm	d2 mm	Number of edges	Fig.	Order No.	
													TINAMATIC	
													DIN 6535 Form HA	DIN 6535 Form HB
G 1/16"	0,907	28	6	74	16,3	18,1	15,42	18	10	8,0	3	1	171585	172387
G 1/8"	0,907	28	7,95	80	21,8	23,5	20,86	24	12	10,0	3	1	171586	172388
G 1/4"	1,337	19	9,9	100	28,0	30,8	26,74	21	16	13,5	4	1	171587	172389
G 3/8"	1,337	19	13,95	90	37,5		34,76	27	14		4	2	171588	172390
G 1/2"	1,814	14	15,95	100	46,75		43,54	25	16		5	2	171589	172391
G 5/8"	1,814	14	17,95	110	51,0		47,16	27	18		5	2	171590	172392

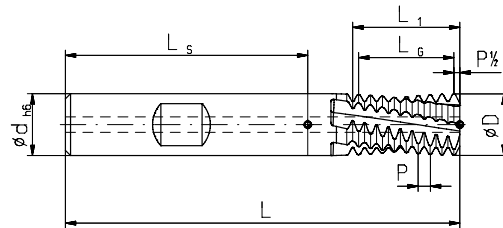
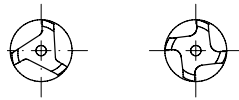
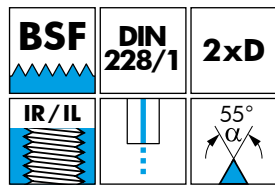
SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 166



Thread	P mm	Pitch/"	D ^{+0,02} mm	L mm	L1 mm	L6 mm	Number of teeth	d _{h6} mm	Number Internal of edges	coolant	Order No.		
											TINAMATIC	DIN 6535 Form HA	DIN 6535 Form HB
5/16"	1,411	18	6,0	60	19,75	18,34	14	6	3	✓	168383	168384	168385
3/8"	1,588	16	5,95	60	20,60	19,06	13	6	3	✓	168386	168387	168388
7/16"	1,814	14	7,95	70	23,60	21,77	13	8	3	✓	168389	168390	168391
1/2"	2,117	12	7,95	70	23,30	21,17	11	8	3	✓	168392	168393	168394
5/8"	2,309	11	9,90	75	30,00	27,71	13	10	4	✓	168395	168396	168397

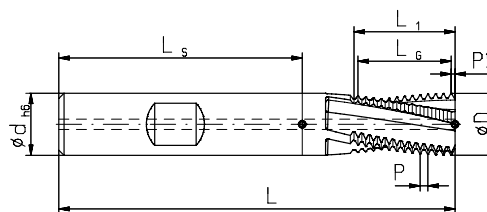
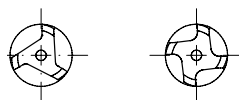
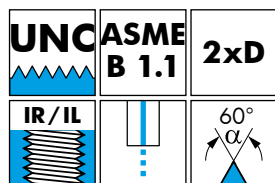
- Fixed dimension type
- Cutting Data see page 166



Thread	P mm	Pitch/"	D ^{+0,02} mm	L mm	L1 mm	L6 mm	Number of teeth	d _{h6} mm	Number Internal of edges	coolant	Order No.		
											TINAMATIC	DIN 6535 Form HA	DIN 6535 Form HB
5/16"	1,155	22	5,95	60	19,6	18,48	17	6	3	✓	168398	168399	168400
3/8"	1,270	20	5,95	60	19,0	17,78	15	6	3	✓	168401	168402	168403
7/16"	1,411	18	7,95	70	22,6	21,17	16	8	3	✓	168404	168405	168406
1/2"	1,588	16	7,95	70	23,8	22,23	15	8	3	✓	168407	168408	168409
5/8"	1,814	14	9,90	75	29,0	27,21	16	10	4	✓	168410	168411	168412

SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 166



Thread	P mm	Pitch/°	D ^{±0,02} mm	L mm	L1 mm	Lg mm	Number of teeth	dh6 mm	Number Internal of edges coolant	Order No.		
										TINAMATIC		
										DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
1/4"-20	1,270	20	4,8	55	14	12,7	11	6	3	168413	168414	168415
5/16"-18	1,411	18	5,95	60	19,7	18,34	14	6	3	168416	168417	168418
3/8"-16	1,588	16	7,6	70	23,8	22,23	15	8	3	168419	168420	168421
7/16"-14	1,814	14	7,95	70	23,6	21,77	13	8	3	168422	168423	168424
1/2"-13	1,954	13	9,9	75	29,3	27,36	15	10	4	168425	168426	168427

- Chamfer type
- Cutting Data see page 166

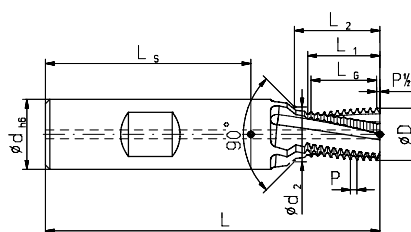


Figure 1:
Chamfer on the shank

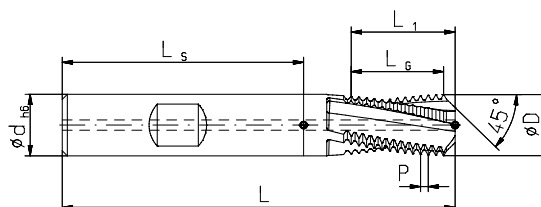
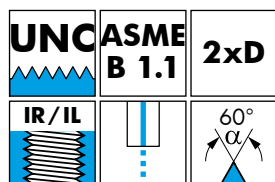
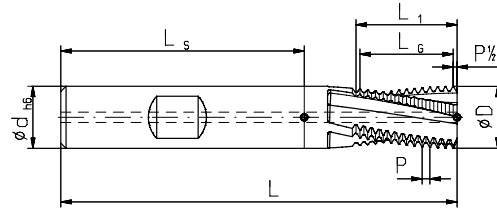
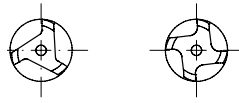
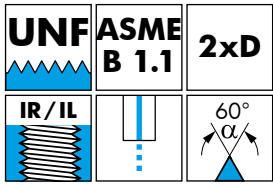


Figure 2:
Chamfer on the face

Thread	P mm	Pitch/°	D ^{±0,02} mm	L mm	L1 mm	L2 mm	Lg mm	Number of teeth	dh6 mm	d2 mm	Number of edges	Internal coolant	Fig.	Order No.		
														TINAMATIC		
															DIN 6535 Form HA	DIN 6535 Form HB
1/4"-20	1,270	20	4,8	62	14,0	15,73	12,7	11	8	6,65	3		1	171591	172393	
5/16"-18	1,411	18	5,95	74	19,7	21,9	18,34	14	10	8,25	3	✓	1	171592	172394	
3/8"-16	1,588	16	7,95	80	23,8	25,85	22,23	15	12	9,83	3	✓	1	171593	172395	
7/16"-14	1,814	14	7,95	90	23,6	26,5	21,77	13	14	11,43	3	✓	1	171594	172396	
1/2"-13	1,954	13	9,9	90	29,3	32,1	27,36	15	14	13	4	✓	1	171595	172397	
9/16"-12	2,117	12	11,8	100	33,9	36,6	31,76	16	16	14,61	4	✓	1	171596	172398	
5/8"-11	2,309	11	12,7	90	38,4		34,63	16	14		4	✓	2	171597	172399	
3/4"-10	2,540	10	15,2	110	40,6	44,3	38,1	16	20	19,35	5	✓	1	171598	172400	

SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 166



Thread	P mm	Pitch/°	D ^{±0,02} mm	L mm	L1 mm	L6 mm	Number of teeth	dh6 mm	Number Internal of edges coolant	Order No.		
										TINAMATIC		
										DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
1/4"-28	0,907	28	4,8	55	14,5	13,61	16	6	3	168428	168429	168430
5/16"-24	1,058	24	5,95	60	19,0	17,99	18	6	3	168431	168432	168433
3/8"-24	1,058	24	7,95	70	22,2	21,16	21	8	3	168434	168435	168436
7/16"-20	1,270	20	7,95	70	22,8	21,59	18	8	3	168437	168438	168439
1/2"-20	1,270	20	9,9	75	27,9	26,67	22	10	4	168440	168441	168442

