

MINI-/SOLID CARBIDE MILL THREAD PROMO

FOR FAST MACHINING AND HIGH CUTTING STABILITY

BUY **3**

SOLID CARBIDE MILL THREAD

of Type FT, FMTZ, FMT, FSH or FMTI

PAY ONLY **2**

(The cheapest one is for free.)



FT FMTZ FMT FSH FMTI

Choose between different Solid Carbide Mill Threads: FT, FMTZ, FMT, FSH oder FMTI

If you buy 3 Solid Carbide Thread Milling Cutters, you will receive the cheapest one for free.

Promotion is **only** valid for the Solid Carbide Thread Mills listed above.

FT Type – Solid Carbide Thread Mill



P M K S

NEW

- right hand cutting with left hand helix
- offers more flutes for increased productivity
- lower tool vibrations and High Surface Finish

FMTZ Type – Solid Carbide Thread Mill



P M K S

NEW

- right hand cutting with left hand helix
- equipped with radial coolant holes
- Smooth cutting and reduced cutting forces during process

FMT Type – Solid Carbide Thread Mill



P M K S

- for increased productivity and extended tool life
- large number of flutes results in significantly shorter machining time
- fast Thread Mills with internal coolant bore

FSH Type – Hardcut



P S

- High productive Solid Carbide Mill Threads with a large number of flutes for machining hard materials up to 65 HRC

FMTI Type – Mini Mill-Thread

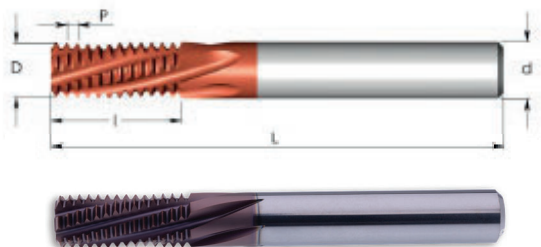


P M S

- increased productivity and high performance.
- with a large number of flutes that enables to achieve significant shorter machining time

ISO

Tools for Internal Thread



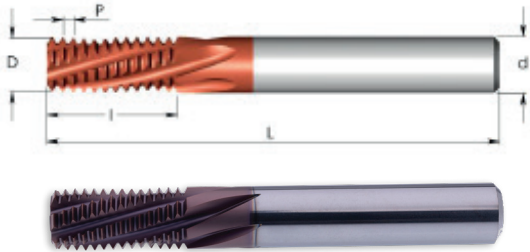
Grade	P	M	K	N	S	H
MT6	●	●	●	○	●	≤55 HRc

Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	l	L
1.0	M6	M8	FT 06048 E10 1.0ISO	6	4.8	5	10.5	57
1.0		M8, M9	FT 0606 E12 1.0ISO	6	6.0	5	12.5	57
1.0		M10	FT 0808 F16 1.0ISO	8	8.0	6	16.5	63
1.0		M12, M14	FT 12107 F24 1.0ISO	12	10.7	6	24.5	83
1.25	M8	M10	FT 08064 E14 1.25ISO	8	6.4	5	14.4	63
1.5	M10	M12	FT 08078 E17 1.5ISO	8	7.8	5	17.0	63
1.5		M14	FT 1010 F21 1.5ISO	10	10.0	6	21.8	72
1.5		M14, M16	FT 1212 F26 1.5ISO	12	12.0	6	26.3	83
1.5		M16, M18	FT 1414 F32 1.5ISO	14	14.0	6	32.3	100
1.5		M20	FT 1616 F33 1.5ISO	16	16.0	6	33.8	105
1.75	M12		FT 10095 F20 1.75ISO	10	9.5	6	20.1	72

