

THREADING

33-2024

JUNE 2024

METRIC

NPA

New Product Announcement



Internal Coolant



Great Chip
Evacuation



Improved
Surface Quality



SOLID*M***THREAD**

Mill Thread Solid Carbide Step Release Design



Internal Coolant

Great Chip
EvacuationImproved Surface
Quality

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SOLID M-THREAD

Highlights

Step Release Design Reduces Cutting and Deflection Forces, While Improving the Dimensional Stability. The Unique Design Allows Users to Use Extremely Higher Cutting Conditions.

Introducing the new innovative and effective SOLID-M-THREAD

- SOLID-M-THREAD features Internal coolant which allows superb chip evacuation when machining with extremely high feeds per tooth.
- A step release design reduces cutting and deflection forces, while improving dimensional stability. The unique design allows users to machine under extremely higher cutting conditions.

SOLID-M-THREAD improves surface quality, for achieving fine threads, regardless of the clamping conditions and varying cutting values. The IC908 submicron grade is recommended for all materials from ISO groups P, M, K, N and S up to 48 HRC.

Customers will benefit from cost-effective and simplified handling due to the short machining time and long tool life. In addition, radius corrections are unnecessary in most thread profiles.

SOLID-M-THREAD has metric fine and UNF threads in dimensions from M4 to M20.

[Click for Short Video](#)

NPA

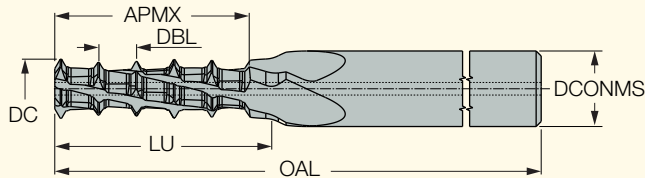
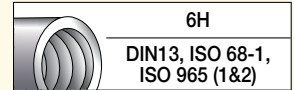
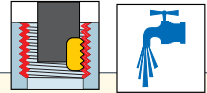
New Product Announcement

SOLID M THREAD

MTECM-ISO

Solid Carbide Internal Threading Endmill Step Release, Lead x3 With Coolant Holes, Used for ISO Thread Profile.

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5151&mapp=TH&GFSTYP=M&srch=1>



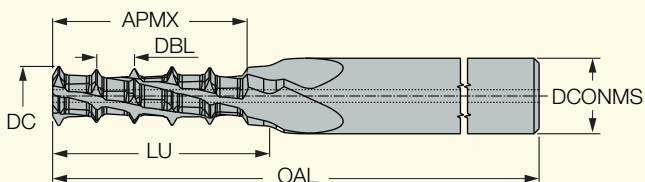
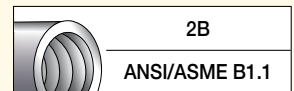
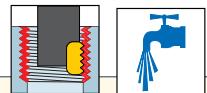
Designation	Dimensions											Tough ↔ Hard		
	Pitch	M Coarse	M Fine	DBL	APMX	LU	OAL	NOF ⁽¹⁾	DCONMS	DC	Shank	IC908	IC903	IC902
	MTECM 06031C11 0.7ISO	0.700	M4	-	2.10	10.80	16.00	58.00	3	6.00	3.10	C	●	
MTECM 06039C12 0.8ISO	0.800	M5	-	2.40	13.20	19.00	58.00	3	6.00	3.90	C	●		
MTECM 06047D14 1.0ISO	1.000	M6	-	3.00	15.40	17.20	58.00	4	6.00	4.70	C	●		
MTECM 08079E21 1.0ISO	1.000	-	M10	3.00	21.40	-	64.00	5	8.00	7.90	C	●		
MTECM 10096D32 1.75ISO	1.750	M12	-	5.25	32.30	39.20	81.00	4	10.00	9.60	C	●		
MTECM 16131E32 2.0ISO	2.000	M16	-	6.00	32.90	41.50	93.00	5	16.00	13.10	C	●		
MTECM 16131E42 2.0ISO	2.000	M16	-	6.00	42.90	53.00	105.00	5	16.00	13.10	C	●	●	●

⁽¹⁾ Number of flutes

MTECM-UN

Solid Carbide Internal Threading Endmill Step Release, Lead x3 With Coolant Hole, Used for UN Thread Profiles.

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5152&mapp=TH&GFSTYP=M&srch=1>



Designation	Dimensions											NOF ⁽¹⁾	IC908
	Pitch	UNC	UNF	UNEF	DBL	APMX	LU	OAL	DCONMS	DC	Shank		
MTECM 0250C28 32UN	0.794	#8			2.38	7.50	13.40	63.50	6.35	3.10	C	3	●
MTECM 0250C50 24UN	1.058	#10			3.17	13.20	17.00	63.50	6.35	3.50	C	3	●
MTECM 0250C65 20UN	1.270	1/4			3.81	17.10	25.90	63.50	6.35	4.70	C	3	●
MTECM 06047C16 20UN	1.270	1/4			3.81	17.10	25.90	58.00	6.00	4.70	C	3	●
MTECM 0312D09 16UN	1.587	3/8			4.76	24.50	25.50	63.50	7.94	7.40	C	4	●

