

TYSON TOOL®

Thread Milling

Solid Carbide

- mini thread mills
- helical flute, solid & coolant through

Indexable Insert Thread Mills



Solid Carbide Mini Thread Mills

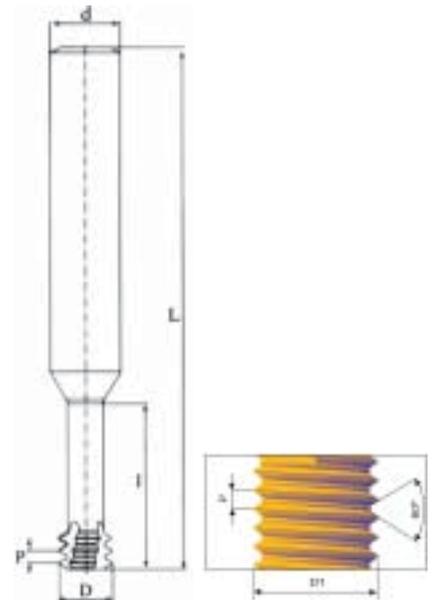
ISO tools for internal thread depth up to 2 x D1

Designation	Pitch mm	D ¹	d	D	No. of flutes	l	L
MTS0250C180.4ISO	0.40	M2	1/4	.061	3	.18	2.5
MTS0250C200.45ISO	0.45	M2.2	1/4	.065	3	.20	2.5
MTS0250C220.45ISO	0.45	M2.5	1/4	.077	3	.22	2.5
MTS0250C260.5ISO	0.50	M3	1/4	.093	3	.26	2.5
MTS0250C300.6ISO	0.60	M3.5	1/4	.108	3	.30	2.5
MTS0250C350.7ISO	0.70	M4	1/4	.122	3	.35	2.5
MTS0250C490.8ISO	0.80	M5	1/4	.150	3	.49	2.5
MTS0250C551.0ISO	1.00	M6	1/4	.183	3	.55	2.5
MTS0250C711.25ISO	1.25	M8	1/4	.234	3	.71	2.5



ISO tools for internal thread depth up to 3 x D1

Designation	Pitch mm	D ¹	d	D	No. of flutes	l	L
MTS0250C300.45ISO	0.45	M2.5	1/4	.077	3	.30	2.5
MTS0250C370.5ISO	0.50	M3	1/4	.093	3	.37	2.5
MTS0250C490.7ISO	0.70	M4	1/4	.122	3	.49	2.5
MTS0250C630.8ISO	0.80	M5	1/4	.150	3	.63	2.5
MTS0250C791.0ISO	1.00	M6	1/4	.183	3	.79	2.5
MTS0250C941.25ISO	1.25	M8	1/4	.234	3	.94	2.5



UN tools for internal thread depth up to 2 x D1

Designation	Pitch mm	UNC	UNF	d	D	No. of flutes	l	L
MTS0250C1572UN	72		1	1/4	.057	3	.15	2.5
MTS0250C1564UN	64	1	2	1/4	.055	3	.15	2.5
MTS0250C1756UN	56	2	3	1/4	.065	3	.17	2.5
MTS0250C2048UN	48	3	4	1/4	.075	3	.20	2.5
MTS0250C2540UN	40	4		1/4	.083	3	.25	2.5
MTS0250C2840UN	40	5	6	1/4	.096	3	.28	2.5
MTS0250C3536UN	36		8	1/4	.130	3	.35	2.5
MTS0250C2832UN	32	6		1/4	.100	3	.28	2.5
MTS0250C3732UN	32	8	10	1/4	.126	3	.37	2.5
MTS0250C5728UN	28		1/4	1/4	.197	3	.57	2.5
MTS0250C4224UN	24	10, 12		1/4	.138	3	.42	2.5
MTS0312C6724UN	24		5/16	5/16	.260	3	.67	2.5
MTS0250C5520UN	20	1/4		1/4	.187	3	.55	2.5

Our new Mini Thread Mills are specially designed to produce internal threads in very small bores.