Order example: FT 1212 F31 16UN MT6

UN

Tools for Internal Thread



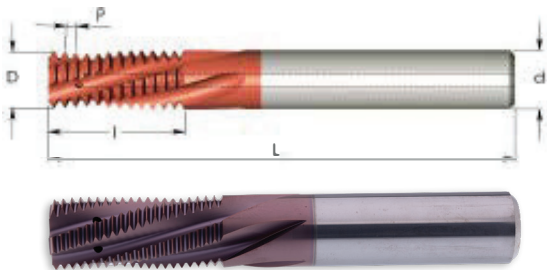
Grade	P	M	K	N	S	H
MT6	●	●	●	○	●	≤55 HRc

Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	I	L
28		1/4		FT 06052 E11 28UN	6	5.2	5	11.3	57
24		5/16		FT 08066 E14 24UN	8	6.6	5	14.3	63
24		3/8	9/16-5/8	FT 0808 F21 24UN	8	8.0	6	20.6	63
20	1/4			FT 06048 D12 20UN	6	4.8	4	12.1	57
20		7/16-1/2		FT 0808 F21 20UN	8	8.0	6	21.0	63
20			3/4-1	FT 1212 F27 20UN	12	12.0	6	27.3	83
18	5/16			FT 0606 E14 18UN	6	6.0	5	14.8	57
18		9/16-5/8	1 1/8-1 5/8	FT 12113 F26 18UN	12	11.3	6	26.1	83
16	3/8			FT 08074 E16 16UN	8	7.4	5	16.7	63
16		3/4		FT 1212 F31 16UN	12	12.0	6	31.0	83
14	7/16			FT 10085 E20 14UN	10	8.5	5	20.9	72
14		7/8		FT 1616 F37 14UN	16	16.0	6	37.2	105
13	1/2			FT 10098 E22 13UN	10	9.8	5	22.5	72
12	9/16			FT 12116 F26 12UN	12	11.6	6	26.5	83
12		1-1 1/2		FT 1616 F41 12UN	16	16.0	6	41.3	105
11	5/8			FT 1212 E28 11UN	12	12.0	5	28.9	83
10	3/4			FT 16147 E34 10UN	16	14.7	5	34.3	105
8	1			FT 20195 F42 8UN	20	19.5	6	42.9	104

Order example: FT 1212 F31 16UN MT6

ISO With internal coolant through the flutes

Tools for Internal Thread



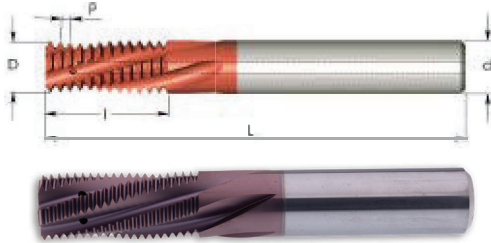
Grade	P	M	K	N	S	H
MT6	●	●	●	○	●	≤55 HRC

Pitch mm	M coarse	M fine	Ordering Code	d	D	No. of Flutes	I	L
1.0	M6	M8	FMTZ 06048 C10 1.0ISO	6	4.8	3	10.5	58
1.0		M8, M9	FMTZ 0606 C12 1.0ISO	6	6.0	3	12.5	58
1.0		M10	FMTZ 0808 D16 1.0ISO	8	8.0	4	16.5	64
1.0		M12, M14	FMTZ 12107 E24 1.0ISO	12	10.7	5	24.5	84
1.25	M8	M10	FMTZ 08064 D14 1.25ISO	8	6.4	4	14.4	64
1.5	M10	M12	FMTZ 08078 C17 1.5ISO	8	7.8	3	17.0	64
1.5		M14	FMTZ 1010 D21 1.5ISO	10	10.0	4	21.8	73
1.5		M14, M16	FMTZ 1212 D26 1.5ISO	12	12.0	4	26.3	84
1.5		M16, M18	FMTZ 1414 E32 1.5ISO	14	14.0	5	32.3	101
1.5		M20	FMTZ 1616 E33 1.5ISO	16	16.0	5	33.8	101
1.75	M12		FMTZ 10095 E20 1.75ISO	10	9.5	5	20.1	73