- Chamfer type
- Cutting Data see page 166

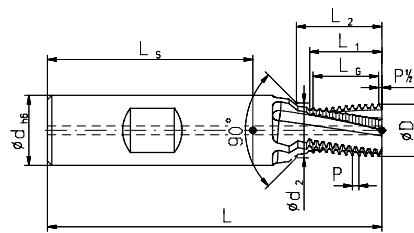
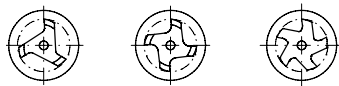


Figure 1: Chamfer on the shank

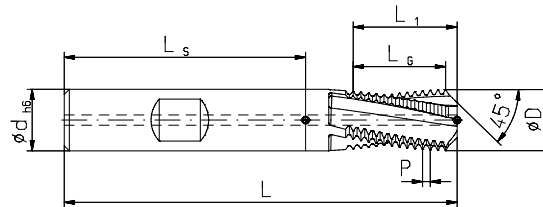
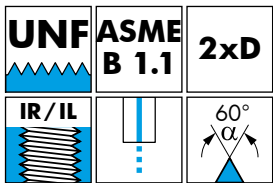
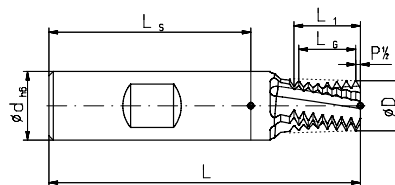
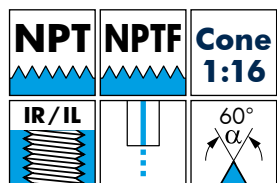


Figure 2: Chamfer on the face

Thread	P mm	Pitch/°	D ^{±0,02} mm	L mm	L1 mm	L2 mm	L6 mm	Number of teeth	dh6 mm	d2 mm	Number of edges	Internal coolant	Fig.	Order No.	
														TINAMATIC	
														DIN 6535 Form HA	DIN 6535 Form HB
1/4"-28	0,907	28	4,8	62	14,5	16,2	13,61	16	8	6,65	3		1	171599	172401
5/16"-24	1,058	24	5,95	74	19,0	21	17,99	18	10	8,25	3	✓	1	171600	172402
3/8"-24	1,058	24	7,6	80	22,2	23	21,16	21	12	9,83	3	✓	1	171601	172403
7/16"-20	1,270	20	7,95	90	22,8	25,5	21,59	18	14	11,4	3	✓	1	171602	172404
1/2"-20	1,270	20	9,9	90	27,9	30,43	26,67	22	14	13	4	✓	1	171603	172405
9/16"-18	1,411	18	12	100	31,0	33,35	29,63	22	16	14,61	4	✓	1	171604	172406
5/8"-18	1,411	18	13,5	90	36,8		33,86	25	14		4	✓	2	171605	172407
3/4"-16	1,588	16	17	110	39,7	42	38,11	25	20	19,35	5	✓	1	171606	172408

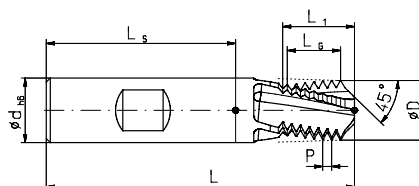
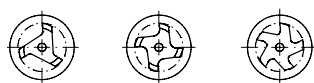
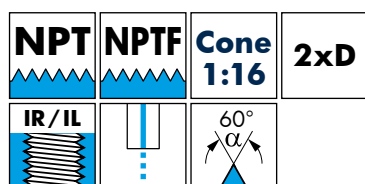
SolidCUT Solid Carbide Circular Thread Milling Cutter