Thanks to their unique design, accuracy and high quality sub-micron carbide grade with TiAlN coating the following benefits are obtained:

- threading from #1-72 UNF
- high cutting speeds
- short cycle times
- low cutting forces
- no broken tap in workpiece
- threading up to shoulder in blind holes
- threading of hardened materials

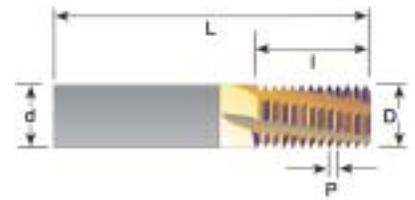
UN tools for internal thread depth up to 3 x D1

Designation	Pitch mm	UNC	UNF	d	D	No. of flutes	l	L
MTS0250C3840UN	40	5	6	1/4	.096	3	.38	2.5
MTS0250C4932UN	32	8	10	1/4	.126	3	.49	2.5
MTS0250C7528UN	28		1/4	1/4	.197	3	.75	2.5
MTS0312C9424UN	24		5/16	5/16	.260	3	.94	2.5
MTS0250C7520UN	20	1/4		1/4	.187	3	.75	2.5

Solid Carbide Helical Thread Mills

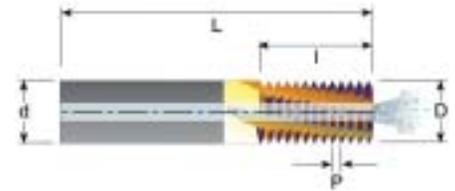
NPT tools for internal & external threading

Designation	Pitch TPI	standard	d	D	No. of flutes	l	L
MT0250C0427NPT	27	1/8	1/4	.250	3	.39	2.5
MT0312C0618NPT	18	1/4 - 3/8	5/16	.312	3	.58	2.5
MT0500D0814NPT	14	1/2 - 3/4	1/2	.500	4	.82	3.0
MT0625D1111.5NPT	11.5	1 - 2	5/8	.625	4	1.09	4.0
MT0750D168NPT	8	> 2-1/2	3/4	.750	4	1.56	4.0



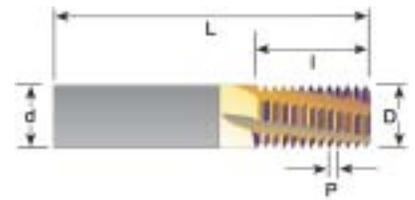
NPT tools for internal & external threading

Designation	Pitch TPI	standard	d	D	No. of flutes	l	L
MTB0312C0427NPT	27	1/8	5/16	.299	3	.43	2.5
MTB0375D0618NPT	18	1/4 - 3/8	3/8	.375	4	.64	3.0
MTB0625D0814NPT	14	1/2 - 3/4	5/8	.610	4	.89	4.0
MTB0750D1111.5NPT	11.5	1 - 2	3/4	.750	4	1.17	4.0



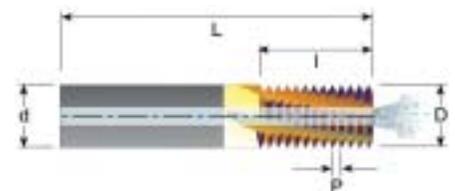
NPTF tools for internal & external threading

Designation	Pitch TPI	standard	d	D	No. of flutes	l	L
MT0250C0427NPTF	27	1/8	1/4	.250	3	.39	2.5
MT0312C0618NPTF	18	1/4 - 3/8	5/16	.312	3	.58	2.5
MT0500D0814NPTF	14	1/2 - 3/4	1/2	.500	4	.82	3.0
MT0625D1111.5NPTF	11.5	1 - 2	5/8	.625	4	1.09	4.0
MT0750D168NPTF	8	>2-1/2	3/4	.750	4	1.56	4.0



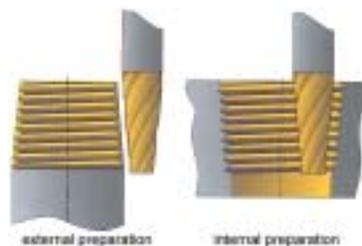
NPTF tools for internal & external threading

Designation	Pitch TPI	standard	d	D	No. of flutes	l	L
MTB0312C0427NPTF	27	1/8	5/16	.299	3	.43	2.5
MTB0375D0618NPTF	18	1/4 - 3/8	3/8	.375	4	.64	3.0
MTB0625D0814NPTF	14	1/2 - 3/4	5/8	.610	4	.89	4.0
MTB0750D1111.5NPTF	11.5	1 - 2	3/4	.750	4	1.17	4.0



solid carbide tapered end mills

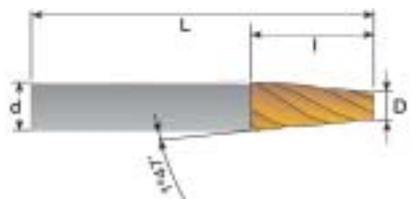
used for milling preparation of tapered threads, before the thread milling operation



