

## Recommended internal thread milling Tool & Insert selection

METRIC COARSE		
THREAD SIZE	TOOLHOLDER	INSERT
M16 x 2	F14S20B012X20-1	F14N2.0ISO
M18 x 2.5	F14S20B012X20 ..-1	F14SN2.5ISO
M20 x 2.5	F14S20B015X ..-1	F14SN2.5ISO
M22 x 2.5	F14S20B017X ..-1	F14SN2.5ISO
M24 x 3	F21S20B019X ..-1	F21N3ISO
M27 x 3	F21S20B020X ..-1	F21N3ISO
M30 x 3.5	F21S20B020X ..-1	F21SN3.5ISO
M33 X 3.5	F21S20B020X ..-1	F21SN3.5ISO
M36 x 4	F30S25B029X ..-1	F30N4.0ISO
M39 x 4	F30S25B029X ..-1	F30N4.0ISO
M42 x 4.5	F30S25B029X ..-1	F30SN4.5ISO
M45 x 4.5	F30S25B029X ..-1	F30SN4.5ISO
M48 x 5	F30S32B040X70-2	F30SN5.0ISO
M52 x 5	F30S32B040X70-2	F30SN5.0ISO
M56 x 5.5	F40S40B044X82-1	F40N5.5ISO
M60 x 5.5	F40S40B044X82-1	F40N5.5ISO
M64 x 6	F40S40B050X82-2	F40N6.0ISO

UNC		
THREAD SIZE	TOOLHOLDER	INSERT
5/8" x 11	F14S20B012X20-1	F14SN11UN
3/4" x 10	F14S20B015X ..-1	F14SN10UN
1" x 8	F21S20B019X..-1	F21N8UN
1-1/8" x 7	F21S20B020X ..-1	F21SN7UN
1-1/4" x 7	F21S20B020X ..-1	F21SN7UN
1-3/8" x 6	F30S25B029X ..-1	F30N6UN
1-1/2" x 6	F30S25B029X ..-1	F30N6UN
1-3/4" x 5	F30S25B029X ..-1	F30N5UN
2" x 4.5	F30S32B038X ..-1	F30SN4.5UN
2-1/4" x 4.5	F30S32B040X70-2	F30SN4.5UN
2-1/2" x 4	F40S40B044X82-1	F40SN4UN

UNF		
THREAD SIZE	TOOLHOLDER	INSERT
5/8" x 18	F14S20B012X20-1	F14N18UN
3/4" x 16	F14S20B015X ..-1	F14N16UN
7/8" x 14	F14S20B017X ..-1	F14N14UN
1" x 12	F14S20B017X ..-1	F14N12UN
1-1/8" x 12	F21S20B020X ..-1	F21N12UN
1-1/4" x 12	F21S20B020X ..-1	F21N12UN
1-3/8" x 12	F30S25B029X ..-1	F30N12UN
1-1/2" x 12	F30S25B029X ..-1	F30N12UN
1-3/4" x 12	F30S25B029X ..-1	F30N12UN
2" x 12	F30S32B040X70-2	F30N12UN
2-1/4" x 12	F30S32B040X70-2	F30N12UN
2-1/2" x 12	F30S32B040X70-2	F30N12UN

UNEF		
THREAD SIZE	TOOLHOLDER	INSERT
5/8" x 24	F14S20B012X20-1	F14N24UN
3/4" x 20	F14S20B015X ..-1	F14N20UN
7/8" x 20	F14S20B017X ..-1	F14N20UN
1" x 20	F14S20B017X ..-1	F14N20UN
1-1/8" x 18	F21S20B020X ..-1	F21N18UN
1-1/4" x 18	F21S20B020X ..-1	F21N18UN
1-3/8" x 18	F21S20B020X ..-1	F21N18UN
1-1/2" x 18	F21S25B030X50-2	F21N18UN
1-3/4" x 18	F21S25B030X50-2	F21N18UN
2" x 18	F21S25B030X50-2	F21N18UN
2-1/4" x 18	F21S25B030X50-2	F21N18UN
2-1/2" x 18	F21S25B030X50-2	F21N18UN

