



ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing



Drilling



Boring



Reaming



Burnishing



Threading

► Solid Carbide Thread Mills



Specials

AccuThread™ 856



The Foundation

Since 1941, Allied Machine & Engineering has provided dependable and practical holmaking solutions to the world. What was once a small job shop in Ohio is now a worldwide leader in cutting tool technology. With three manufacturing facilities in Ohio, one in Georgia, another in Germany, and headquarters in both the United States and Europe, Allied Machine is positioned to bring innovative solutions and technical expertise directly to the customers' hands.



The Beginning



Harold E. Stokey founded Allied Machine & Engineering to aid the war effort, manufacturing taper bearing lock nuts for the production of M1 tanks. Years later, after a sales meeting gone wrong, Stokey possessed a warehouse stocked with spade drill inserts. He set forth into the industry that would become Allied Machine's thriving identity: holmaking.

The T-A®

When Harold's son, William H. Stokey, became the president and CEO, he developed the Throw Away—or T-A—spade drill insert system. The T-A revolutionized the holmaking industry, launching Allied Machine ahead of the competition. Since then, numerous innovations and advancements have been created from the T-A's inspiration.



The Innovation

Since the development of the T-A, Allied Machine has expanded its product offering to support a vast range of customer applications, including large diameter and deep hole drilling, boring, reaming, burnishing, porting, and threading.



The Future

Allied Machine is constantly investing in the brightest and sharpest minds, shaping a future filled with success and quality for customers around the world.



Steve Stokey
Executive Vice President

William H. Stokey
President and CEO

Mike Stokey
Executive Vice President



ALLIED MACHINE & ENGINEERING

Holemaking Solutions for Today's Manufacturing

WOHLHAUPTER



SUPERION

CRITERION

DRILLING

High Penetration



GEN3SYS® XT Pro



GEN3SYS® XT



ASC 320®

General Production

(certain sizes are ideal for deep hole drilling and/or large diameter drilling)



GEN2 T-A®



Original T-A®



High Performance



Universal

Large Diameter



Revolution Drill®



Opening Drill®

Large Diameter / Deep Hole



APX Drill



BT-A Drill

Deep Hole



Guided T-A® Drill
(special)

Porting



AccuPort 432®

Structural Steel



GEN3SYS® XT



T-A®

BORING



WOHLHAUPTER®

Bringing you the finest in precision cutting tools

CRITERION™

REAMING



ALVAN®
Reaming Systems

S.C.A.M.I.®

BURNISHING



S.C.A.M.I.®
Roller Burnishing

THREADING



AccuThread™ 856
Pin Style Indexable



AccuThread™ 856
Bolt-in Style Indexable



AccuThread™ 856
Solid Carbide



ThreadMills USA
Solid Carbide



SPECIALS



Insta-Quote™
Online custom tool builder and quote generator



i-Form
Custom indexable drill / form tool system

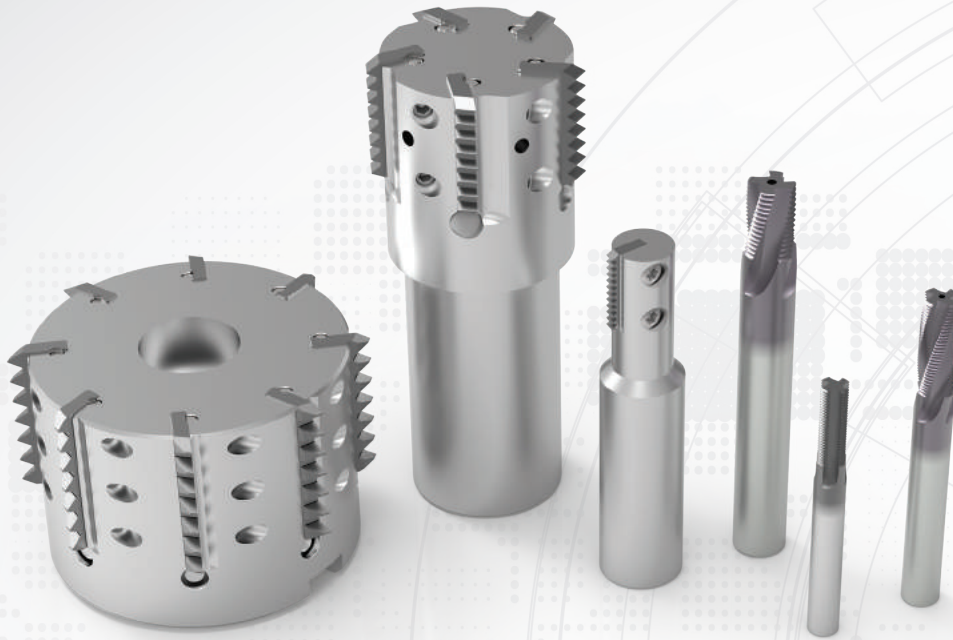
Engineered Specials

If your special holmaking needs cannot be met with the Insta-Quote system, Allied Machine can specially engineer ANY product to make your application a success. Simply contact your local Field Sales Engineer or the Allied Machine Application Engineering department for assistance with creating your special tooling. Let Allied Machine resolve your challenges today.

Allied Machine & Engineering patent information can be found at www.alliedmachine.com/patents

Threading Solutions

Solid Carbide and Indexable Thread Mills | AccuThread™ 856 | ThreadMills USA



Any Thread, Any Time

Allied Machine's thread milling product line has developed into a comprehensive range of high precision tooling that offers outstanding productivity with exceptional levels of tool life and thread accuracy. The thread mill range covers both solid carbide and indexable replaceable insert tools with an extensive range of thread forms.

Our thread milling product line has been specifically designed to provide customers with a wide range of options. This is achieved by offering two thread mill ranges within our product lineup: the low cost, general production ThreadMills USA range, and the high performance, high productivity AccuThread™ range.

Online programmer
available 24/7

Solid carbide and
indexable insert styles

Large range of
thread form options

Applicable Industries



Aerospace



Agriculture



Automotive



Firearms



General
Machining



Medical



Oil & Gas



Renewable
Energy



Tool, Mold
& Die

Your safety and the safety of others is very important. This catalog contains important safety messages. Always read and follow all safety precautions.



This triangle is a safety hazard symbol. It alerts you to potential safety hazards that can cause tool failure and serious injury.

When you see this symbol in the catalog, look for a related safety message that may be near this triangle or referred to in the nearby text.

There are safety signal words also used in the catalog. Safety messages follow these words.

WARNING

WARNING (shown above) means that failure to follow the precautions in this message could result in tool failure and serious injury.

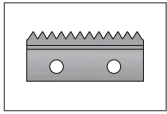
NOTICE means that failure to follow the precautions in this message could result in damage to the tool or machine but not result in personal injury.

NOTE and **IMPORTANT** are also used. These are important that you read and follow but are not safety-related.

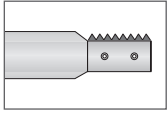
Visit www.alliedmachine.com for the most up-to-date information and procedures.

Reference Icons

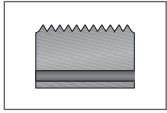
The following icons will appear throughout the catalog to help you navigate between products.

**Bolt-in Style Inserts**

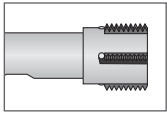
Refers to the available bolt-in style thread mill insert options

**Bolt-in Style Insert Holders**

Refers to the range of holder options available for bolt-in style inserts

**Pin Style Inserts**

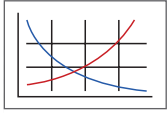
Refers to the available pin style thread mill insert options.

**Pin Style Insert Holders**

Refers to the range of holder options available for pin style inserts

**Setup / Assembly Information**

Detailed instructions and information regarding the corresponding part(s)

**Recommended Cutting Data**

Speed and feed recommendations for optimum and safe threading

**Coolant Through Option**

Indicates that the product is coolant through

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High Performance Threading Solutions



THREAD MILLING DONE **RIGHT**



Solid Carbide Thread Mills	Notes
AccuThread™ 856 	- Allied Machine's proprietary AM210® coating yields a 25-50% increase in tool life over competitor products - Standard cutting lengths allow for multiple applications without the need for special thread mills - Helical flute offers increased strength and rigidity when cutting forces are applied
ThreadMills USA 	- Helical flute offers increased strength and rigidity when cutting forces are applied - High quality for consistent, predictable production - Coolant through options available - TiAlN coating improves tool life versus uncoated tools 

Indexable Insert Thread Mills	Notes
AccuThread™ 856 Bolt-in Style 	- Thread mill holders are manufactured from stainless steel that is engineered to dampen vibration during operation - Extensive range of thread forms with two thread lengths - Can produce left or right handed threads
AccuThread™ 856 Pin Style 	- Patented pin style locking system ensures unsurpassed repeatability - Thread mill holders are manufactured from stainless steel that is engineered to dampen vibration during operation - Extensive range of thread forms with two thread lengths
AccuThread™ 856 Indexable Inserts  Bolt-in Style  Pin Style	- Full profiles present on all inserts allow 100% thread form against 65-75% for tapping - Allied Machine's premium carbide allows for extended tool life while providing high quality thread forms - Allied Machine's proprietary AM210® coating yields a 25-50% increase in tool life over competitor products

Online Tools

Insta-Code™

Find your thread mill. Create your program.



The user-friendly software lets you choose the best thread mill product for your application and create the program code for your machine. Insta-Code is available across multiple platforms, including the mobile device app, the PC download app (that can be used offline), and the online web app available 24/7 at www.alliedmachine.com.

Eliminate the wait. Get your program now.



Insta-Code also has a
Cycle Time Calculator

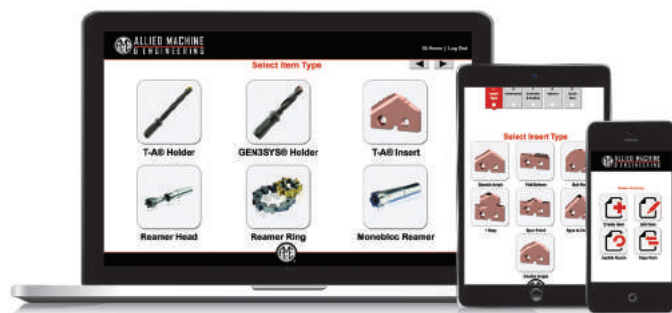
Insta-Quote™

Design, create, and quote tools in minutes.

Available online 24/7



Solid Carbide Thread Mills (both AccuThread™ 856 and ThreadMills USA)



Insta-Quote is the online system that lets you design special tooling for your specific application. Receive your drawing and quote within seconds after you complete your design.

Now, you can quickly find the exact thread mill you need with Insta-Quote. Go online today and let Insta-Quote help solve your applications. After all, why should you do all the work?

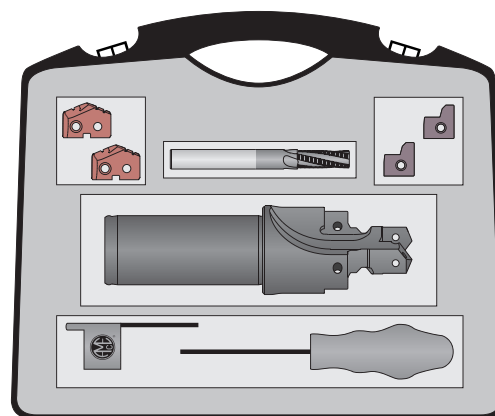
Solid Carbide Styles and Thread Forms

Thread Forms	AccuThread™ 856 - Non-Coolant	ThreadMills USA - Non-Coolant	ThreadMills USA - Coolant Through
Straight BSW			
Helical BSPP, NPS, NPSF, UN, ISO			
Taper Helical BSPT, NPT, NPTF			

The Complete Package

Producing fully finished threaded hydraulic ports has never been easier. The Port and Thread Finishing Kit includes the AccuPort 432® port contour cutter with a dedicated AccuThread 856 solid carbide thread mill in a single kit. You also receive the T-A® inserts and port form inserts needed to complete the assembly.

Port kits incorporate the AccuThread 856 solid carbide thread mills to increase the manufacturing flexibility by allowing hydraulic ports to be produced in just two operations. In addition, where a unique port profile is required, Allied Machine provides a dedicated special tooling solution using our extensive tool design and manufacturing experience to meet precise specifications.



