

Recommended internal thread milling
Tool & Insert selection

METRIC

THREAD SIZE	F14		F21		F30		F40	
	TOOLHOLDER	INSERT	TOOLHOLDER	INSERT	TOOLHOLDER	INSERT	TOOLHOLDER	INSERT
M16 x 1	F14S20B012X20-1	F14N1.0ISO						
M16 x 1.5	F14S20B012X20-1	F14N1.5ISO						
M16 x 2	F14S20B012X20-1	F14N2.0ISO						
M17 x 1	F14S20B012X20-1	F14N1.0ISO						
M17 x 1.5	F14S20B012X20-1	F14N1.5ISO						
M18 x 1	F14S20B012X20-1	F14N1.0ISO						
M18 x 1.5	F14S20B012X20-1	F14N1.5ISO						
M18 x 2	F14S20B012X20-1	F14N2.0ISO						
M18 x 2.5	F14S20B012X20-1	F14SN2.5ISO						
M20 x 1	F14S20B015X ...-1	F14N1.0ISO						
M20 x 1.5	F14S20B015X ...-1	F14N1.5ISO						
M20 x 2	F14S20B015X ...-1	F14N2.0ISO						
M20 x 2.5	F14S20B015X ...-1	F14SN2.5ISO						
M22 x 1	F14S20B017X ...-1	F14N1.0ISO						
M22 x 1.5	F14S20B017X ...-1	F14N1.5ISO						
M22 x 2	F14S20B017X ...-1	F14N2.0ISO						
M22 x 2.5	F14S20B017X ...-1	F14SN2.5ISO						
M24 x 1	F14S20B020X40-2	F14N1.0ISO						
M24 x 1.5	F14S20B020X40-2	F14N1.5ISO						
M24 x 2	F14S20B017X ...-1	F14N2.0ISO						
M24 x 3			F21S20B019X ...-1	F21N3.0ISO				
M25 x 1	F14S20B020X40-2	F14N1.0ISO	F21S20B020X ...-1	F21N1.0ISO				
M25 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S20B020X ...-1	F21N1.5ISO				
M25 x 2	F14S20B020X40-2	F14N2.0ISO	F21S20B020X ...-1	F21N2.0ISO				
M27 x 1	F14S20B020X40-2	F14N1.0ISO	F21S20B020X ...-1	F21N1.0ISO				
M27 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S20B020X ...-1	F21N1.5ISO				
M27 x 2	F14S20B020X40-2	F14N2.0ISO	F21S20B020X ...-1	F21N2.0ISO				
M27 x 3			F21S20B020X ...-1	F21N3.0ISO				
M28 x 1	F14S20B020X40-2	F14N1.0ISO	F21S20B020X ...-1	F21N1.0ISO				
M28 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S20B020X ...-1	F21N1.5ISO				
M28 x 2	F14S20B020X40-2	F14N2.0ISO	F21S20B020X ...-1	F21N2.0ISO				
M30 x 1	F14S20B020X40-2	F14N1.0ISO	F21S20B020X ...-1	F21N1.0ISO				
M30 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S20B020X ...-1	F21N1.5ISO				
M30 x 2	F14S20B020X40-2	F14N2.0ISO	F21S20B020X ...-1	F21N2.0ISO				
M30 x 3			F21S20B020X ...-1	F21N3.0ISO				
M30 x 3.5			F21S20B020X ...-1	F21SN3.5ISO				
M32 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S20B020X ...-1	F21N1.5ISO				
M32 x 2	F14S20B020X40-2	F14N2.0ISO	F21S20B020X ...-1	F21N2.0ISO				
M33 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S20B020X ...-1	F21N1.5ISO				
M33 x 2	F14S20B020X40-2	F14N2.0ISO	F21S20B020X ...-1	F21N2.0ISO				
M33 x 3			F21S20B020X ...-1	F21N3.0ISO				
M33 x 3.5			F21S20B020X ...-1	F21SN3.5ISO				
M35 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S25B029X ...-1	F30N1.5ISO		
M36 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S25B029X ...-1	F30N2.0ISO		
M36 x 3			F21S25B030X50-2	F21N3.0ISO	F30S25B029X ...-1	F30N3.0ISO		
M36 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S25B029X ...-1	F30N4.0ISO		
M38 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S25B029X ...-1	F30N1.5ISO		
M39 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S25B029X ...-1	F30N1.5ISO		
M39 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S25B029X ...-1	F30N2.0ISO		
M39 x 3			F21S25B030X50-2	F21N3.0ISO	F30S25B029X ...-1	F30N3.0ISO		
M39 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S25B029X ...-1	F30N4.0ISO		