Order example: FMTZ 08078 C17 1.5ISO MT6

UN With internal coolant through the flutes

Tools for Internal Thread

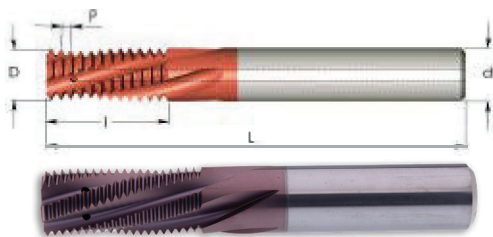


Grade	P	M	K	N	S	H
MT6	●	●	●	○	●	≤55 HRc

Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	No. of Flutes	I	L
28		1/4		FMTZ 06052 D11 28UN	6	5.2	4	11.3	58
24		5/16		FMTZ 08066 D14 24UN	8	6.6	4	14.3	64
24		3/8	9/16-5/8	FMTZ 0808 D21 24UN	8	8.0	4	20.6	64
20		7/16-1/2		FMTZ 0808 C21 20UN	8	8.0	3	21.0	64
20			3/4-1	FMTZ 1212 E27 20UN	12	12.0	5	27.3	84
18	5/16			FMTZ 0606 D14 18UN	6	6.0	4	14.8	58
18		9/16-5/8	1 1/8-1 5/8	FMTZ 12113 D26 18UN	12	11.3	4	26.1	84
16	3/8			FMTZ 08074 D16 16UN	8	7.4	4	16.7	64
16		3/4		FMTZ 1212 D31 16UN	12	12.0	4	31.0	84
14	7/16			FMTZ 10085 D20 14UN	10	8.5	4	20.9	73
14		7/8		FMTZ 1616 E37 14UN	16	16.0	5	37.2	101
13	1/2			FMTZ 10098 E22 13UN	10	9.8	5	22.5	73
12	9/16			FMTZ 12116 E26 12UN	12	11.6	5	26.5	84
12		1-1 1/2		FMTZ 1616 E41 12UN	16	16.0	5	41.3	101
11	5/8			FMTZ 1212 E28 11UN	12	12.0	5	28.9	84
10	3/4			FMTZ 16147 E34 10UN	16	14.7	5	34.3	101
8	1			FMTZ 20195 E42 8UN	20	19.5	5	42.9	105

Order example: FMTZ 1212 D31 16UN MT6

G (55°) BSF, BSP With internal coolant through the flutes



Grade	P	M	K	N	S	H
MT6	●	●	●	○	●	≤55 HRC

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/8	FMTZ 08078 C14 28W	8	7.8	3	14.1	64
19	G1/4-3/8	FMTZ 1010 D16 19W	10	10.0	4	16.7	73
19	G1/4-3/8	FMTZ 1010 D26 19W	10	10.0	4	26.1	73
14	G1/2-7/8	FMTZ 1616 E26 14W	16	16.0	5	26.3	101
11	G≥1	FMTZ 1616 D38 11W	16	16.0	4	38.1	101

Order example: FMTZ 1010 D26 19W MT6

Cutting Data

ISO Standard	Material	Cutting Speed m/min	Cutting Diameter = D Feed mm/tooth		
			D ≤ 4	4 < D < 9	D ≥ 9
P	Low & Medium Carbon Steels < 0.55%C	100-250	0.03-0.04	0.03-0.08	0.08-0.12
	High Carbon Steels ≥ 0.55%C	110-180	0.02-0.03	0.02-0.07	0.07-0.10
	Alloy Steels, Treated Steels	90-160	0.02-0.03	0.03-0.06	0.05-0.08
M	Stainless Steel-Free Cutting	60-160	0.02-0.03	0.03-0.06	0.05-0.08
	Stainless Steel-Austenitic	60-120	0.02-0.03	0.03-0.05	0.04-0.07
	Cast Steels	130-170	0.02-0.03	0.03-0.05	0.04-0.07
K	Cast Iron	70-150	0.03-0.04	0.05-0.08	0.08-0.12
N	Aluminum ≤ 12%Si, Copper	150-350	0.03-0.04	0.05-0.08	0.08-0.12
	Aluminum > 12%Si	100-250	0.02-0.03	0.03-0.05	0.04-0.07
	Synthetics, Duroplastics, Thermoplastics	100-400	0.05-0.07	0.07-0.11	0.10-0.15
S	Nickel alloys, Titanium alloys.	20-80	0.02-0.03	0.02-0.03	0.02-0.04
H	Hardened Steel 45-50 HRc	60-70	0.02-0.03	0.02-0.03	0.02-0.04
	Hardened Steel 50-55 HRc	50-60	0.01-0.02	0.01-0.02	0.01-0.03