NOTE: See Section A9 of our product catalog for the complete list of Port and Thread Finishing Kits.



One Tool, FOUR Operations

- Spot Face
- Port Contour
- Tap Drill
- Spot Drill



NOTE: See Section A92 of our product catalog for full AccuPort 432 product line information.



Product Nomenclature

AccuThread™ 856 Solid Carbide Thread Mills

TM	U	K	0250	–	20	M
1	2	3	4		5	6



1. Thread Mill	2. Thread Class	3. Coating	4. Min Thread Diameter	5. Thread Pitch	6. Shank
TM = Standard HDTM = Heavy duty	U = UN N = NPT, NPTF B = BSPP, BSPT, BSW M = ISO A = AccuPort® specific	K = AM210® U = Uncoated	0250 = 1/4 (English) 0008 = #8 (Number Drill) 0450 = M4.5 (ISO)	20 = UN 20 TPI 075 = ISO 0.75 NPT = All pipe threads will show thread form	Blank = Imperial M = Metric

ThreadMills USA Solid Carbide Thread Mills

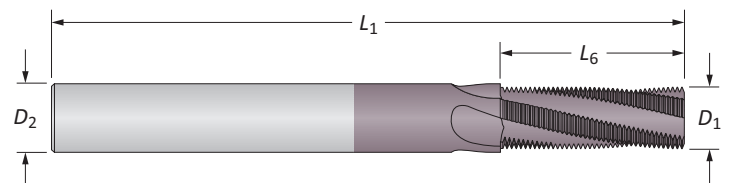
TM	250	20	CH	M
1	2	3	4	5



1. Thread Mill	2. Min Thread Diameter	3. Thread Pitch	4. Optional	5. Shank
TM = TiAIN TMFT = Uncoated HDTM = Heavy duty HDTMFT = Heavy duty uncoated	250 = 1/4 (English) 08 = #8 (Number Drill) 45 = M4.5 (ISO)	20 = UN 20 TPI 075 = ISO 0.75 NPT = All pipe threads will show thread form	CH = Coolant hole DE = Double end NPT = All pipe threads will show thread form	Blank = Imperial M = Metric

Reference Key

Symbol	Attribute
D_1	Maximum cutter diameter
D_2	Shank diameter
L_1	Overall length
L_6	Length of cut



A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

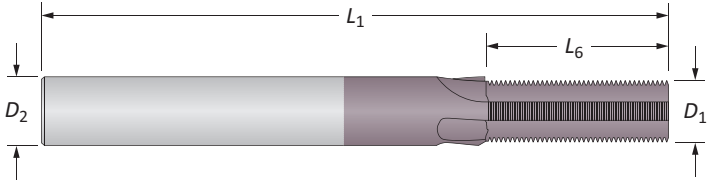
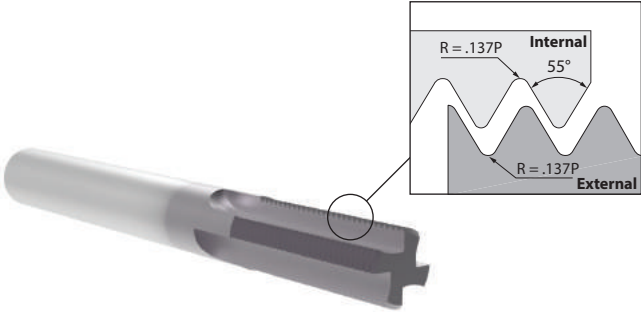
THREADING

X

SPECIALS

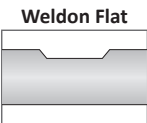
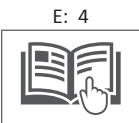
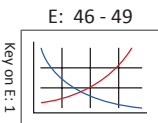
Solid Carbide Thread Mills

BSW | Non-Coolant



BSW | Non-Coolant

		TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.	
					D_1	D_2	L_6	L_1	 ThreadMills USA	 AccuThread™ 856
i	20	1/4	3	0.177	0.250	0.400	2.500	TM20BSW	—	
	18	5/16	3	0.197	0.250	0.445	2.500	TM18BSW	—	
	16	3/8	5	0.276	0.312	0.563	3.000	TM16BSW	—	
	14	7/16	5	0.311	0.312	0.715	3.000	TM14BSW	—	
	12	1/2	5	0.354	0.375	0.750	3.500	TM12BSW	—	
	11	5/8	5	0.468	0.500	0.910	3.500	TM11BSW	—	
	10	3/4	5	0.468	0.500	1.100	3.500	TM10BSW	—	
	9	7/8	6	0.620	0.625	1.112	4.000	TM9BSW	—	
	8	1	6	0.620	0.625	1.375	4.000	TM8BSW	—	
m	20	1/4	3	4.50	6.00	10.16	58.00	TM20BSWM	TMBK0250-20M	
	18	5/16	3	5.00	6.00	11.29	58.00	TM18BSWM	TMBK0312-18M	
	16	3/8	5	7.00	8.00	14.29	64.00	TM16BSWM	TMBK0375-16M	
	14	7/16	5	7.90	8.00	18.15	64.00	TM14BSWM	TMBK0437-14M	
	12	1/2	5	9.00	10.00	19.10	73.00	TM12BSWM	TMBK0500-12M	
	11	5/8	5	11.90	12.00	23.10	84.00	TM11BSWM	TMBK0625-11M	
	10	3/4	5	11.90	12.00	27.94	84.00	TM10BSWM	TMBK0750-10M	
	9	7/8	6	15.90	16.00	28.23	93.00	TM9BSWM	TMBK0875-9M	
	8	1	6	15.90	16.00	34.94	93.00	TM8BSWM	TMBK1000-8M	



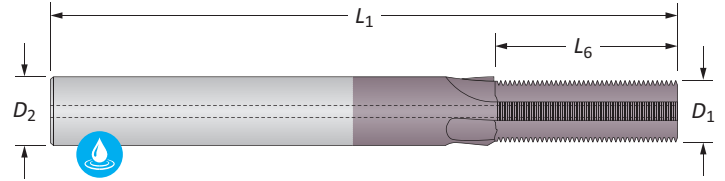
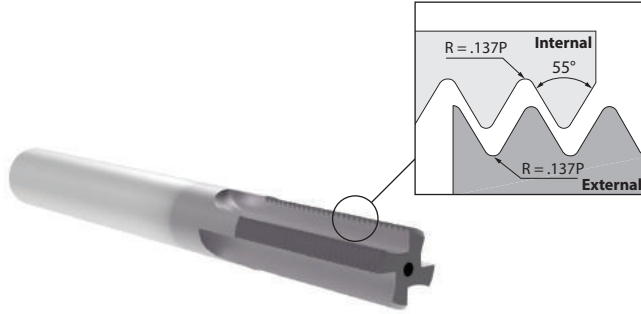
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TW**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)



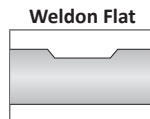
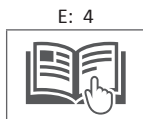
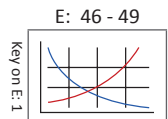
Solid Carbide Thread Mills

BSW | Coolant Through



BSW | Coolant Through

	TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
				D_1	D_2	L_6	L_1	
i	20	1/4	3	0.177	0.250	0.400	2.375	TM20BSWCH
	18	5/16	3	0.197	0.250	0.445	2.375	TM18BSWCH
	16	3/8	5	0.276	0.312	0.563	3.000	TM16BSWCH
	14	7/16	5	0.311	0.312	0.715	3.000	TM14BSWCH
	12	1/2	5	0.354	0.375	0.750	3.000	TM12BSWCH
	11	5/8	5	0.468	0.500	0.910	3.500	TM11BSWCH
	10	3/4	5	0.468	0.500	1.100	3.500	TM10BSWCH
	9	7/8	6	0.620	0.625	1.112	4.000	TM9BSWCH
	8	1	6	0.620	0.625	1.375	4.000	TM8BSWCH
m	20	1/4	3	4.50	6.00	10.16	58.00	TM20BSWCHM
	18	5/16	3	5.00	6.00	11.29	58.00	TM18BSWCHM
	16	3/8	5	7.00	8.00	14.29	64.00	TM16BSWCHM
	14	7/16	5	7.90	8.00	18.15	64.00	TM14BSWCHM
	12	1/2	5	9.00	10.00	19.10	84.00	TM12BSWCHM
	11	5/8	5	11.90	12.00	23.10	84.00	TM11BSWCHM
	10	3/4	5	11.90	12.00	27.94	84.00	TM10BSWCHM
	9	7/8	6	15.90	16.00	28.23	93.00	TM9BSWCHM
	8	1	6	15.90	16.00	34.94	93.00	TM8BSWCHM



To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

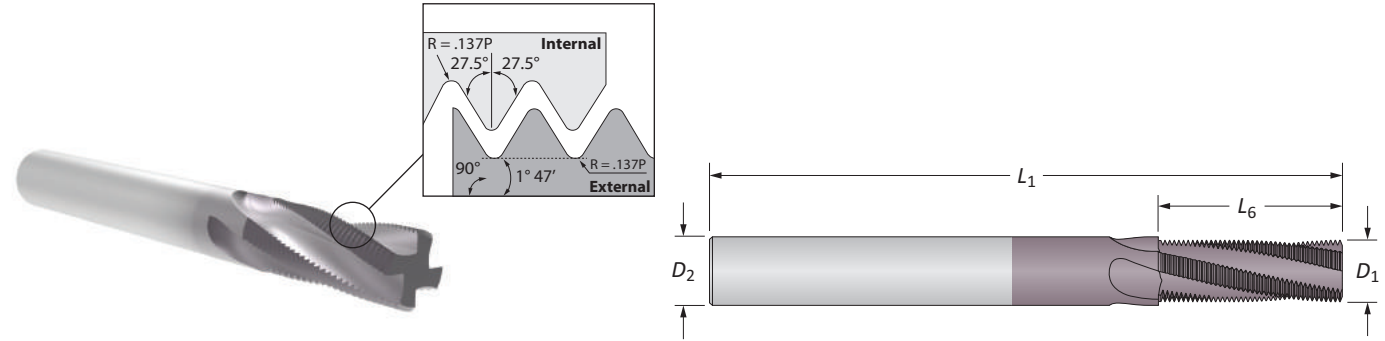
THREADING

X

SPECIALS

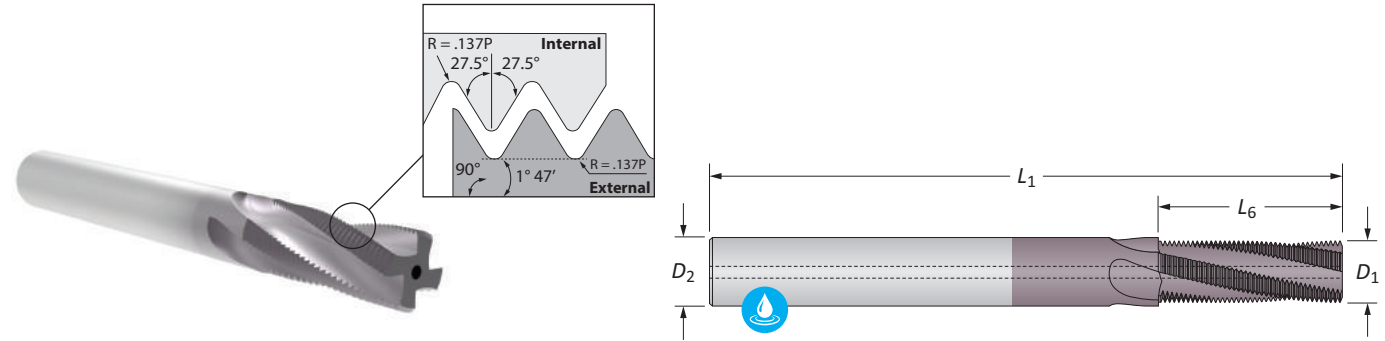
Solid Carbide Thread Mills

BSPT

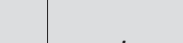


BSPT | Non-Coolant

	TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.	
				D ₁	D ₂	L ₆	L ₁	 ThreadMills USA	 AccuThread™ 856
i	28	1/16 and 1/8	3	0.240	0.250	0.393	2.500	TM28BSPT	–
	19	1/4 and 3/8	4	0.310	0.312	0.580	3.000	TM19BSPT	–
	14	1/2 and 3/4	4	0.470	0.500	0.787	3.500	TM14BSPT	–
	11	1	4	0.620	0.625	1.546	4.000	TM11BSPT	–
m	28	1/16 and 1/8	3	5.97	6.00	9.98	58.00	TM28BSPTM	TMBK0063-BSPTM
	19	1/4 and 3/8	4	9.91	10.00	14.73	73.00	TM19BSPTM	TMBK0250-BSPTM
	14	1/2 and 3/4	4	11.94	12.00	20.00	84.00	TM14BSPTM	TMBK0500-BSPTM
	11	1	4	15.75	16.00	32.31	93.00	TM11BSPTM	TMBK1000-BSPTM