Advantages

- increase the tool life of thread milling cutters and indexable inserts
- equal and uniform load along the cutting edge of the thread mill cutter
- shorter machining time during the thread milling operation, due to the tapered preparation

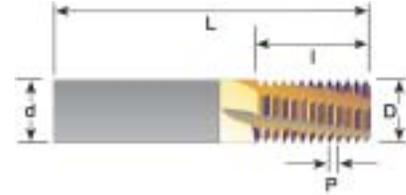
Designation	d	D	l	L	No. of flutes	size
SC0375D09	3/8	.32	.95	3	4	NPT(F) 1/8 - 1
SC0500D12	1/2	.41	1.45	4	4	NPT(F) 1/4 - 3



Solid Carbide Helical Thread Mills

UN tools for internal threading

Designation	Pitch TPI	UNC	UNF	UNEF	d	D	No. of flutes	l	L
MT0250C0240UN	40	5			1/4	.098	3	.24	2.5
MT0250C0232UN	32	8	10	12	1/4	.126	3	.27	2.5
MT0250C0428UN	28		1/4		1/4	.157	3	.45	2.5
MT0250C0528UN	28			7/16 - 1/2	1/4	.236	3	.57	2.5
MT0250C0624UN	24		5/16 - 3/8		1/4	.197	3	.56	2.5
MT0312C0824UN	24			9/16 - 5/8	5/16	.276	3	.81	2.5
MT0250C0520UN	20	1/4			1/4	.177	3	.48	2.5
MT0312C0820UN	20		7/16 - 1/2		5/16	.276	3	.83	2.5
MT0500E1120UN	20			3/4 - 1	1/2	.472	5	1.08	3.0
MT0250C0618UN	18	5/16			1/4	.197	3	.58	2.5
MT0375D1018UN	18		9/16 - 5/8	1-1/8 - 1-5/8	3/8	.375	4	1.03	3.0
MT0250C0716UN	16	3/8			1/4	.236	3	.66	2.5
MT0500D1216UN	16		3/4		1/2	.472	4	1.22	3.0
MT0312C0814UN	14	7/16			5/16	.276	3	.82	2.5
MT0625E1514UN	14		7/8		5/8	.591	5	1.46	4.0
MT0312C0913UN	13	1/2			5/16	.313	3	.88	2.5
MT0375C1012UN	12	9/16			3/8	.375	3	1.04	3.0
MT0625E1612UN	12		1 - 1-1/2		5/8	.625	5	1.63	4.0
MT0375C1111UN	11	5/8			3/8	.375	3	1.14	3.0
MT0500C1410UN	10	3/4			1/2	.472	3	1.35	3.0
MT0625C159UN	9	7/8			5/8	.591	3	1.50	4.0
MT0625C178UN	8	1			5/8	.625	3	1.69	4.0
MT0750D177UN	7	1-1/8 - 1-1/4			3/4	.750	4	1.78	4.0