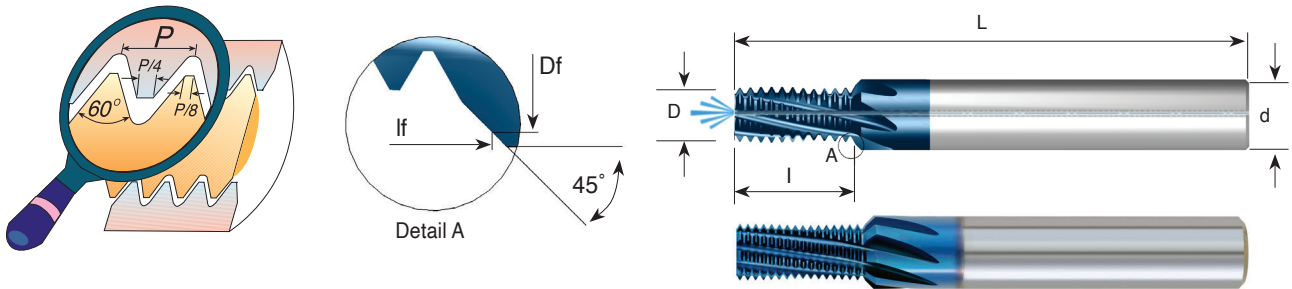
ISO Fast MT with internal coolant bore

Tools for Internal Thread

- A unique line of solid carbide thread milling tools (FMT) for increased productivity and extended tool life.
- Large number of flutes results in significantly shorter machining time.

Carbide grade MT8:

Sub Micron grade with advanced PVD triple coating (ISO K10-K20). Extremely high heat resistance and smooth cutting operation for high performance in normal and general machining conditions on all materials.



Grade	P	M	K	N	S	H
MT8	●	●	●	○	●	≤52 HRc

Pitch mm	M coarse	M fine	Ordering Code	d	D	Df	Flutes	I	lf	L
0.5	M3	M3.5	*FMT 06024 D6 0.5 ISO	6	2.4	4.4	4	6.3	7.3	58
0.5		M4,M5	FMT 06033 E8 0.5 ISO	6	3.3	5.3	5	8.3	9.3	58
0.7	M4		FMT 06032 E7 0.7 ISO	6	3.2	4.8	5	7.4	8.2	58
0.75		M6	FMT 0805 F12 0.75 ISO	8	5.0	7.0	6	12.4	13.4	64
0.8	M5		FMT 0604 E9 0.8 ISO	6	4.0	5.7	5	9.2	10.1	58
1.0	M6	M8	FMT 08048 F10 1.0 ISO	8	4.8	6.8	6	10.5	11.5	64
1.0		M10,M12	FMT 12087 G20 1.0 ISO	12	8.7	11.7	7	20.5	22.0	84
1.25	M8	M10	FMT 10064 G14 1.25 ISO	10	6.4	9.6	7	14.4	16.0	73
1.5	M10	M14	FMT 1008 G17 1.5 ISO	10	8.0	9.8	7	17.3	18.2	73
1.75	M12		FMT 12095 G20 1.75 ISO	12	9.5	11.7	7	20.1	21.2	84
2.0	M14, M16	M18	FMT 1411 G29 2.0 ISO	14	11.0	13.4	7	29.0	30.2	83

Order example: FMT 1008 G17 1.5 ISO MT8

● First choice ○ Alternative

* Without internal coolant

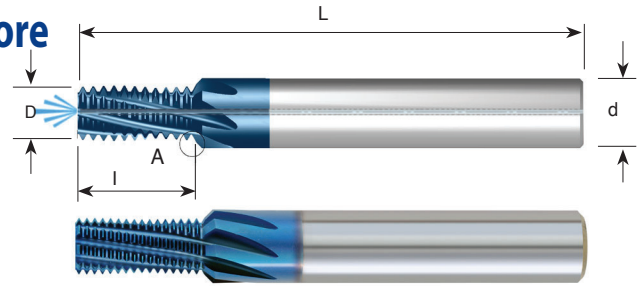
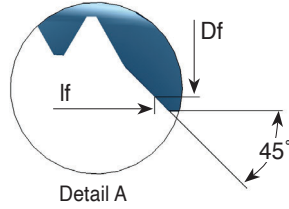
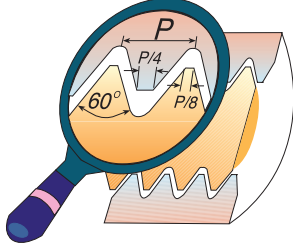
For small thread mills see page B09-17