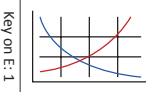
BSPT | Coolant Through

	TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
				D ₁	D ₂	L ₆	L ₁	 ThreadMills USA
i	28	1/16 and 1/8	3	0.240	0.250	0.393	2.375	TM28BSPTCH
	19	1/4 and 3/8	4	0.310	0.312	0.580	3.000	TM19BSPTCH
	14	1/2 and 3/4	4	0.470	0.500	0.787	3.500	TM14BSPTCH
	11	1	4	0.620	0.625	1.546	4.000	TM11BSPTCH
m	28	1/16 and 1/8	3	5.97	6.00	9.98	58.00	TM28BSPTCHM
	19	1/4 and 3/8	4	9.91	10.00	14.73	84.00	TM19BSPTCHM
	14	1/2 and 3/4	4	11.94	12.00	20.00	84.00	TM14BSPTCHM
	11	1	4	15.75	16.00	32.31	93.00	TM11BSPTCHM

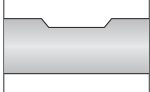
E: 46 - 49

E: 4

Weldon Flat







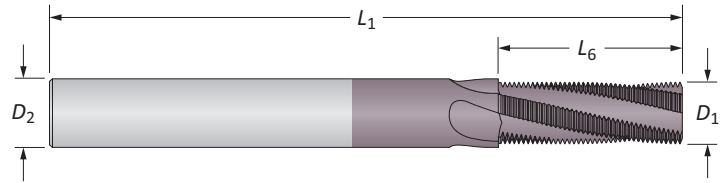
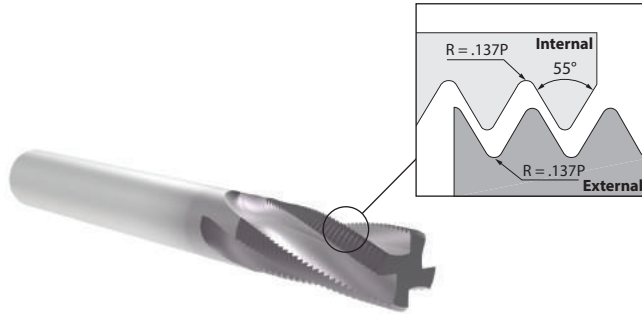
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Example: Cylindrical shank = **TW**NK0500-NPT | Weldon shank flat = **TWN**K0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

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m = Metric (mm)



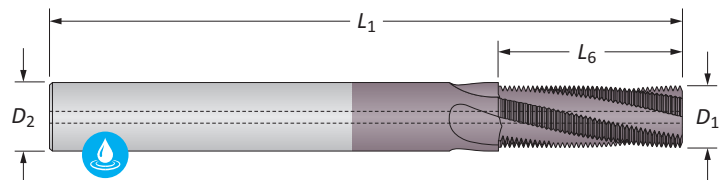
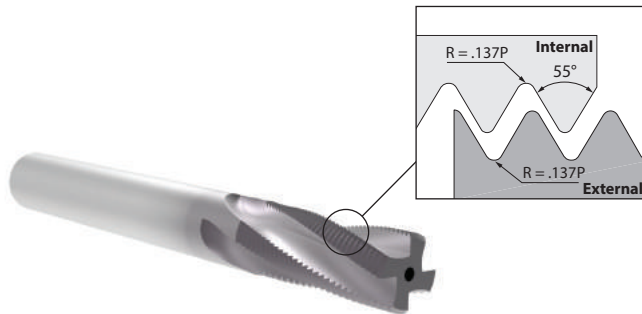
Solid Carbide Thread Mills

BSPP



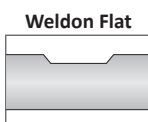
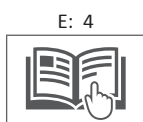
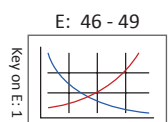
BSPP | Non-Coolant

		Thread Mill						Part No.	
	TPI (Pitch)	Min Thread Ø	Flutes	D_1	D_2	L_6	L_1	 ThreadMills USA	 AccuThread™ 856
i	28	1/16 and 1/8	3	0.240	0.250	0.572	2.500	TM28BSPP	–
	19	1/4 and 3/8	4	0.310	0.312	0.737	3.000	TM19BSPP	–
	14	1/2 and 3/4	4	0.470	0.500	1.143	3.500	TM14BSPP	–
	11	1	4	0.620	0.625	1.365	4.000	TM11BSPP	–
m	28	1/16 and 1/8	3	5.97	6.00	14.53	58.00	TM28BSPPM	TMBK0063-BSPPM
	19	1/4 and 3/8	4	9.91	10.00	18.72	73.00	TM19BSPPM	TMBK0250-BSPPM
	19	3/8	4	11.94	12.00	28.41	84.00	HDTM19BSPPM	–
	14	1/2 and 3/4	4	11.94	12.00	29.03	84.00	TM14BSPPM	TMBK0500-BSPPM
	14	3/4	5	15.75	16.00	34.47	93.00	HDTM14BSPPM	–
	11	1	4	15.75	16.00	34.67	93.00	TM11BSPPM	TMBK1000-BSPPM



BSPP | Coolant Through

		Thread Mill						Part No.	
	TPI (Pitch)	Min Thread Ø	Flutes	D_1	D_2	L_6	L_1	 ThreadMills USA	
i	28	1/16 and 1/8	3	0.240	0.250	0.572	2.375	TM28BSPPCH	
	19	1/4 and 3/8	4	0.310	0.312	0.737	3.000	TM19BSPPCH	
	14	1/2 and 3/4	4	0.470	0.500	1.143	3.500	TM14BSPPCH	
	11	1	4	0.620	0.625	1.365	4.000	TM11BSPPCH	
m	28	1/16 and 1/8	3	5.97	6.00	14.53	58.00	TM28BSPPCHM	
	19	1/4 and 3/8	4	9.91	10.00	18.72	84.00	TM19BSPPCHM	
	14	1/2 and 3/4	4	11.94	12.00	29.03	84.00	TM14BSPPCHM	
	11	1	4	15.75	16.00	34.67	93.00	TM11BSPPCHM	



To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

X

SPECIALS

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

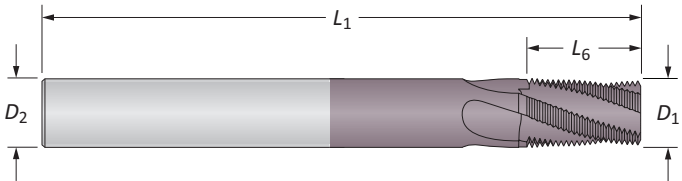
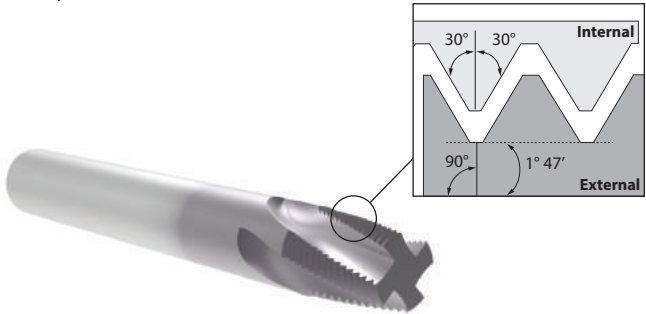
THREADING

X

SPECIALS

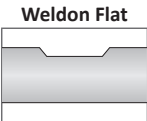
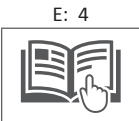
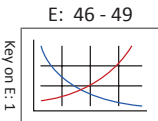
Solid Carbide Thread Mills

NPT | Non-Coolant



NPT | Non-Coolant

		TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.	
					D_1	D_2	L_6	L_1	 ThreadMills USA	 AccuThread™ 856
i	27	1/16 and 1/8	3	0.245	0.250	0.437	2.500	TM27NPT	TMNK0063-NPT	
	27	1/8	4	0.300	0.312	0.482	3.000	HDTM27NPT	HDTMNMK0125-NPT	
	18	1/4 and 3/8	4	0.305	0.312	0.625	3.000	TM18NPT	TMNK0250-NPT	
	18	1/4 and 3/8	4	0.363	0.375	0.680	3.500	HDTM18NPT	HDTMNMK0250-NPT	
	14	1/2 and 3/4	4	0.495	0.500	0.875	3.500	TM14NPT	TMNK0500-NPT	
	14	3/4	4	0.620	0.625	1.000	4.000	HDTM14NPT	HDTMNMK0750-NPT	
	11.5	1	4	0.620	0.625	1.125	4.000	TM11NPT	TMNK1000-NPT	
	11.5	1	5	0.745	0.750	1.219	4.000	HDTM11NPT	HDTMNMK1000-NPT	
	8	2-1/2	4	0.745	0.750	1.500	5.000	TM8NPT	TMNK2500-NPT	
m	27	1/16 and 1/8	3	5.95	6.00	11.30	58.00	TM27NPTM	TMNK0063-NPTM	
	27	1/8	4	7.62	8.00	12.25	64.00	HDTM27NPTM	–	
	18	1/4 and 3/8	4	7.75	8.00	15.70	64.00	TM18NPTM	TMNK0250-NPTM	
	18	1/4 and 3/8	4	9.22	10.00	17.25	84.00	HDTM18NPTM	–	
	14	1/2 and 3/4	4	11.95	12.00	23.70	84.00	TM14NPTM	TMNK0500-NPTM	
	14	3/4	4	15.75	16.00	25.40	93.00	HDTM14NPTM	–	
	11.5	1	4	15.75	16.00	28.75	93.00	TM11NPTM	TMNK1000-NPTM	
	11.5	1	5	18.92	20.00	30.95	105.00	HDTM11NPTM	–	
	8	2-1/2	5	19.75	20.00	38.10	115.00	TM8NPTM	TMNK2500-NPTM	



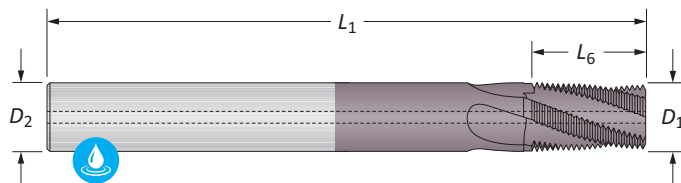
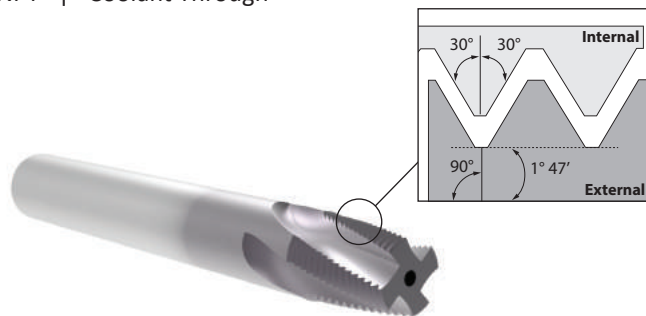
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)