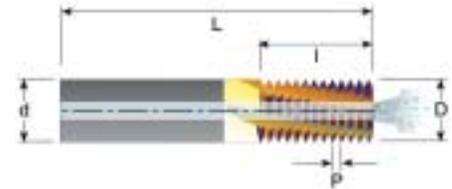


*thread is created
in a single pass*

*helical flutes allow
smooth cutting action*

UN tools for internal threading

Designation	Pitch TPI	UNC	UNF	UNEF	d	D	No. of flutes	l	L
MTB0250C0232UN	32	8	10	12	1/4	.126	3	.27	2.5
MTB0250C0428UN	28		1/4		1/4	.197	3	.44	2.5
MTB0250C0528UN	28			7/16 - 1/2	1/4	.250	3	.56	2.5
MTB0312C0524UN	24		5/16		5/16	.260	3	.56	2.5
MTB0312D0824UN	24			3/8 - 5/8	5/16	.312	4	.81	2.5
MTB0250C0420UN	20	1/4			1/4	.185	3	.48	2.5
MTB0312C0820UN	20		7/16		5/16	.312	3	.83	2.5
MTB0375D0820UN	20		1/2		3/8	.375	4	.88	3.0
MTB0500E1020UN	20			3/4 - 1	1/2	.500	5	1.07	4.0
MTB0250C0518UN	18	5/16			1/4	.220	3	.58	2.5
MTB0500D1018UN	18		9/16 - 5/8	1-1/8 - 1-5/8	1/2	.445	4	1.03	4.0
MTB0312C0616UN	16	3/8			5/16	.264	3	.66	2.5
MTB0500D1216UN	16		3/4		1/2	.500	4	1.22	4.0
MTB0312C0814UN	14	7/16			5/16	.303	3	.82	2.5
MTB0625E1414UN	14		7/8		5/8	.625	5	1.46	4.0
MTB0375C0813UN	13	1/2			3/8	.362	3	.89	3.0
MTB0500C1012UN	12	9/16			1/2	.413	3	1.04	4.0
MTB0625E1612UN	12		1 - 1-1/2		5/8	.625	5	1.63	4.0
MTB0500C1111UN	11	5/8			1/2	.449	3	1.14	4.0
MTB0625D1310UN	10	3/4			5/8	.567	4	1.35	4.0
MTB0625C159UN	9	7/8			5/8	.625	3	1.50	4.0



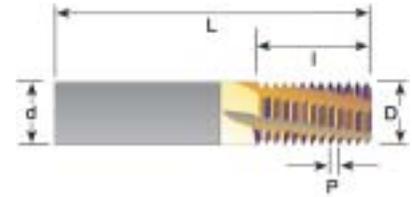
*multi (3-6) flutes
allow higher feed per
revolution for short
cycle times*

*thread close to
shoulder in blind holes*

Solid Carbide Helical Thread Mills

ISO tools for internal threading

Designation	Pitch mm	M coarse	M fine	d	D	No. of flutes	l	L
MT0250C020.5ISO	0.50	M3	$\emptyset \geq .16$	1/4	.087	3	.21	2.5
MT0250C040.5ISO	0.50		$\emptyset \geq .20$	1/4	.150	3	.41	2.5
MT0250C030.7ISO	0.70	M4	$\emptyset \geq .20$	1/4	.122	3	.29	2.5
MT0250C040.75ISO	0.75		$\emptyset \geq .24$	1/4	.177	3	.40	2.5
MT0250C040.8ISO	0.80	M5	$\emptyset \geq .24$	1/4	.142	3	.36	2.5
MT0250C041.0ISO	1.00	M6	$\emptyset \geq .28$	1/4	.157	3	.41	2.5
MT0250C061.0ISO	1.00	M6	$\emptyset \geq .28$	1/4	.157	3	.57	2.5
MT0250C051.0ISO	1.00		$\emptyset \geq .35$	1/4	.236	3	.49	2.5
MT0312D071.0ISO	1.00		$\emptyset \geq .39$	5/16	.313	4	.65	2.5
MT0250C061.25ISO	1.25	M8	$\emptyset \geq .39$	1/4	.197	3	.57	2.5
MT0250C071.25ISO	1.25	M8	$\emptyset \geq .39$	1/4	.197	3	.76	2.5
MT0312C071.5ISO	1.50	M10	$\emptyset \geq .47$	5/16	.276	3	.68	2.5
MT0312C091.5ISO	1.50	M10	$\emptyset \geq .47$	5/16	.276	3	.98	2.5
MT0375D091.5ISO	1.50		$\emptyset \geq .55$	3/8	.375	4	.86	3.0
MT0625F131.5ISO	1.50		$\emptyset \geq .79$	5/8	.625	6	1.33	4.0
MT0312C081.75ISO	1.75	M12	$\emptyset \geq .55$	5/16	.313	3	.79	2.5
MT0312C111.75ISO	1.75	M12	$\emptyset \geq .55$	5/16	.313	3	1.14	2.5
MT0375C112.0ISO	2.00	M16	$\emptyset \geq .67$	3/8	.375	3	1.06	3.0
MT0375C152.0ISO	2.00	M16	$\emptyset \geq .67$	3/8	.375	3	1.54	3.0
MT0500D112.0ISO	2.00		$\emptyset \geq .71$	1/2	.472	4	1.06	3.0
MT0750F162.0ISO	2.00		$\emptyset \geq 1.02$	3/4	.750	6	1.61	4.0
MT0625D132.5ISO	2.50	M20	$\emptyset \geq .87$	5/8	.551	4	1.33	4.0
MT0625D192.5ISO	2.50	M20	$\emptyset \geq .87$	5/8	.551	4	1.92	4.0
MT0625C163.0ISO	3.00	M24	$\emptyset \geq .98$	5/8	.625	3	1.59	4.0
MT0625C233.0ISO	3.00	M24	$\emptyset \geq .98$	5/8	.625	3	2.31	4.0
MT0750C173.0ISO	3.00	M28	$\emptyset \geq 1.10$	3/4	.750	4	1.71	4.0