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THREAD SIZE	F14		F21		F30		F40	
	TOOLHOLDER	INSERT	TOOLHOLDER	INSERT	TOOLHOLDER	INSERT	TOOLHOLDER	INSERT
M40 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S25B029X ..-1	F30N1.5ISO		
M40 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S25B029X ..-1	F30N2.0ISO		
M40 x 3			F21S25B030X50-2	F21N3.0ISO	F30S25B029X ..-1	F30N3.0ISO		
M42 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S25B029X ..-1	F30N1.5ISO		
M42 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S25B029X ..-1	F30N2.0ISO		
M42 x 3			F21S25B030X50-2	F21N3.0ISO	F30S25B029X ..-1	F30N3.0ISO		
M42 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S25B029X ..-1	F30N4.0ISO		
M42 x 4.5					F30S25B029X ..-1	F30SN4.5ISO		
M45 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S25B029X ..-1	F30N1.5ISO		
M45 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S25B029X ..-1	F30N2.0ISO		
M45 x 3			F21S25B030X50-2	F21N3.0ISO	F30S25B029X ..-1	F30N3.0ISO		
M45 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S25B029X ..-1	F30N4.0ISO		
M45 x 4.5					F30S25B029X ..-1	F30SN4.5ISO		
M48 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S32B040X70-2	F30N1.5ISO		
M48 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S32B040X70-2	F30N2.0ISO		
M48 x 3			F21S25B030X50-2	F21N3.0ISO	F30S32B040X70-2	F30N3.0ISO		
M48 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S32B040X70-2	F30N4.0ISO		
M48 x 5					F30S32B040X70-2	F30SN5.0ISO		
M50 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S32B040X70-2	F30N1.5ISO		
M50 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S32B040X70-2	F30N2.0ISO		
M50 x 3			F21S25B030X50-2	F21N3.0ISO	F30S32B040X70-2	F30N3.0ISO		
M52 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S32B040X70-2	F30N1.5ISO		
M52 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S32B040X70-2	F30N2.0ISO		
M52 x 3			F21S25B030X50-2	F21N3.0ISO	F30S32B040X70-2	F30N3.0ISO		
M52 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S32B040X70-2	F30N4.0ISO		
M52 x 5					F30S32B040X70-2	F30SN5.0ISO		
M55 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S32B040X70-2	F30N1.5ISO	F40S40B044X82-1	F40N1.5ISO
M55 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S32B040X70-2	F30N2.0ISO	F40S40B044X82-1	F40N2.0ISO
M55 x 3			F21S25B030X50-2	F21N3.0ISO	F30S32B040X70-2	F30N3.0ISO	F40S40B044X82-1	F40N3.0ISO
M55 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S32B040X70-2	F30N4.0ISO	F40S40B044X82-1	F40N4.0ISO
M56 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S32B040X70-2	F30N1.5ISO	F40S40B050X82-2	F40N1.5ISO
M56 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S32B040X70-2	F30N2.0ISO	F40S40B050X82-2	F40N2.0ISO
M56 x 3			F21S25B030X50-2	F21N3.0ISO	F30S32B040X70-2	F30N3.0ISO	F40S40B044X82-1	F40N3.0ISO
M56 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S32B040X70-2	F30N4.0ISO	F40S40B044X82-1	F40N4.0ISO
M56 x 5.5					F30S32B040X70-2	F30SN5.5ISO	F40S40B044X82-1	F40N5.5ISO
M58 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S32B040X70-2	F30N1.5ISO	F40S40B050X82-2	F40N1.5ISO
M58 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S32B040X70-2	F30N2.0ISO	F40S40B050X82-2	F40N2.0ISO
M58 x 3			F21S25B030X50-2	F21N3.0ISO	F30S32B040X70-2	F30N3.0ISO	F40S40B050X82-2	F40N3.0ISO
M58 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S32B040X70-2	F30N4.0ISO	F40S40B044X82-1	F40N4.0ISO
M60 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S32B040X70-2	F30N1.5ISO	F40S40B050X82-2	F40N1.5ISO
M60 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S32B040X70-2	F30N2.0ISO	F40S40B050X82-2	F40N2.0ISO
M60 x 3			F21S25B030X50-2	F21N3.0ISO	F30S32B040X70-2	F30N3.0ISO	F40S40B050X82-2	F40N3.0ISO
M60 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S32B040X70-2	F30N4.0ISO	F40S40B050X82-2	F40N4.0ISO
M60 x 5.5					F30S32B040X70-2	F30SN5.5ISO	F40S40B050X82-2	F40N5.5ISO
M62 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S32B040X70-2	F30N1.5ISO	F40S40B050X82-2	F40N1.5ISO
M62 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S32B040X70-2	F30N2.0ISO	F40S40B050X82-2	F40N2.0ISO
M62 x 3			F21S25B030X50-2	F21N3.0ISO	F30S32B040X70-2	F30N3.0ISO	F40S40B050X82-2	F40N3.0ISO
M62 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S32B040X70-2	F30N4.0ISO	F40S40B050X82-2	F40N4.0ISO
M64 x 1.5	F14S20B020X40-2	F14N1.5ISO	F21S25B030X50-2	F21N1.5ISO	F30S32B040X70-2	F30N1.5ISO	F40S40B050X82-2	F40N1.5ISO
M64 x 2	F14S20B020X40-2	F14N2.0ISO	F21S25B030X50-2	F21N2.0ISO	F30S32B040X70-2	F30N2.0ISO	F40S40B050X82-2	F40N2.0ISO
M64 x 3			F21S25B030X50-2	F21N3.0ISO	F30S32B040X70-2	F30N3.0ISO	F40S40B050X82-2	F40N3.0ISO
M64 x 4			F21S25B030X50-2	F21SN4.0ISO	F30S32B040X70-2	F30N4.0ISO	F40S40B050X82-2	F40N4.0ISO
M64 x 6					F30S32B040X70-2	F30SN6.0ISO	F40S40B050X82-2	F40N6.0ISO