Solid Carbide Thread Mills

NPT | Coolant Through



NPT | Coolant Through

	TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
				D ₁	D ₂	L ₆	L ₁	ThreadMills USA
i	27	1/16 and 1/8	3	0.245	0.250	0.437	2.375	TM27NPTCH
	27	1/8	4	0.300	0.312	0.482	3.000	HDTM27NPTCH
	18	1/4 and 3/8	4	0.305	0.312	0.625	3.000	TM18NPTCH
	18	1/4 and 3/8	4	0.363	0.375	0.680	3.000	HDTM18NPTCH
	14	1/2 and 3/4	4	0.495	0.500	0.875	3.500	TM14NPTCH
	14	3/4	4	0.620	0.625	1.000	4.000	HDTM14NPTCH
	11.5	1	4	0.620	0.625	1.125	4.000	TM11NPTCH
	11	1	5	0.745	0.750	1.219	4.000	HDTM11NPTCH
m	8	2-1/2	4	0.745	0.750	1.500	5.000	TM8NPTCH
	27	1/16 and 1/8	3	5.95	6.00	11.30	58.00	TM27NPTCHM
	27	1/8	4	7.62	8.00	12.25	64.00	HDTM27NPTCHM
	18	1/4 and 3/8	4	7.75	8.00	15.70	64.00	TM18NPTCHM
	18	1/4 and 3/8	4	9.22	10.00	17.25	84.00	HDTM18NPTCHM
	14	1/2 and 3/4	4	11.95	12.00	23.70	84.00	TM14NPTCHM
	14	3/4	4	15.75	16.00	25.40	93.00	HDTM14NPTCHM
	11.5	1	4	15.75	16.00	28.75	93.00	TM11NPTCHM
	11.5	1	5	18.92	20.00	30.95	105.00	HDTM11NPTCHM
	8	2-1/2	5	19.75	20.00	38.10	115.00	TM8NPTCHM

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

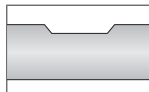
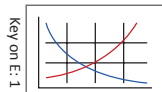
X

SPECIALS

E: 46 - 49

E: 4

Weldon Flat

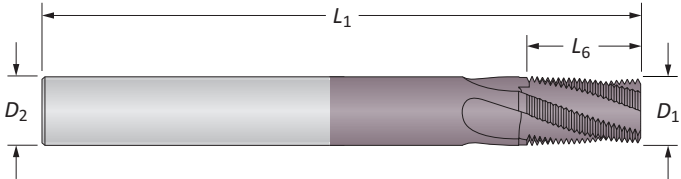
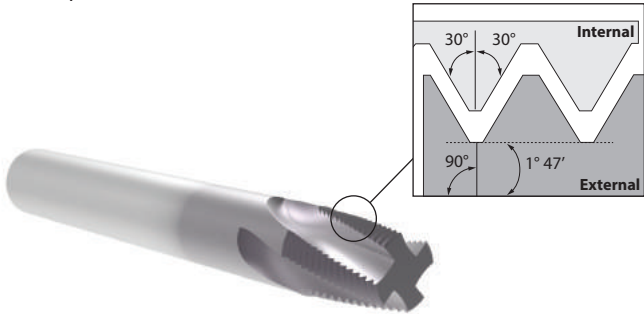


To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)

Solid Carbide Thread Mills

NPTF | Non-Coolant



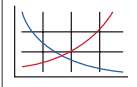
NPTF | Non-Coolant

		TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.	
					D_1	D_2	L_6	L_1	 ThreadMills USA	 AccuThread™ 856
i	27	1/16 and 1/8	3	0.245	0.250	0.437	2.500	TM27NPTF	TMNK0063-NPTF	
	18	1/4 and 3/8	4	0.305	0.312	0.625	3.000	TM18NPTF	TMNK0250-NPTF	
	14	1/2 and 3/4	4	0.495	0.500	0.875	3.500	TM14NPTF	TMNK0500-NPTF	
	11.5	1	4	0.620	0.625	1.125	4.000	TM11NPTF	TMNK1000-NPTF	
	8	2-1/2	4	0.745	0.750	1.500	5.000	TM8NPTF	TMNK2500-NPTF	
m	27	1/16 and 1/8	3	5.95	6.00	11.30	58.00	TM27NPTFM	TMNK0063-NPTFM	
	18	1/4 and 3/8	4	7.75	8.00	15.70	64.00	TM18NPTFM	TMNK0250-NPTFM	
	14	1/2 and 3/4	4	11.95	12.00	23.70	84.00	TM14NPTFM	TMNK0500-NPTFM	
	11.5	1	4	15.75	16.00	28.75	93.00	TM11NPTFM	TMNK1000-NPTFM	
	8	2-1/2	5	19.75	20.00	38.10	115.00	TM8NPTFM	TMNK2500-NPTFM	

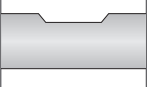
E: 46 - 49

E: 4

Weldon Flat







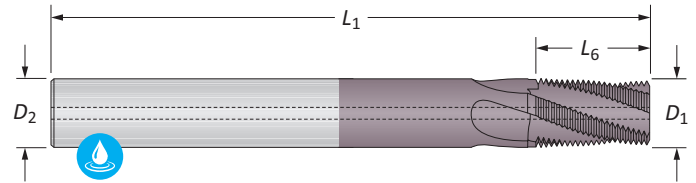
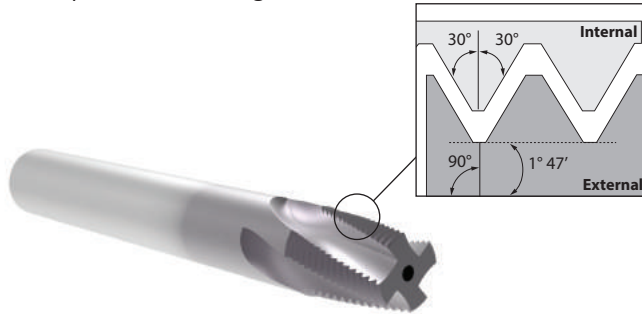
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)



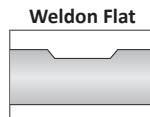
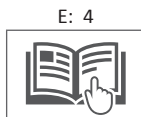
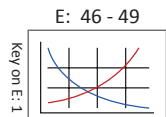
Solid Carbide Thread Mills

NPTF | Coolant Through



NPTF | Coolant Through

		Thread Mill						Part No.
		TPI (Pitch)	Min Thread Ø	Flutes	D_1	D_2	L_6	L_1
i		27	1/16 and 1/8	3	0.245	0.250	0.437	2.375
		18	1/4 and 3/8	4	0.305	0.312	0.625	3.000
		14	1/2 and 3/4	4	0.495	0.500	0.875	3.500
		11.5	1	4	0.620	0.625	1.125	4.000
		8	2-1/2	4	0.745	0.750	1.500	5.000
m		27	1/16 and 1/8	3	5.95	6.00	11.30	58.00
		18	1/4 and 3/8	4	7.75	8.00	15.70	64.00
		14	1/2 and 3/4	4	11.95	12.00	23.70	84.00
		11.5	1	4	15.75	16.00	28.75	93.00
		8	2-1/2	5	19.75	20.00	38.10	115.00

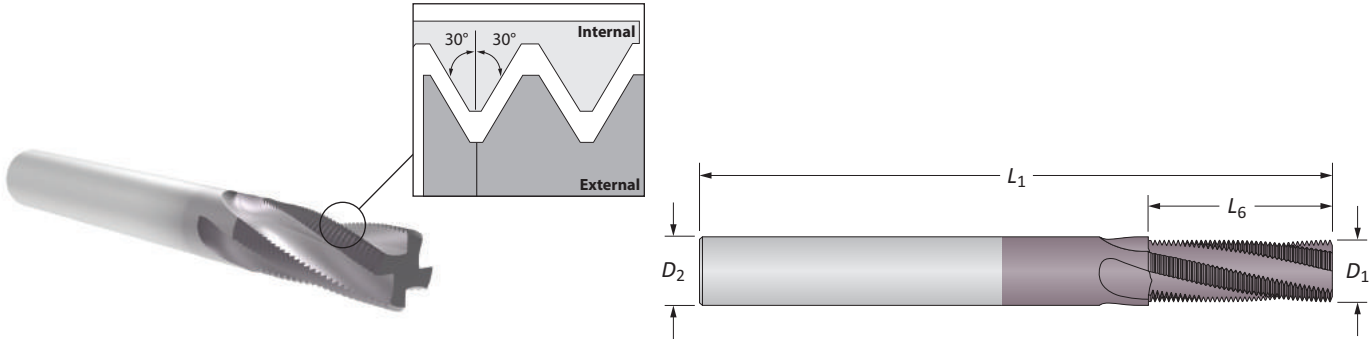


To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)

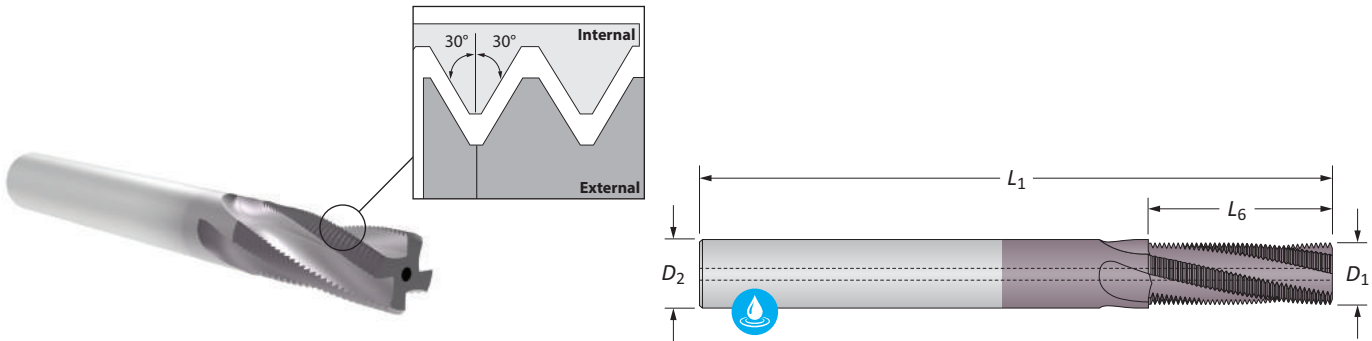
Solid Carbide Thread Mills

NPS



NPS | Non-Coolant

	TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
				D ₁	D ₂	L ₆	L ₁	 ThreadMills USA
i	27	1/8	3	0.245	0.250	0.630	2.500	TM27NPS
	18	1/4 and 3/8	4	0.370	0.375	0.889	3.500	TM18NPS
	14	1/2 and 3/4	4	0.490	0.500	1.288	3.500	TM14NPS
	11.5	1	4	0.620	0.625	1.392	4.000	TM11NPS
m	27	1/8	3	5.95	6.00	16.00	58.00	TM27NPSM
	18	1/4 and 3/8	4	9.40	10.00	22.60	84.00	TM18NPSM
	14	1/2 and 3/4	4	11.94	12.00	32.70	84.00	TM14NPSM
	11.5	1	4	15.75	16.00	35.35	93.00	TM11NPSM



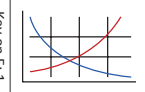
NPS | Coolant Through

	TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
				D ₁	D ₂	L ₆	L ₁	 ThreadMills USA
i	27	1/8	3	0.245	0.250	0.630	2.375	TM27NPSCH
	18	1/4 and 3/8	4	0.370	0.375	0.889	3.000	TM18NPSCH
	14	1/2 and 3/4	4	0.490	0.500	1.288	3.500	TM14NPSCH
	11.5	1	4	0.620	0.625	1.392	4.000	TM11NPSCH
m	27	1/8	3	5.95	6.00	16.00	58.00	TM27NPSCHM
	18	1/4 and 3/8	4	9.40	10.00	22.60	84.00	TM18NPSCHM
	14	1/2 and 3/4	4	11.94	12.00	32.70	84.00	TM14NPSCHM
	11.5	1	4	15.75	16.00	35.35	93.00	TM11NPSCHM

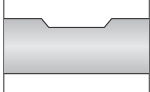
E: 46 - 49

E: 4

Weldon Flat







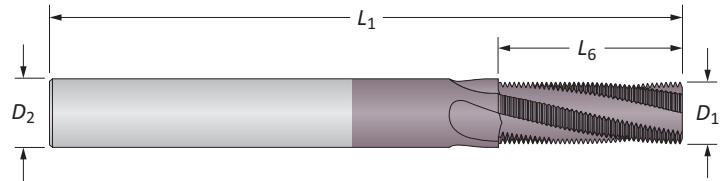
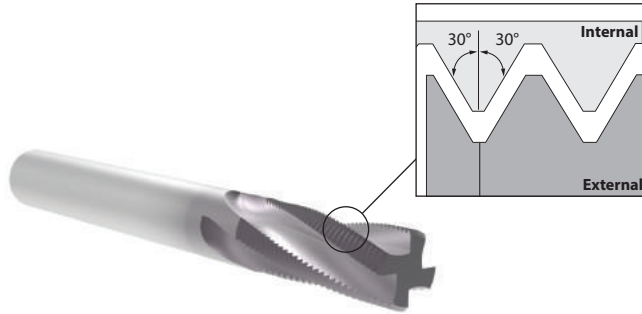
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TW**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)