- Fixed dimension type
- Cutting Data see page 166



Thread	P mm	Pitch/"	D ^{±0,02} mm	L mm	L1 mm	LG mm	Number of teeth	d h6 mm	Number of edges	Internal coolant	Order No.		
											TINAMATIC		
											DIN 6535 Form HA	DIN 6535 Form HB	DIN 6535 Form HE
1/16"	0,941	27	5,8	70	11,3	10,35	12	8	3	✓	170752	170753	170754
1/8"	0,941	27	7,6	75	11,3	10,35	12	10	3	✓	170755	170756	170757
1/4"	1,411	18	10,1	90	15,5	14,11	11	14	3	✓	170758	170759	170760
3/8"	1,411	18	12,8	90	16,7	14,11	11	16	4	✓	170761	170762	170763
1/2"	1,814	14	16,0	110	21,35	18,14	11	20	5	✓	170764	170765	170766
3/4"	1,814	14	18,5	110	19,95	18,14	11	20	5	✓	170767	170768	170769

- Chamfer type
- Cutting Data see page 166

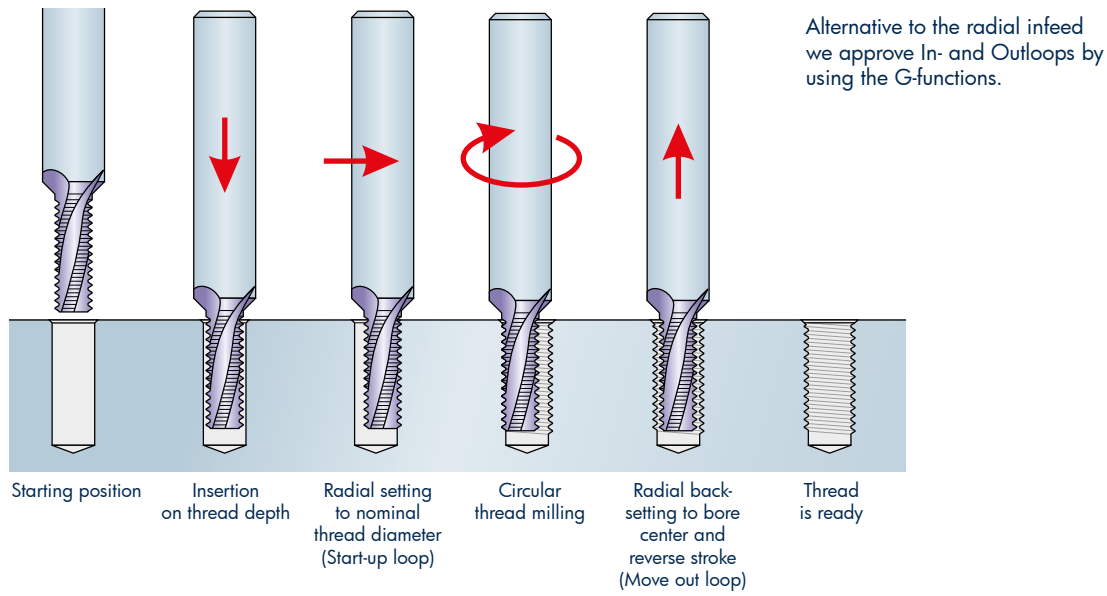


Thread	P mm	Pitch/"	D ^{±0,02} mm	L mm	L1 mm	LG mm	Number of teeth	d h6 mm	Number of edges	Internal coolant	Order No.	
											TINAMATIC	
											DIN 6535 Form HA	DIN 6535 Form HB
1/4"	1,411	18	10,1	90	18,2	14,11	11	14	3	✓	171609	172411
3/8"	1,411	18	12,8	90	18,2	14,11	11	16	4	✓	171610	172412
1/2"	1,814	14	16,0	110	22,8	18,14	11	20	5	✓	171611	172413
3/4"	1,814	14	18,5	110	23,0	18,14	11	20	5	✓	171612	172414

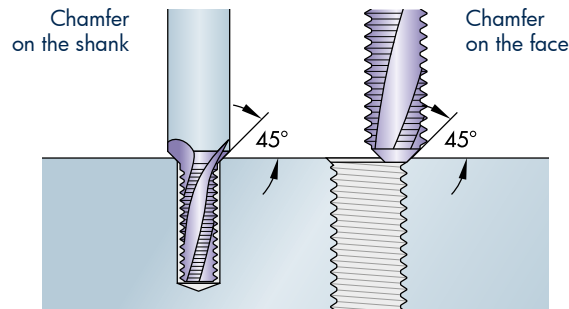
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Machining Sequence



Types with chamfer



i More information to circular thread milling see page 175

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