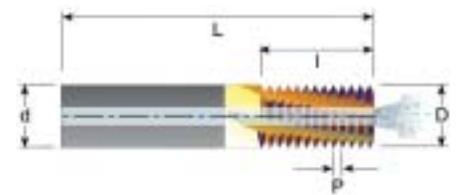


the same tool can be used for many different materials

the same tool can be used for R.H. and L.H. threads

ISO tools for internal threading

Designation	Pitch mm	M coarse	M fine	d	D	No. of flutes	l	L
MTB0250C040.5ISO	0.5		$\emptyset \geq .20$	1/4	.150	3	.41	2.5
MTB0250C020.7ISO	0.7	M4	$\emptyset \geq .20$	1/4	.122	3	.29	2.5
MTB0250C040.75ISO	0.75		$\emptyset \geq .24$	1/4	.177	3	.40	2.5
MTB0250C030.8ISO	0.8	M5	$\emptyset \geq .24$	1/4	.150	3	.36	2.5
MTB0250C041.0ISO	1.0	M6	$\emptyset \geq .28$	1/4	.181	3	.41	2.5
MTB0250C061.0ISO	1.0	M6	$\emptyset \geq .28$	1/4	.181	3	.60	2.5
MTB0250C051.0ISO	1.0		$\emptyset \geq .35$	1/4	.250	3	.50	2.5
MTB0312D061.0ISO	1.0		$\emptyset \geq .39$	5/16	.312	4	.65	2.5
MTB0250C051.25ISO	1.25	M8	$\emptyset \geq .39$	1/4	.250	3	.57	2.5
MTB0250C071.25ISO	1.25	M8	$\emptyset \geq .39$	1/4	.250	3	.76	2.5
MTB0312C061.5ISO	1.5	M10	$\emptyset \geq .47$	5/16	.307	3	.67	2.5
MTB0312C091.5ISO	1.5	M10	$\emptyset \geq .47$	5/16	.307	3	.98	2.5
MTB0375D081.5ISO	1.5		$\emptyset \geq .55$	3/8	.375	4	.86	3.0
MTB0625F131.5ISO	1.5		$\emptyset \geq .79$	5/8	.625	6	1.33	4.0
MTB0375C071.75ISO	1.75	M12	$\emptyset \geq .47$	3/8	.354	3	.79	3.0
MTB0375C111.75ISO	1.75	M12	$\emptyset \geq .47$	3/8	.354	3	1.14	3.0
MTB0375C102.0ISO	2.0	M14	$\emptyset \geq .59$	3/8	.375	3	1.06	3.0
MTB0500D102.0ISO	2.0	M16	$\emptyset \geq .67$	1/2	.465	4	1.06	4.0
MTB0500D152.0ISO	2.0	M16	$\emptyset \geq .67$	1/2	.465	4	1.54	4.0
MTB0750F162.0ISO	2.0		$\emptyset \geq .94$	3/4	.750	6	1.61	4.0



excellent surface finish

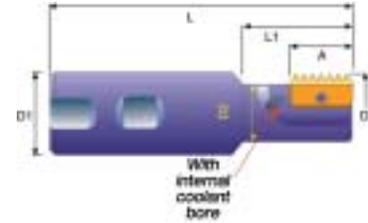
low cutting pressure allows for machining thin wall parts

Indexable Thread Mills

single insert toolholders

Designation	A mm	D	D ¹	D ²	L	L ¹	insert screw	torx key
SR0375H12	12	.37	.75	.30	3.35	.51	S12	K12
SR0390H12*	12	.39	.75	.30	3.35	.51	S12	K12
SR0500F14	14	.50	.75	.37	2.95	.70	S14	K14
SR0540F14	14	.54	.75	.38	2.98	.77	S14	K14
SR0570H14	14	.57	.75	.41	3.20	1.00	S14	K14
SR0670H14	14	.67	.75	.53	3.35	1.18	S14	K14
SR0790H21	21	.79	.75	.61	3.70	1.57	S21	K21
SR1140J30	30	1.14	1.00	.91	4.27	1.85	S30	K30
SR1730M40	40	1.73	1.50	1.38	6.02	3.19	S40	K40