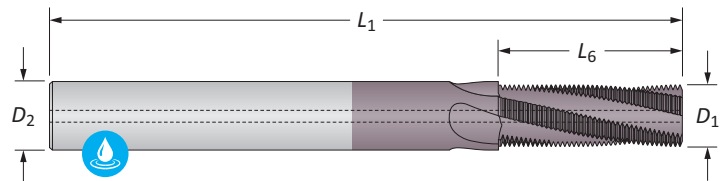
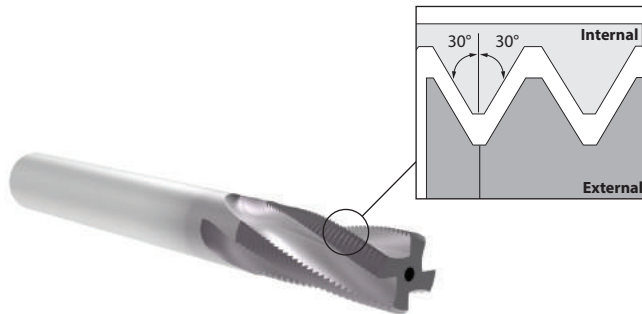
Solid Carbide Thread Mills

NPSF



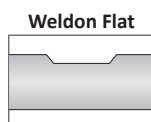
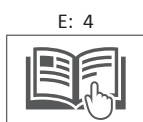
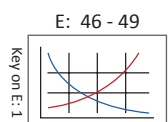
NPSF | Non-Coolant

	TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
				D_1	D_2	L_6	L_1	ThreadMills USA
i	27	1/8	3	0.245	0.250	0.630	2.500	TM27NPSF
	18	1/4 and 3/8	4	0.370	0.375	0.889	3.500	TM18NPSF
	14	1/2 and 3/4	4	0.490	0.500	1.288	3.500	TM14NPSF
	11.5	1	4	0.620	0.625	1.392	4.000	TM11NPSF
m	27	1/8	3	5.95	6.00	16.00	58.00	TM27NPSFM
	18	1/4 and 3/8	4	9.40	10.00	22.60	84.00	TM18NPSFM
	14	1/2 and 3/4	4	11.94	12.00	32.70	84.00	TM14NPSFM
	11.5	1	4	15.75	16.00	35.35	93.00	TM11NPSFM



NPSF | Coolant Through

	TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
				D_1	D_2	L_6	L_1	ThreadMills USA
i	27	1/8	3	0.245	0.250	0.630	2.375	TM27NPSFCH
	18	1/4 and 3/8	4	0.370	0.375	0.889	3.000	TM18NPSFCH
	14	1/2 and 3/4	4	0.490	0.500	1.288	3.500	TM14NPSFCH
	11.5	1	4	0.620	0.625	1.392	4.000	TM11NPSFCH
m	27	1/8	3	5.95	6.00	16.00	58.00	TM27NPSFCHM
	18	1/4 and 3/8	4	9.40	10.00	22.60	84.00	TM18NPSFCHM
	14	1/2 and 3/4	4	11.94	12.00	32.70	84.00	TM14NPSFCHM
	11.5	1	4	15.75	16.00	35.35	93.00	TM11NPSFCHM



To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TW**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

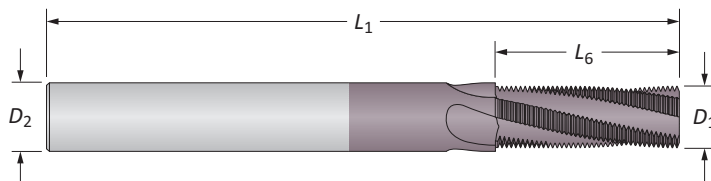
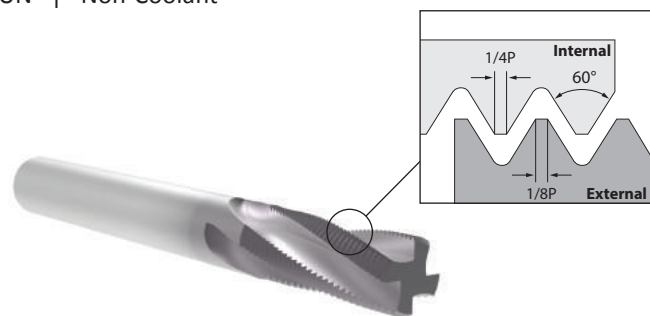
THREADING

X

SPECIALS

Solid Carbide Thread Mills

UN | Non-Coolant



UN | Non-Coolant

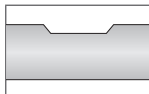
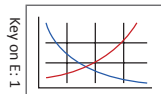
TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.	
			D_1	D_2	L_6	L_1	 ThreadMills USA	 AccuThread™ 856
64	#2	3*	0.065	0.125	0.125	2.000	TM08664	–
56	#2	3*	0.065	0.125	0.125	2.000	TM08656	TMUK0002-56
48	#3	3*	0.075	0.125	0.167	2.000	TM09948	–
44	#5	3	0.095	0.125	0.228	2.000	TM12544	–
40	#4	3*	0.085	0.125	0.175	2.000	TM12540	TMUK0004-40
36	#8	3	0.115	0.125	0.250	2.000	TM16436	–
32	#6	3	0.100	0.125	0.218	2.000	TM13832	TMUK0006-32
32	#8	3	0.115	0.125	0.250	2.000	TM16432	TMUK0008-32
32	#10	3	0.120	0.125	0.312	2.000	TM19032	TMUK0010-32
32	#10	3	0.150	0.187	0.312	2.500	HDTM19032	–
32	1/2	6	0.370	0.375	1.000	3.500	TM50032	–
28	#10	3	0.120	0.125	0.312	2.000	TM19028	TMUK0010-28
28	1/4	3	0.180	0.187	0.500	2.500	TM25028	TMUK0250-28
28	1/2	6	0.370	0.375	1.000	3.500	TM50028	–
24	#10	3	0.120	0.125	0.312	2.000	TM19024	TMUK0010-24
24	#10	3	0.145	0.187	0.312	2.500	HDTM19024	–
24	5/16	3	0.235	0.250	0.625	2.500	TM31224	TMUK0313-24
24	3/8	4	0.285	0.312	0.750	3.000	TM37524	TMUK0375-24
24	1/2	6	0.370	0.375	1.000	3.500	TM50024	–
20	1/4	3	0.180	0.187	0.500	2.500	TM25020	TMUK0250-20
20	1/4	3	0.195	0.250	0.500	2.500	HDTM25020	–
20	7/16	4	0.335	0.375	0.875	3.500	TM43720	TMUK0438-20
20	1/2	6	0.370	0.375	1.000	3.500	TM50020	–

*Straight fluted

E: 46 - 49

E: 4

Weldon Flat



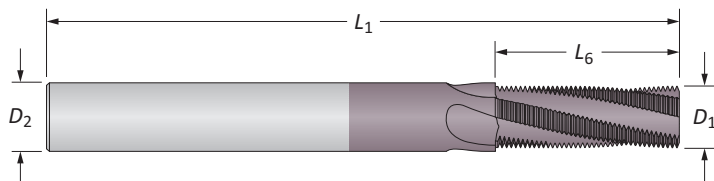
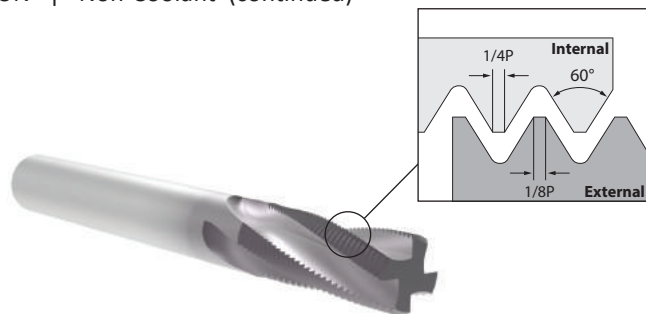
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TW**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

ⓘ = Imperial (in)
 ⓘ = Metric (mm)



Solid Carbide Thread Mills

UN | Non-Coolant (continued)



UN | Non-Coolant

TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.	
			D ₁	D ₂	L ₆	L ₁	ThreadMills USA	AccuThread™ 856
18	5/16	3	0.235	0.250	0.625	2.500	TM31218	TMUK0313-18
18	5/16	3	0.245	0.312	0.625	3.000	HDTM31218	—
18	9/16	4	0.370	0.375	0.875	3.500	TM56218	TMUK0563-18
16	3/8	4	0.285	0.312	0.750	3.000	TM37516	TMUK0375-16
16	3/8	4	0.300	0.375	0.750	3.500	HDTM37516	—
16	3/4	4	0.490	0.500	1.250	3.500	TM75016	TMUK0750-16
14	7/16	4	0.305	0.312	0.750	3.000	TM43714	TMUK0438-14
14	7/8	4	0.490	0.500	1.250	3.500	TM87514	TMUK0875-14
13	1/2	4	0.350	0.375	0.875	3.500	TM50013	TMUK0500-13
13	1/2	4	0.400	0.500	0.875	3.500	HDTM50013	—
12	9/16	4	0.370	0.375	0.875	3.500	TM56212	TMUK0563-12
12	3/4	4	0.495	0.500	1.250	3.500	TM75012	TMUK0750-12
12	1	6	0.745	0.750	1.500	4.000	TM10012	—
11	5/8	4	0.470	0.500	1.250	3.500	TM62511	TMUK0625-11
11	5/8	4	0.470	0.500	1.455	3.500	TM62511-XL	TMUK0625-11XL
10	3/4	4	0.495	0.500	1.250	3.500	TM75010	TMUK0750-10
10	3/4	4	0.495	0.500	1.600	4.000	TM75010-XL	TMUK0750-10XL
9	7/8	4	0.620	0.625	1.375	4.000	TM87509	TMUK0875-9
9	7/8	4	0.620	0.625	1.778	4.000	TM87509-XL	TMUK0875-9XL
8	1	4	0.620	0.625	1.375	4.000	TM10008	TMUK1000-8
8	1	6	0.745	0.750	2.000	4.500	TM10008-XL	TMUK1000-8XL
7	1-1/8	5	0.745	0.750	1.572	4.500	TM12507	—
6	1-3/8	5	0.745	0.750	1.500	4.500	TM13706	—

i

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

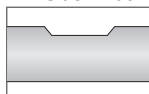
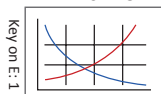
X

SPECIALS

E: 46 - 49

E: 4

Weldon Flat



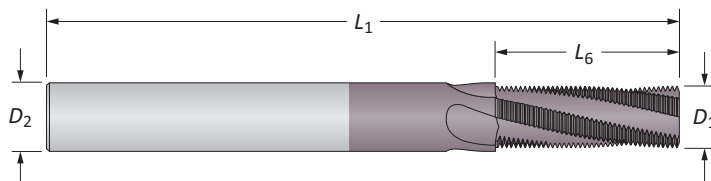
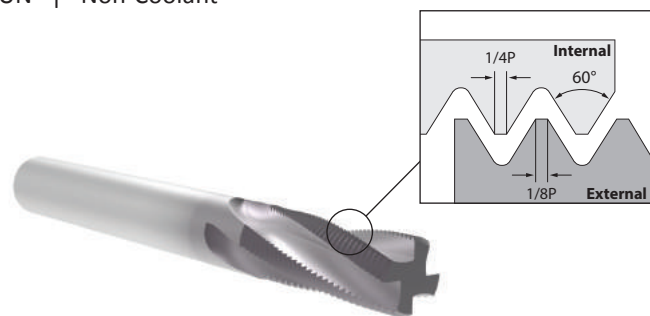
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)