⁽¹⁾ Number of flutes

NPA

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SOLID M THREAD

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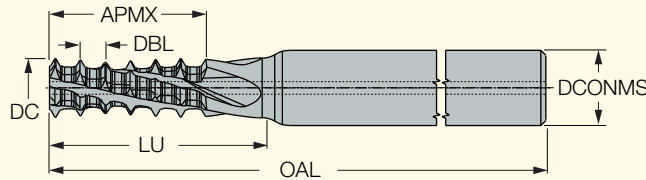
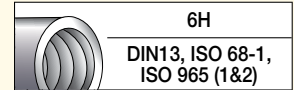
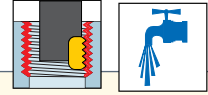
METRIC

MTECK-ISO

Solid Carbide Internal Threading Endmill Step Release,

Lead x2 With Coolant Hole, Used for ISO Thread Profile.

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5153&mapp=TH&GFSTYP=M&srch=1>



Designation	Dimensions											IC908
	Pitch	M Coarse	M Fine	DBL	APMX	LU	OAL	NOF ⁽¹⁾	DCONMS	DC	Shank	
MTECK 06032D8 0.5ISO	0.500	-	M4	1.00	8.20	16.60	58.00	4	6.00	3.20	C	●
MTECK 06031C9 0.7ISO	0.700	M4	-	1.40	8.70	14.00	58.00	3	6.00	3.10	C	●
MTECK 06039C10 0.8ISO	0.800	M5	-	1.60	10.80	16.00	58.00	3	6.00	3.90	C	●
MTECK 06047D12 1.0ISO	1.000	M6	-	2.00	12.50	17.50	58.00	4	6.00	4.70	C	●
MTECK 08063D16 1.25ISO	1.250	M8	-	2.50	16.90	22.50	64.00	4	8.00	6.30	C	●
MTECK 08079D21 1.5ISO	1.500	M11	-	3.00	21.70	-	64.00	4	8.00	7.90	C	●
MTECK 120117E28 1.5ISO	1.500	-	M16	3.00	29.30	-	94.00	5	12.00	11.70	C	●
MTECK 160125F33 1.5ISO	1.500	-	M16	3.00	33.70	40.00	93.00	6	16.00	12.50	C	●
MTECK10098E24 1.5ISO	1.500	-	M13	3.00	24.80	24.10	73.00	5	10.00	9.80	C	●
MTECK 10096D24 1.75ISO	1.750	M12	-	3.50	25.30	30.50	73.00	4	10.00	9.60	C	●
MTECK 12112D28 2.0ISO	2.000	M16	-	4.00	28.90	36.50	84.00	4	12.00	11.20	C	●

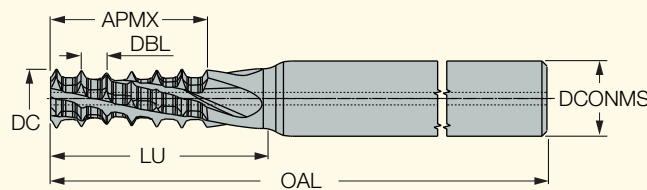
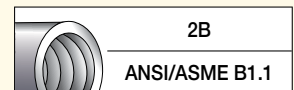
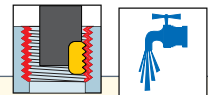
⁽¹⁾ Number of flutes

MTECK-UN

Solid Carbide Internal Threading Endmill Step Release,

Lead x2 With Coolant Hole, Used for UN Thread Profiles.

<https://www.iscar.com/eCatalog/Family.aspx?fnum=5154&mapp=TH&GFSTYP=M&srch=1>



Designation	Dimensions												IC908
	Pitch	UNC	UNF	UNEF	DBL	APMX	LU	OAL	DCONMS	DC	Shank	NOF ⁽¹⁾	
MTECK 0250C34 32UN	0.794	#8			1.59	9.10	15.00	63.50	6.35	3.10	C	3	●
MTECK 0250D50 28UN	0.907		1/4		1.81	13.10	18.80	63.50	6.35	5.00	C	4	●
MTECK 06035C10 24UN	1.058	#10			2.12	11.00	15.50	58.00	6.00	3.50	C	3	●
MTECK 0250C50 20UN	1.270	1/4			2.54	13.30	19.50	63.50	6.35	4.70	C	3	●
MTECK 12011E29 18UN	1.411		9/16		2.82	30.40	34.90	84.00	12.00	11.00	C	5	●
MTECK 0250D67 18UN	1.411	5/16			2.82	17.60	999.00	63.50	6.35	6.10	C	4	●
MTECK 08061D17 18UN	1.411	5/16			2.82	17.60	23.50	64.00	8.00	6.10	C	4	●
MTECK 08061D22 18UN	1.411	5/16			2.82	23.20	30.90	76.00	8.00	6.10	C	4	●
MTECK 08074D19 16UN	1.587	3/8			3.17	19.80	24.50	64.00	8.00	7.40	C	4	●
MTECK 1298D25 13UN	1.954	1/2			3.91	26.30	34.50	84.00	12.00	9.80	C	4	●

⁽¹⁾ Number of flutes