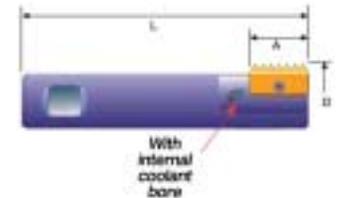
* for conic inserts: 12-18 NPT, 12-18 NPTF, 12-19 BSPT



long shank toolholders

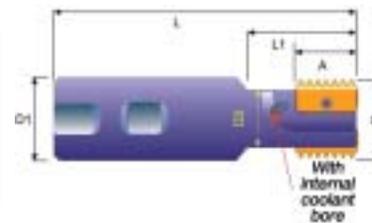
Designation	A mm	D	D ¹	L	insert screw	torx key
SR0940K21	21	0.94	0.75	5.00	S21	K21
SR1240M30	30	1.24	1.00	6.00	S30	K30
SR1500M30	30	1.50	1.25	6.00	S30	K30

for holders with long overhang reduce the cutting speed and feed rate between 20-40% (depends on workpiece material, pitch and over hang)



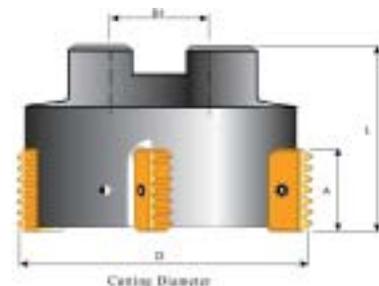
twin insert toolholders

Designation	A mm	D	D ¹	D ²	L	L ¹	No. of inserts	insert screw	torx key
SR0790H142	14	.79	.75	.63	3.66	1.57	2	S14	K14
SR1180J212	21	1.18	1.00	.95	4.25	1.97	2	S21	K21
SR1580L302	30	1.57	1.25	1.18	5.12	2.80	2	S30	K30
SR1970M402	40	1.97	1.50	1.49	6.02	3.35	2	S40	K40



multi insert toolholders

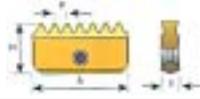
Designation	A mm	D	D ¹	L	No. of inserts	insert screw	torx key
SR2480C215	21	2.48	.75	1.97	5	S21	K21
SR2480C304	30	2.48	.75	1.97	4	S30	K30
SR3150D304	30	3.15	1.00	2.16	4	S30	K30
SR3940D304	30	3.94	1.25	2.36	4	S30	K30
SR3150D404	40	3.15	1.00	2.56	4	S40	K40
SR3940E404	40	3.94	1.25	2.76	4	S40	K40



Long carbide shank holders are also available, please inquire for your deep thread milling applications.

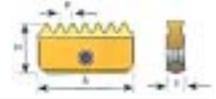
Inserts for Indexable Thread Mills

UN inserts



Pitch TPI		Insert Size = A				
		12mm .472	14mm .551	21mm .827	30mm 1.181	40mm 1.575
32	Ext.		14 E 32 UN			
	Int.	*12 I 32 UN	14 I 32 UN			
28	Ext.		14 E 28 UN			
	Int.	*12 I 28 UN	14 I 28 UN			
27	Ext.					
	Int.		14 I 27 UN			
24	Ext.		14 E 24 UN	21 E 24 UN		
	Int.	*12 I 24 UN	14 I 24 UN	21 I 24 UN		
20	Ext.		14 E 20 UN	21 E 20 UN	30 E 20 UN	
	Int.	*12 I 20 UN	14 I 20 UN	21 I 20 UN	30 I 20 UN	
18	Ext.		14 E 18 UN	21 E 18 UN	30 E 18 UN	
	Int.	*12 I 18 UN	14 I 18 UN	21 I 18 UN	30 I 18 UN	
16	Ext.		14 E 16 UN	21 E 16 UN	30 E 16 UN	40 E 16 UN
	Int.	*12 I 16 UN	14 I 16 UN	21 I 16 UN	30 I 16 UN	40 I 16 UN
14	Ext.		14 E 14 UN	21 E 14 UN	30 E 14 UN	40 E 14 UN
	Int.		14 I 14 UN	21 I 14 UN	30 I 14 UN	40 I 14 UN
12	Ext.		14 E 12 UN	21 E 12 UN	30 E 12 UN	40 E 12 UN
	Int.		14 I 12 UN	21 I 12 UN	30 I 12 UN	40 I 12 UN
10	Ext.			21 E 10 UN	30 E 10 UN	40 E 10 UN
	Int.			21 I 10 UN	30 I 10 UN	40 I 10 UN
8	Ext.				30 E 8 UN	40 E 8 UN
	Int.			21 I 8 UN	30 I 8 UN	40 I 8 UN
6	Ext.				30 E 6 UN	40 E 6 UN
	Int.				30 I 6 UN	40 I 6 UN
4.5	Ext.					40 E 4.5 UN
	Int.					40 I 4.5 UN
4	Ext.					40 E 4 UN
	Int.					40 I 4 UN