Solid Carbide Thread Mills

UN | Non-Coolant

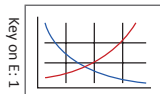


UN | Non-Coolant

TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.	
			D_1	D_2	L_6	L_1	 ThreadMills USA	 AccuThread™ 856
64	#2	3*	1.65	3.00	3.20	39.00	TM08664M	TMUK0002-64M
56	#2	3*	1.65	3.00	3.20	39.00	TM08656M	TMUK0002-56M
48	#3	3*	1.80	3.00	3.75	39.00	TM09948M	TMUK0003-48M
44	#5	3	2.40	3.00	4.65	39.00	TM12544M	TMUK0005-44M
40	#4	3*	2.20	3.00	4.45	39.00	TM12540M	TMUK0004-40M
36	#8	3	3.00	4.00	6.35	51.00	TM16436M	TMUK0008-36M
32	#6	3	2.50	3.00	5.55	39.00	TM13832M	TMUK0006-32M
32	#8	3	3.20	4.00	6.35	51.00	TM16432M	TMUK0008-32M
32	#10	3	3.80	4.00	7.95	51.00	TM19032M	TMUK0010-32M
32	#10	3	3.80	4.00	7.95	51.00	HDTM19032M	—
32	1/2	6	9.40	10.00	25.40	84.00	TM50032M	—
28	#10	3	3.80	4.00	8.20	51.00	TM19028M	TMUK0010-28M
28	1/4	3	4.75	6.00	12.70	58.00	TM25028M	TMUK0250-28M
28	7/16	4	7.90	8.00	19.95	64.00	—	TMUK0438-28M
28	1/2	6	9.40	10.00	25.40	84.00	TM50028M	—
24	#10	3	3.70	4.00	8.50	51.00	TM19024M	TMUK0010-24M
24	#10	3	3.70	4.00	8.50	51.00	HDTM19024M	TMUK0313-24M
24	5/16	3	5.95	6.00	16.00	58.00	TM31224M	TMUK0375-24M
24	3/8	4	7.25	8.00	19.00	64.00	TM37524M	—
24	1/2	6	9.40	10.00	25.40	84.00	TM50024M	—
20	1/4	3	4.75	6.00	12.70	58.00	TM25020M	TMUK0250-20M
20	1/4	3	4.95	6.00	12.70	58.00	HDTM25020M	—
20	7/16	4	8.75	10.00	22.85	73.00	TM43720M	TMUK0438-20M
20	1/2	6	9.40	10.00	25.40	84.00	TM50020M	—

*Straight fluted

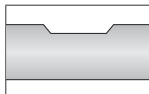
E: 46 - 49



E: 4



Weldon Flat



To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)

Example: Cylindrical shank = **TW**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT

NOTE: Weldon flats have a minimum order quantity of 2 pieces

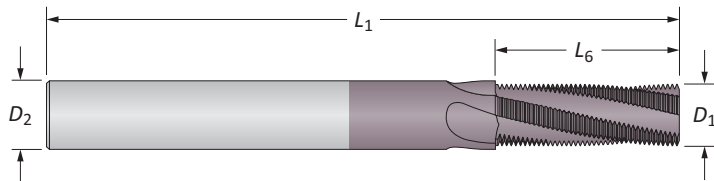
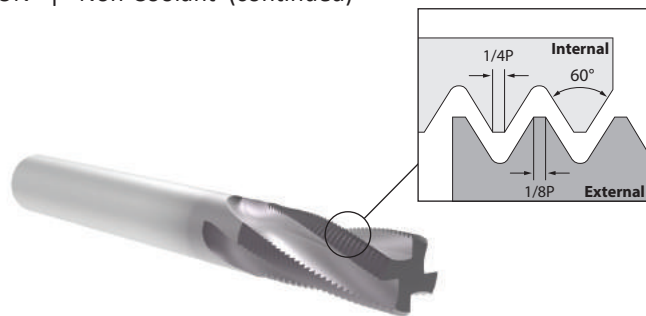
ⓘ = Imperial (in)

Ⓜ = Metric (mm)



Solid Carbide Thread Mills

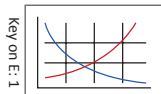
UN | Non-Coolant (continued)



UN | Non-Coolant

TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.	
			D ₁	D ₂	L ₆	L ₁	ThreadMills USA	AccuThread™ 856
18	5/16	3	5.95	6.00	17.00	58.00	TM31218M	TMUK0313-18M
18	5/16	3	6.22	8.00	15.87	64.00	HDTM31218M	-
18	9/16	4	9.90	10.00	22.65	73.00	TM56218M	TMUK0563-18M
16	3/8	4	7.25	8.00	19.05	64.00	TM37516M	TMUK0375-16M
16	3/8	4	7.62	10.00	19.05	84.00	HDTM37516M	-
16	3/4	4	11.95	12.00	31.75	84.00	TM75016M	TMUK0750-16M
14	7/16	4	7.75	8.00	20.00	64.00	TM43714M	TMUK0438-14M
14	7/8	4	11.95	12.00	32.70	84.00	TM87514M	TMUK0875-14M
13	1/2	4	9.40	10.00	23.50	73.00	TM50013M	TMUK0500-13M
13	1/2	4	10.16	12.00	23.50	84.00	HDTM50013M	-
12	9/16	4	9.90	10.00	23.35	73.00	TM56212M	TMUK0563-12M
12	3/4	4	11.95	12.00	31.75	84.00	TM75012M	TMUK0750-12M
12	1	6	18.92	20.00	38.10	105.00	TM10012M	-
11	5/8	4	11.95	12.00	32.40	84.00	TM62511M	TMUK0625-11M
11	5/8	4	11.95	12.00	37.00	100.00	TM62511M-XL	TMUK0625-11XLM
10	3/4	4	11.95	12.00	33.00	84.00	TM75010M	TMUK0750-10M
10	3/4	4	11.95	12.00	40.70	100.00	TM75010M-XL	TMUK0750-10XLM
9	7/8	4	15.75	16.00	36.75	93.00	TM87509M	TMUK0875-9M
9	7/8	4	15.75	16.00	45.20	100.00	TM87509M-XL	TMUK0875-9XLM
8	1	4	15.75	16.00	35.00	93.00	TM10008M	TMUK1000-8M
8	1	6	19.90	20.00	50.80	115.00	TM10008M-XL	TMUK1000-8XLM
7	1-1/8	5	19.90	20.00	36.30	105.00	TM12507M	TMUK1125-7M
6	1-3/8	5	19.90	20.00	38.10	105.00	TM13706M	TMUK1375-6M

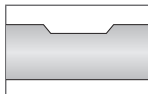
E: 46 - 49



E: 4



Weldon Flat

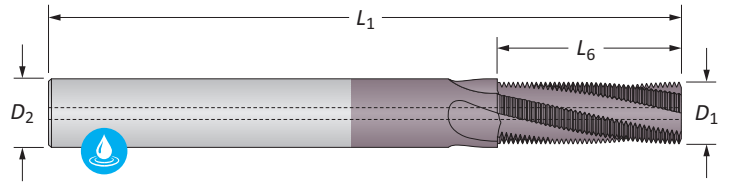
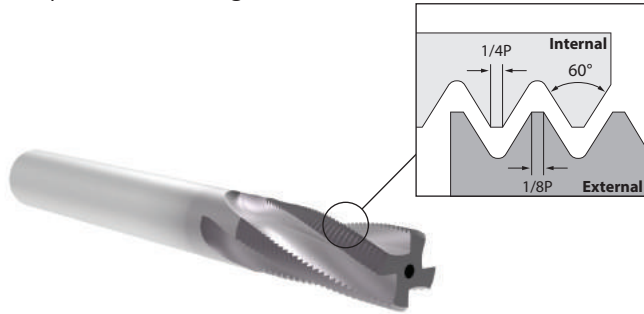


To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

① = Imperial (in)
 Ⓜ = Metric (mm)

Solid Carbide Thread Mills

UN | Coolant Through



UN | Coolant Through

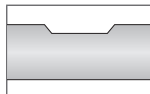
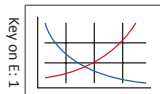
TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
			D_1	D_2	L_6	L_1	
64	#2	3*	0.065	0.125	0.125	1.500	TM08664CH
56	#2	3*	0.065	0.125	0.125	1.500	TM08656CH
48	#3	3*	0.075	0.125	0.167	1.500	TM09948CH
44	#5	3	0.095	0.125	0.228	1.500	TM12544CH
40	#4	3*	0.085	0.125	0.175	1.500	TM12540CH
36	#8	3	0.115	0.125	0.250	1.500	TM16436CH
32	#6	3	0.100	0.125	0.218	1.500	TM13832CH
32	#8	3	0.115	0.125	0.250	1.500	TM16432CH
32	#10	3	0.150	0.187	0.312	2.375	TM19032CH
32	#10	3	0.150	0.187	0.312	2.375	HDTM19032CH
32	1/2	6	0.370	0.375	1.000	3.500	TM50032CH
28	#10	3	0.120	0.125	0.312	1.500	TM19028CH
28	1/4	3	0.180	0.187	0.500	2.375	TM25028CH
28	1/2	6	0.370	0.375	1.000	3.500	TM50028CH
24	#10	3	0.145	0.187	0.312	2.375	TM19024CH
24	#10	3	0.145	0.187	0.312	2.375	HDTM19024CH
24	5/16	3	0.235	0.250	0.625	2.375	TM31224CH
24	3/8	4	0.285	0.312	0.750	3.000	TM37524CH
24	1/2	6	0.370	0.375	1.000	3.500	TM50024CH
20	1/4	3	0.180	0.187	0.500	2.375	TM25020CH
20	1/4	3	0.195	0.250	0.500	2.375	HDTM25020CH
20	7/16	4	0.335	0.375	0.875	3.000	TM43720CH
20	1/2	6	0.370	0.375	1.000	3.500	TM50020CH

*Straight fluted

E: 46 - 49

E: 4

Weldon Flat



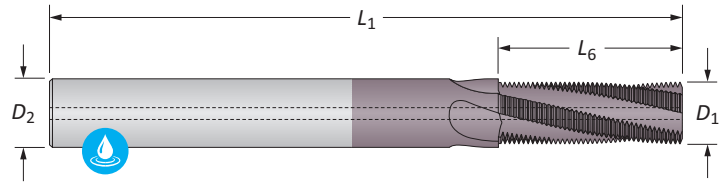
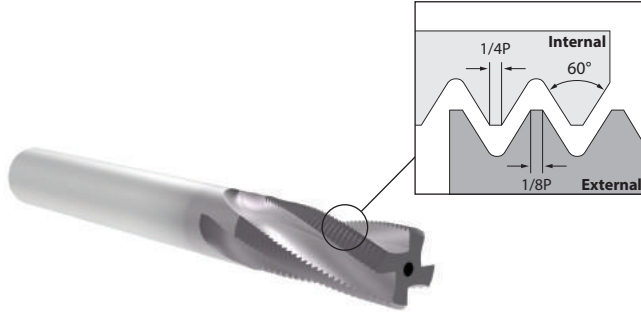
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

ⓘ = Imperial (in)
 ⓘ = Metric (mm)



Solid Carbide Thread Mills

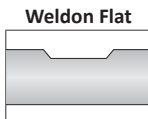
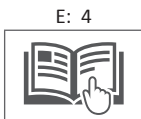
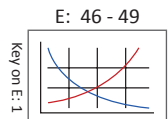
UN | Coolant Through (continued)