BSW		
THREAD SIZE	TOOLHOLDER	INSERT
5/8" x 11	F14S20B012X20-1	F14SX11W
11/16" x 11	F14S20B012X20-1	F14SX11W
3/4" x 10	F14S20B015X ..-1	F14SX11W
13/16" x 10	F14S20B017X ..-1	F14SX11W
15/16" x 9	F21S20B019X ..-1	F21X9W
1" x 8	F21S20B020X ..-1	F21SX8W

BSF		
THREAD SIZE	TOOLHOLDER	INSERT
5/8" x 14	F14S20B012X20-1	F14X14W
11/16" x 14	F14S20B015X ..-1	F14X14W
3/4" x 12	F14S20B015X ..-1	F14SX12W
7/8" x 11	F14S20B017X ..-1	F14SX11W
1" x 10	F21S20B020X ..-1	F21X10W
1-1/8" x 9	F21S20B020X ..-1	F21X9W
1-1/4" x 9	F21S20B020X ..-1	F21X9W
1-3/8" x 8	F30S25B029X ..-1	F30SX8W
1-1/2" x 8	F30S25B029X ..-1	F30SX8W

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BSP ( G )		
THREAD SIZE	TOOLHOLDER	INSERT
3/8" x 19	F14S20B012X20-1	F14X19W
1/2" x 14	F14S20B015X ..-1	F14X14W
5/8" x 14	F14S20B015X ..-1	F14X14W
3/4" x 14	F21S20B020X ..-1	F21X14W
7/8" x 14	F21S20B020X ..-1	F21X14W
1" x 11	F21S20B020X ..-1	F21X11W
1-1/8" x 11	F30S25B029X ..-1	F30X11W
1-1/4" x 11	F30S25B029X ..-1	F30X11W
1-1/2" x 11	F30S32B040X70-2	F30X11W
1-3/4" x 11	F30S32B040X70-2	F30X11W
2" x 11	F30S32B040X70-2	F30X11W
2-1/4" x 11	F30S32B040X70-2	F30X11W
2-1/2" x 11	F40S40B050X82-2	F40X11W

BSPT ( R )		
THREAD SIZE	TOOLHOLDER	INSERT
3/8" x 19	F14S20B012X20-1	F14X19BSPT
1/2" x 14	F14S20B017X ..-1	F14X14BSPT
3/4" x 14	F21S20B020X ..-1	F21X14BSPT
1" x 11	F30S25B029X ..-1	F30X11BSPT
1-1/4" x 11	F30S25B029X ..-1	F30X11BSPT
1-1/2" x 11	F30S25B029X ..-1	F30X11BSPT
2" x 11	F40S40B050X82-2	F40X11BSPT
2-1/2" x 11	F40S40B050X82-2	F40X11BSPT

NPT		
THREAD SIZE	TOOLHOLDER	INSERT
3/8" x 18	F14S20B012X20-1	F14X18NPT
1/2" x 14	F14S20B015X ..-1	F14X14NPT
5/8" x 14	F14S20B015X ..-1	F14X14NPT
3/4" x 14	F21S20B020X ..-1	F21X14NPT
7/8" x 14	F21S20B020X ..-1	F21X14NPT
1" x 11.5	F21S20B020X ..-1	F21X11.5NPT
1-1/4" x 11.5	F30S25B029X ..-1	F30X11.5NPT
1-1/2" x 11.5	F30S32B040X70-2	F30X11.5NPT
2" x 11.5	F30S32B040X70-2	F30X11.5NPT
2-1/2" x 8	F40S40B050X82-2	F40X11.5NPT

NPTF		
THREAD SIZE	TOOLHOLDER	INSERT
3/8" x 18	F14S20B012X20-1	F14X18NPTF
1/2" x 14	F14S20B015X ..-1	F14X14NPTF
5/8" x 14	F14S20B015X ..-1	F14X14NPTF
3/4" x 14	F21S20B020X ..-1	F21X14NPTF
7/8" x 14	F21S20B020X ..-1	F21X14NPTF
1" x 11.5	F21S20B020X ..-1	F21X11.5NPTF
1-1/4" x 11.5	F30S25B029X ..-1	F30X11.5NPTF
1-1/2" x 11.5	F30S32B040X70-2	F30X11.5NPTF
2" x 11.5	F30S32B040X70-2	F30X11.5NPTF
2-1/2" x 8	F40S40B050X82-2	F40X8NPTF