ISO inserts



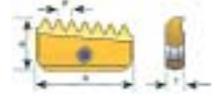
Pitch TPI		Insert Size = A				
		12mm .472	14mm .551	21mm .827	30mm 1.181	40mm 1.575
0.5	Ext.					
	Int.	*12 I 0.5 ISO	14 I 0.5 ISO			
0.75	Ext.		14 E 0.75 ISO			
	Int.	*12 I 0.75 ISO	14 I 0.75 ISO			
1.0	Ext.		14 E 1.0 ISO	21 E 1.0 ISO		
	Int.	*12 I 1.0 ISO	14 I 1.0 ISO	21 I 1.0 ISO		
1.25	Ext.		14 E 1.25 ISO			
	Int.	*12 I 1.25 ISO	14 I 1.25 ISO			
1.5	Ext.		14 E 1.5 ISO	21 E 1.5 ISO	30 E 1.5 ISO	40 E 1.5 ISO
	Int.	*12 I 1.5 ISO	14 I 1.5 ISO	21 I 1.5 ISO	30 I 1.5 ISO	40 I 1.5 ISO
1.75	Ext.		14 E 1.75 ISO			
	Int.		14 I 1.75 ISO	21 I 1.75 ISO		
2.0	Ext.		14 E 2.0 ISO	21 E 2.0 ISO	30 E 2.0 ISO	40 E 2.0 ISO
	Int.		14 I 2.0 ISO	21 I 2.0 ISO	30 I 2.0 ISO	40 I 2.0 ISO
2.5	Ext.		14 E 2.5 ISO	21 E 2.5 ISO		
	Int.		14 I 2.5 ISO	21 I 2.5 ISO		
3.0	Ext.			21 E 3.0 ISO	30 E 3.0 ISO	40 E 3.0 ISO
	Int.			21 I 3.0 ISO	30 I 3.0 ISO	40 I 3.0 ISO
3.5	Ext.				30 E 3.5 ISO	
	Int.			21 I 3.5 ISO	30 I 3.5 ISO	40 I 3.5 ISO
4.0	Ext.				30 E 4.0 ISO	40 E 4.0 ISO
	Int.				30 I 4.0 ISO	40 I 4.0 ISO
4.5	Ext.					
	Int.				30 I 4.5 ISO	40 I 4.5 ISO
5.0	Ext.					40 E 5.0 ISO
	Int.					40 I 5.0 ISO
5.5	Ext.					40 E 5.5 ISO
	Int.					40 I 5.5 ISO
6.0	Ext.					40 E 6.0 ISO
	Int.					40 I 6.0 ISO

NPTF inserts**



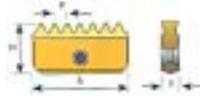
Pitch TPI		Insert Size = A				
		12mm .472	14mm .551	21mm .827	30mm 1.181	40mm 1.575
18	Ext.	12-18 NPTF	14-18 NPTF			
	Int.		14-14 NPTF	21-14 NPTF		
11.5	Ext.			21-11.5 NPTF	30-11.5 NPTF	40-11.5 NPTF
	Int.				30-8 NPTF	40-8 NPTF

NPT inserts**



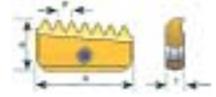
Pitch TPI		Insert Size = A				
		12mm .472	14mm .551	21mm .827	30mm 1.181	40mm 1.575
18	Ext.	12-18 NPT	14-18 NPT			
	Int.		14-14 NPT	21-14 NPT		
11.5	Ext.			21-11.5 NPT	30-11.5 NPT	40-11.5 NPT
	Int.				30-8 NPT	40-8 NPT