UN | Coolant Through

TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
			D ₁	D ₂	L ₆	L ₁	
18	5/16	3	0.235	0.250	0.625	2.375	TM31218CH
18	5/16	3	0.245	0.312	0.625	3.000	HDTM31218CH
18	9/16	4	0.370	0.375	0.875	3.000	TM56218CH
16	3/8	4	0.285	0.312	0.750	3.000	TM37516CH
16	3/8	4	0.300	0.375	0.750	3.000	HDTM37516CH
16	3/4	4	0.490	0.500	1.250	3.500	TM75016CH
14	7/16	4	0.305	0.312	0.750	3.000	TM43714CH
14	7/8	4	0.490	0.500	1.250	3.500	TM87514CH
13	1/2	4	0.350	0.375	0.875	3.000	TM50013CH
13	1/2	4	0.400	0.500	0.875	3.500	HDTM50013CH
12	9/16	4	0.370	0.375	0.875	3.500	TM56212CH
12	3/4	4	0.495	0.500	1.250	3.500	TM75012CH
12	1	6	0.745	0.750	1.500	4.000	TM10012CH
11	5/8	4	0.470	0.500	1.250	3.500	TM62511CH
11	5/8	4	0.470	0.500	1.455	3.500	TM62511CH-XL
10	3/4	4	0.495	0.500	1.250	3.500	TM75010CH
10	3/4	4	0.495	0.500	1.600	4.000	TM75010CH-XL
9	7/8	4	0.620	0.625	1.375	4.000	TM87509CH
9	7/8	4	0.620	0.625	1.778	4.000	TM87509CH-XL
8	1	4	0.620	0.625	1.375	4.000	TM10008CH
8	1	6	0.745	0.750	2.000	4.500	TM10008CH-XL
7	1-1/8	5	0.745	0.750	1.572	4.500	TM12507CH
6	1-3/8	5	0.745	0.750	1.500	4.500	TM13706CH

i



To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

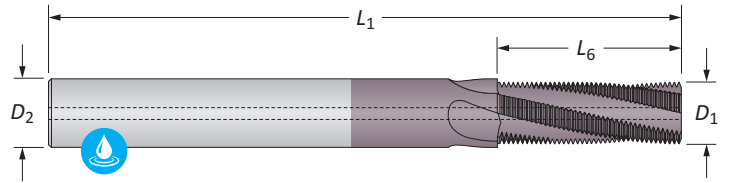
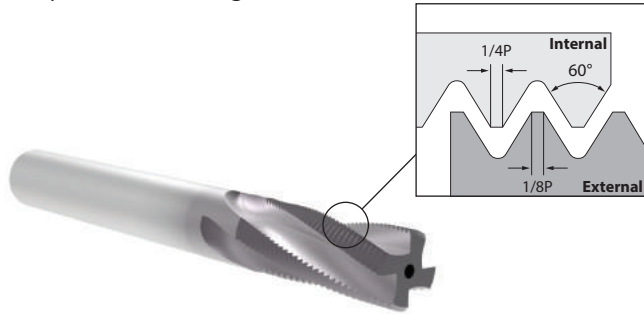
THREADING

X

SPECIALS

Solid Carbide Thread Mills

UN | Coolant Through



UN | Coolant Through

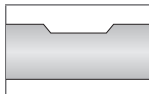
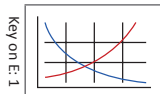
TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
			D_1	D_2	L_6	L_1	
64	#2	3*	1.65	3.00	3.20	39.00	TM08664CHM
56	#2	3*	1.65	3.00	3.20	39.00	TM08656CHM
48	#3	3*	1.80	3.00	3.75	39.00	TM09948CHM
44	#5	3	2.40	3.00	4.65	39.00	TM12544CHM
40	#4	3*	2.20	3.00	4.45	39.00	TM12540CHM
36	#8	3	3.00	4.00	6.35	51.00	TM16436CHM
32	#6	3	2.50	3.00	5.55	39.00	TM13832CHM
32	#8	3	3.20	4.00	6.35	51.00	TM16432CHM
32	#10	3	3.80	4.00	7.95	51.00	TM19032CHM
32	#10	3	3.80	4.00	7.95	51.00	HDTM19032CHM
32	1/2	6	9.40	10.00	25.40	84.00	TM50032CHM
28	#10	3	3.80	4.00	8.20	51.00	TM19028CHM
28	1/4	3	4.75	6.00	12.70	58.00	TM25028CHM
28	1/2	6	9.40	10.00	25.40	84.00	TM50028CHM
24	#10	3	3.68	4.00	8.50	51.00	TM19024CHM
24	#10	3	3.70	4.00	8.50	51.00	HDTM19024CHM
24	5/16	3	5.95	6.00	16.00	58.00	TM31224CHM
24	3/8	4	7.25	8.00	19.00	64.00	TM37524CHM
24	1/2	6	9.40	10.00	25.40	84.00	TM50024CHM
20	1/4	3	4.75	6.00	12.70	58.00	TM25020CHM
20	1/4	3	4.95	6.00	12.70	58.00	HDTM25020CHM
20	7/16	4	8.75	10.00	22.85	84.00	TM43720CHM
20	1/2	6	9.40	10.00	25.40	84.00	TM50020CHM

*Straight fluted

E: 46 - 49

E: 4

Weldon Flat



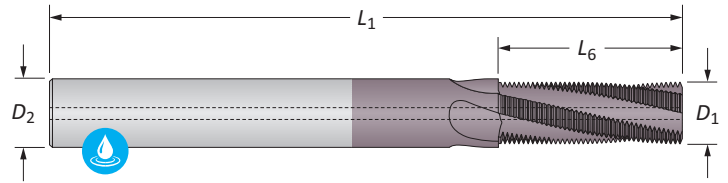
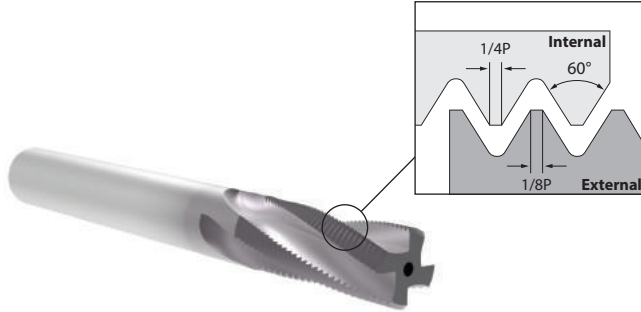
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

ⓘ = Imperial (in)
 ⓘ = Metric (mm)



Solid Carbide Thread Mills

UN | Coolant Through (continued)

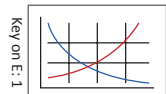


UN | Coolant Through

TPI (Pitch)	Min Thread Ø	Flutes	Thread Mill				Part No.
			D_1	D_2	L_6	L_1	
18	5/16	3	5.95	6.00	17.00	58.00	TM31218CHM
18	5/16	3	6.22	8.00	15.87	64.00	HDTM31218CHM
18	9/16	4	9.90	10.00	22.65	84.00	TM56218CHM
16	3/8	4	7.25	8.00	19.05	64.00	TM37516CHM
16	3/8	4	7.62	10.00	19.05	84.00	HDTM37516CHM
16	3/4	4	11.95	12.00	31.75	84.00	TM75016CHM
14	7/16	4	7.75	8.00	20.00	64.00	TM43714CHM
14	7/8	4	11.95	12.00	32.70	84.00	TM87514CHM
13	1/2	4	9.40	10.00	23.50	84.00	TM50013CHM
13	1/2	4	10.16	12.00	23.50	84.00	HDTM50013CHM
12	9/16	4	9.90	10.00	23.35	84.00	TM56212CHM
12	3/4	4	11.95	12.00	31.75	84.00	TM75012CHM
12	1	6	18.92	20.00	38.10	105.00	TM10012CHM
11	5/8	4	11.95	12.00	32.40	84.00	TM62511CHM
11	5/8	4	11.95	12.00	37.00	100.00	TM62511CHM-XL
10	3/4	4	11.95	12.00	33.00	84.00	TM75010CHM
10	3/4	4	11.95	12.00	40.70	100.00	TM75010CHM-XL
9	7/8	4	15.75	16.00	36.75	93.00	TM87509CHM
9	7/8	4	15.75	16.00	45.20	100.00	TM87509CHM-XL
8	1	4	15.75	16.00	35.00	93.00	TM10008CHM
8	1	6	19.90	20.00	50.80	115.00	TM10008CHM-XL
7	1-1/8	5	19.90	20.00	36.10	105.00	TM12507CHM
6	1-3/8	5	19.90	20.00	38.10	105.00	TM13706CHM

m

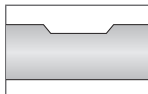
E: 46 - 49



E: 4



Weldon Flat

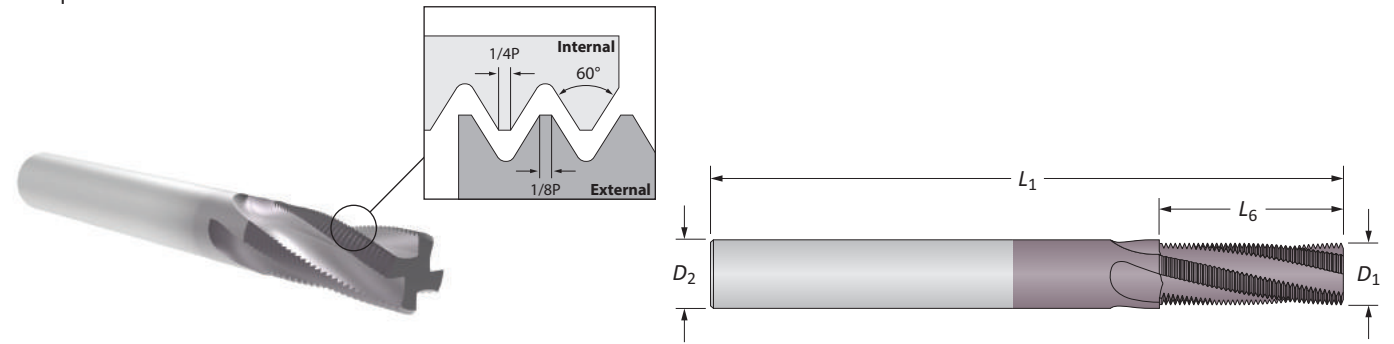


To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

① = Imperial (in)
 m = Metric (mm)

Solid Carbide Thread Mills

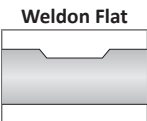
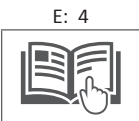
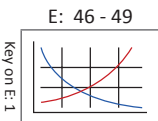
ISO | Non-Coolant



ISO | Non-Coolant

	Pitch	Min Thread Ø	Flutes	Thread Mill				Part No.	
				D ₁	D ₂	L ₆	L ₁	 ThreadMills USA	 AccuThread™ 856
	0.40	M2	3*	0.059	0.125	0.126	2.000	TM20040	–
	0.45	M2.5	3*	0.059	0.125	0.142	2.000	TM25045	–
	0.50	M3	3*	0.085	0.125	0.178	2.000	TM30050	–
	0.50	M6	3	0.181	0.187	0.473	2.500	TM60050	–
	0.50	M10	4	0.310	0.312	0.591	3.000	TM10050	–
	0.70	M4	3	0.115	0.125	0.276	2.000	TM40070	–
	0.75	M4.5	3	0.120	0.125	0.266	2.000	TM45075	TMMK0450-075
	0.75	M8	3	0.235	0.250	0.625	2.500	TM80075	TMMK0800-075
	0.75	M10	4	0.310	0.312	0.591	3.000	TM10075	–
	0.80	M5	3	0.120	0.125	0.312	2.000	TM50080	TMMK0500-080
	1.00	M6	3	0.170	0.187	0.500	2.500	TM60100	TMMK0600-100
	1.00	M12	4	0.360	0.375	0.875	3.500	TM12100	TMMK1200-100
	1.25	M8	3	0.235	0.250	0.625	2.500	TM80125	TMMK0800-125
	1.50	M10	4	0.300	0.312	0.750	3.000	TM10150	TMMK1000-150
	1.50	M14	4	0.370	0.375	0.875	3.500	TM14150	TMMK1400-150
	1.50	M18	4	0.490	0.500	1.250	3.500	TM18150	TMMK1800-150
	1.50	M20	5	0.620	0.625	1.418	4.000	TM20150	–
	1.75	M12	4	0.360	0.375	0.875	3.500	TM12175	TMMK1200-175
	2.00	M14	4	0.429	0.500	1.103	3.500	TM14200	–
	2.00	M16	4	0.470	0.500	1.250	3.500	TM16200	TMMK1600-200
	2.50	M20	4	0.495	0.500	1.250	3.500	TM20250	TMMK2000-250
	3.00	M24	4	0.620	0.625	1.375	4.000	TM24300	TMMK2400-300
	3.50	M30	4	0.620	0.625	1.516	4.000	TM30350	–
	4.00	M36	5	0.745	0.750	1.575	4.500	TM36400	–

*Straight fluted



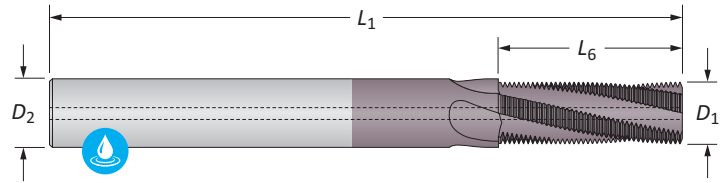
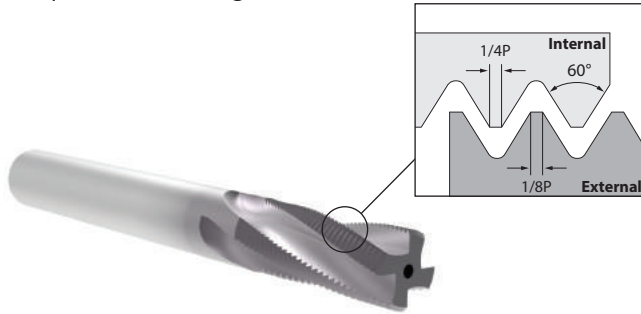
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TW**MNK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

i = Imperial (in)
m = Metric (mm)



Solid Carbide Thread Mills

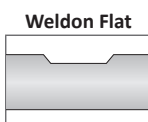
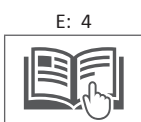
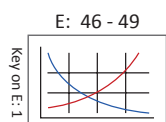
ISO | Coolant Through



ISO | Coolant Through

Pitch	Min Thread ϕ	Flutes	Thread Mill				Part No.
			D_1	D_2	L_6	L_1	ThreadMills USA
0.40	M2	3*	0.059	0.125	0.126	1.500	TM20040CH
0.45	M2.5	3*	0.059	0.125	0.142	1.500	TM25045CH
0.50	M3	3*	0.085	0.125	0.178	1.500	TM30050CH
0.50	M6	3	0.181	0.187	0.473	2.375	TM60050CH
0.50	M10	4	0.310	0.312	0.591	3.000	TM10050CH
0.70	M4	3	0.115	0.125	0.276	1.500	TM40070CH
0.75	M4.5	3	0.120	0.125	0.266	1.500	TM45075CH
0.75	M8	3	0.235	0.250	0.625	2.375	TM80075CH
0.75	M10	4	0.310	0.312	0.591	3.000	TM10075CH
0.80	M5	3	0.120	0.125	0.312	1.500	TM50080CH
1.00	M6	3	0.170	0.187	0.500	2.375	TM60100CH
1.00	M12	4	0.360	0.375	0.875	3.000	TM12100CH
1.25	M8	3	0.235	0.250	0.625	2.375	TM80125CH
1.50	M10	4	0.300	0.312	0.750	3.000	TM10150CH
1.50	M14	4	0.370	0.375	0.875	3.000	TM14150CH
1.50	M18	4	0.490	0.500	1.250	3.500	TM18150CH
1.50	M20	5	0.620	0.625	1.418	4.000	TM20150CH
1.75	M12	4	0.360	0.375	0.875	3.000	TM12175CH
2.00	M14	4	0.429	0.500	1.103	3.500	TM14200CH
2.00	M16	4	0.470	0.500	1.250	3.500	TM16200CH
2.50	M20	4	0.495	0.500	1.250	3.500	TM20250CH
3.00	M24	4	0.620	0.625	1.375	4.000	TM24300CH
3.50	M30	4	0.620	0.625	1.516	4.000	TM30350CH
4.00	M36	5	0.745	0.750	1.575	4.500	TM36400CH

*Straight fluted

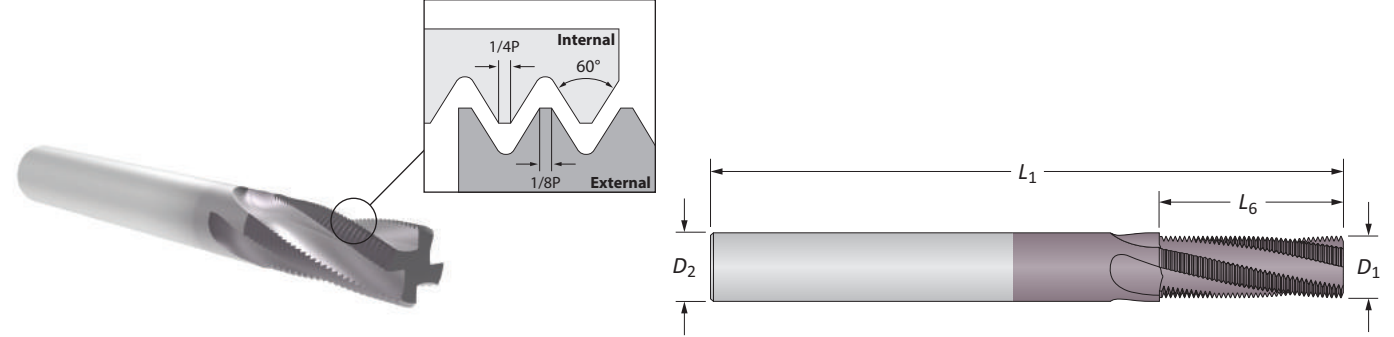


To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TW**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

① = Imperial (in)
 Ⓜ = Metric (mm)

Solid Carbide Thread Mills

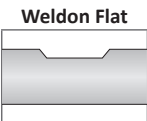
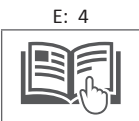
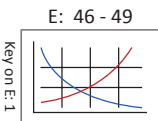
ISO | Non-Coolant



ISO | Non-Coolant

	Pitch	Min Thread Ø	Flutes	Thread Mill				Part No.	
				D ₁	D ₂	L ₆	L ₁	 ThreadMills USA	 AccuThread™ 856
m	0.40	M2	3*	1.50	3.00	3.20	39.00	TM20040M	TMMK0200-040M
	0.45	M2.5	3*	1.50	3.00	3.60	39.00	TM25045M	TMMK0250-045M
	0.50	M3	3*	2.15	3.00	4.50	39.00	TM30050M	TMMK0300-050M
	0.50	M6	3	4.60	6.00	12.00	58.00	TM60050M	TMMK0600-050M
	0.50	M10	4	7.95	8.00	15.00	64.00	TM10050M	TMMK1000-050M
	0.70	M4	3	2.90	3.00	8.00	39.00	TM40070M	TMMK0400-070M
	0.75	M4.5	3	3.00	4.00	6.75	51.00	TM45075M	TMMK0450-075M
	0.75	M6	3	4.60	6.00	12.00	58.00	TM60075M	TMMK0600-075M
	0.75	M10	4	7.95	8.00	15.00	64.00	TM10075M	TMMK1000-075M
	0.80	M5	3	3.60	4.00	8.00	51.00	TM50080M	TMMK0500-080M
	1.00	M6	3	4.60	6.00	12.00	58.00	TM60100M	TMMK0600-100M
	1.00	M12	4	9.40	10.00	20.00	73.00	TM12100M	TMMK1200-100M
	1.25	M8	3	5.90	6.00	16.25	58.00	TM80125M	TMMK0800-125M
	1.50	M10	4	7.40	8.00	19.50	64.00	TM10150M	TMMK1000-150M
	1.50	M14	4	10.90	12.00	27.00	84.00	TM14150M	TMMK1400-150M
	1.50	M18	4	11.90	12.00	31.50	84.00	TM18150M	TMMK1800-150M
	1.50	M20	5	15.75	16.00	36.00	93.00	TM20150M	—
	1.75	M12	4	9.40	10.00	22.71	73.00	TM12175M	TMMK1200-175M
	2.00	M14	4	10.90	12.00	28.00	84.00	TM14200M	TMMK1400-200M
	2.00	M16	4	11.95	12.00	30.00	84.00	TM16200M	TMMK2000-200M
	2.50	M20	4	11.90	12.00	30.00	84.00	TM20250M	TMMK2000-250M
	3.00	M24	4	15.90	16.00	36.00	93.00	TM24300M	TMMK2400-300M
	3.50	M30	4	15.75	16.00	38.50	100.00	TM30350M	TMMK3000-350M
	4.00	M36	5	19.90	20.00	40.00	105.00	TM36400M	TMMK3600-400M

*Straight fluted



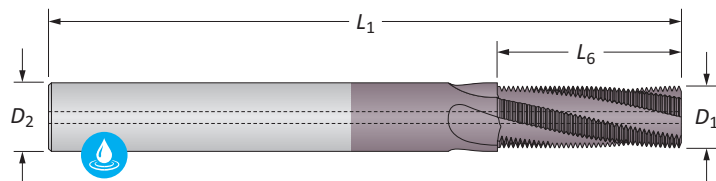
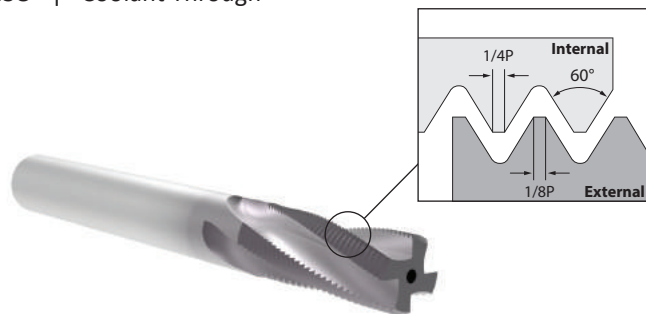
To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TW**MNK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

 = Imperial (in)
 = Metric (mm)



Solid Carbide Thread Mills

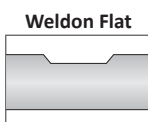
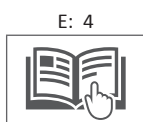
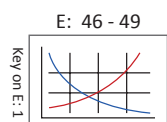
ISO | Coolant Through



ISO | Coolant Through

	Pitch	Min Thread Ø	Flutes	Thread Mill				Part No.
				D ₁	D ₂	L ₆	L ₁	ThreadMills USA
m	0.40	M2	3*	1.50	3.00	3.20	39.00	TM20040CHM
	0.45	M2.5	3*	1.50	3.00	3.60	39.00	TM25045CHM
	0.50	M3	3*	2.15	3.00	4.50	39.00	TM30050CHM
	0.50	M6	3	4.60	6.00	12.00	58.00	TM60050CHM
	0.50	M10	4	7.95	8.00	15.00	64.00	TM10050CHM
	0.70	M4	3	2.90	3.00	8.00	39.00	TM40070CHM
	0.75	M4.5	3	3.00	4.00	6.75	51.00	TM45075CHM
	0.75	M6	3	4.60	6.00	12.00	58.00	TM60075CHM
	0.75	M10	4	7.95	8.00	15.00	64.00	TM10075CHM
	0.80	M5	3	3.60	4.00	8.00	51.00	TM50080CHM
	1.00	M6	3	4.60	6.00	12.00	58.00	TM60100CHM
	1.00	M12	4	9.40	10.00	20.00	84.00	TM12100CHM
	1.25	M8	3	5.90	6.00	16.25	58.00	TM80125CHM
	1.50	M10	4	7.40	8.00	19.50	64.00	TM10150CHM
	1.50	M14	4	10.90	12.00	27.00	84.00	TM14150CHM
	1.50	M18	4	11.90	12.00	31.50	84.00	TM18150CHM
	1.50	M20	5	15.75	16.00	36.00	93.00	TM20150CHM
	1.75	M12	4	9.40	10.00	22.71	84.00	TM12175CHM
	2.00	M14	4	10.90	12.00	28.00	84.00	TM14200CHM
	2.00	M16	4	11.95	12.00	30.00	84.00	TM16200CHM
	2.50	M20	4	11.90	12.00	30.00	84.00	TM20250CHM
	3.00	M24	4	15.90	16.00	36.00	93.00	TM24300CHM
	3.50	M30	4	15.75	16.00	38.50	100.00	TM30350CHM
	4.00	M36	5	19.90	20.00	40.00	105.00	TM36400CHM

*Straight fluted



To order a thread mill with a Weldon flat, replace the leading TM designator with TW (available for inch shanks 3/8 and above, or metric shanks 6mm and above)
Example: Cylindrical shank = **TM**NK0500-NPT | Weldon shank flat = **TW**NK0500-NPT
NOTE: Weldon flats have a minimum order quantity of 2 pieces

Ⓜ = Imperial (in)
 Ⓜ = Metric (mm)

A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

X

SPECIALS