WHIT inserts**



Pitch TPI		Insert Size = A				
		12mm .472	14mm .551	21mm .827	30mm 1.181	40mm 1.575
24	Ext.		14-24 W			
	Int.					
20	Ext.		14-20 W	21-20 W		
	Int.					
19	Ext.	*12-19 W	14-19 W	21-19 W		
	Int.					
16	Ext.		14-16 W	21-16 W	30-16 W	
	Int.					
14	Ext.		14-14 W	21-14 W	30-14 W	
	Int.					
11	Ext.			21-11 W	30-11 W	40-11 W
	Int.					40-8 W

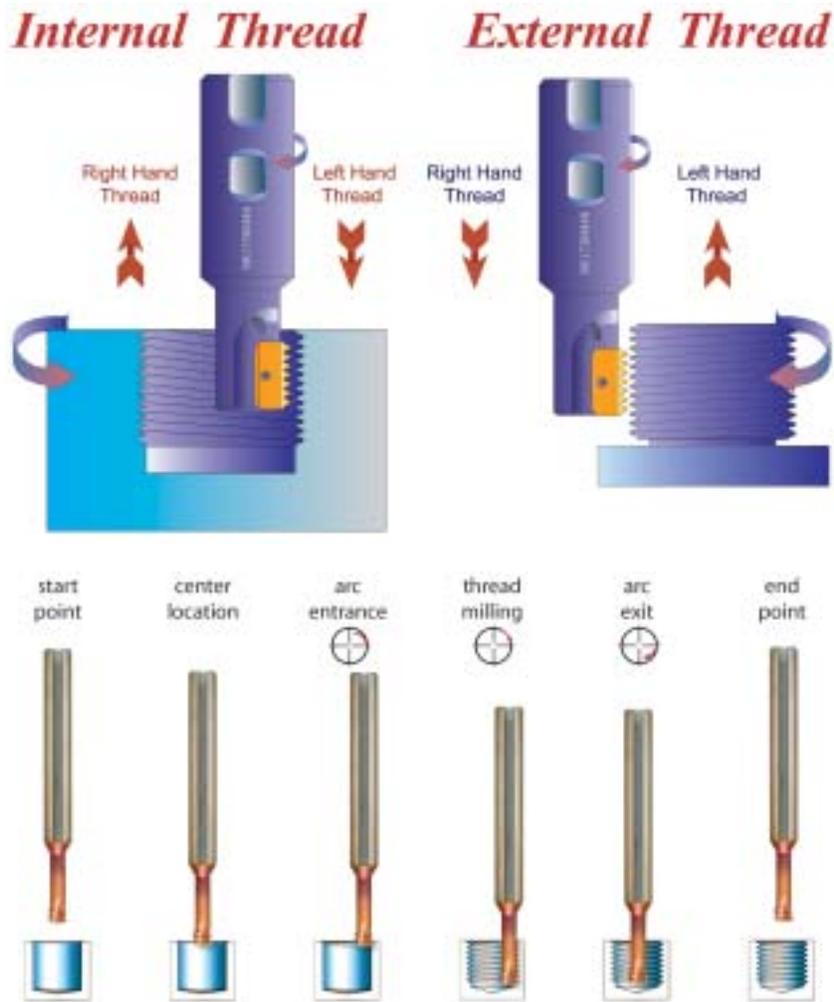
BSPT inserts**



Pitch TPI		Insert Size = A				
		12mm .472	14mm .551	21mm .827	30mm 1.181	40mm 1.575
19	Ext.	12-19 BSPT	14-19 BSPT			
	Int.		14-14 BSPT	21-14 BSPT		
11	Ext.			21-11 BSPT	30-11 BSPT	40-11 BSPT
	Int.					

** Insert with one cutting edge
** Same insert for internal and external thread

Application Examples



comparison table; mini thread mill vs. taps

features	solid carbide thread mills	taps
thread surface quality	high	medium
thread geometry	very accurate	medium
thread tolerances	4h, 5h, 6h, with std. cutter	6h with standard tap / 4h with specific tap
machining times	shorter or same as tap	short
machining load	very low	high
tool breakage	almost not possible	could happen often
range of thread diameters	wide range of diameters	specific tap for each diameter
right / left hand threading	same cutter	specific tap for each
geometric shape	full profile	partial profile

TYSON TOOL

TYSON TOOL COMPANY LIMITED
 75 ORMONT DRIVE, TORONTO, ONTARIO, M9L-2S3
 TEL: (416) 746-3688 ~~ FAX: (416) 746-5415
 INTERNET: www.tysontool.com ~~ E-MAIL: sales@tysontool.com

Available from:

Specifications are subject to change without notice. No responsibility for errors and/or printing errors will be accepted.