Mill-Thread Solid Carbide



UN Fast MT with internal coolant bore Tools for Internal Thread



Grade	P	M	K	N	S	H
MT8	●	●	●	○	●	≤52 HRc

Pitch TPI	UNC	UNF	UNEF	Ordering Code	d	D	Df	No. of Flutes	I	If	L
28		1/4		FMT 08052 F11 28 UN	8	5.2	7.0	6	11.3	12.3	64
28			7/16-1/2	FMT 12098 H19 28 UN	12	9.8	11.8	8	19.5	20.5	84
24		5/16		FMT 10066 G14 24 UN	10	6.6	9.6	7	14.3	15.8	73
24		3/8	9/16, 5/8, 11/16	FMT 12082 G17 24 UN	12	8.2	10.6	7	17.5	18.7	84
20	1/4			*FMT 08048 E12 20 UN	8	4.8	6.8	5	12.1	13.1	64
20		7/16		FMT 12092 H21 20 UN	12	9.2	11.4	8	21.0	22.1	84
20		1/2	3/4, 7/8, 1	FMT 14111 H22 20 UN	14	11.1	13.5	8	22.2	23.4	84
18	5/16			FMT 1006 F14 18 UN	10	6.0	8.4	6	14.8	16.0	73
18		9/16, 5/8	1 1/16, 1 1/8	FMT 16125 H26 18 UN	16	12.5	15.0	8	26.1	27.4	105
16	3/8			FMT 10074 F16 16 UN	10	7.4	9.6	6	16.7	17.8	73
16		3/4		FMT 20167 H34 16 UN	20	16.7	19.3	8	34.1	35.4	105
14	7/16	7/8		FMT 12085 F20 14 UN	12	8.5	10.7	6	20.9	22.0	84
13	1/2			FMT 12098 F24 13 UN	12	9.8	11.8	6	24.4	25.4	84
12	9/16	1		FMT 16116 F26 12 UN	16	11.6	15.2	6	26.5	28.3	105
11	5/8			FMT 1612 F33 11 UN	16	12.0	15.4	6	33.4	35.1	105

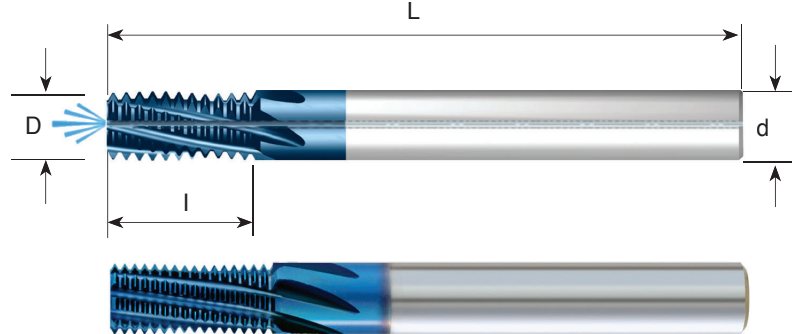
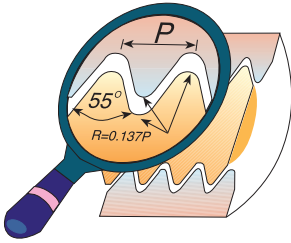
Order example: FMT 12092 H21 20 UN

* without internal coolant

For small thread mills see page B09-17

G (55°) Fast MT With internal coolant bore

Same Tool for Internal and External Thread



Grade	P	M	K	N	S	H
MT8	●	●	●	○	●	≤52 HRc

Pitch TPI	Standard	Ordering Code	d	D	No. of Flutes	I	L
28	G1/8	FMT 08078 H14 28 W	8	7.8	8	14.1	64
19	G1/4-3/8	FMT 1010 G16 19 W	10	10.0	7	16.7	73
14	G1/2-7/8	FMT 1414 H26 14 W	14	14.0	8	26.3	84
11	G≥1	FMT 1616 H38 11 W	16	16.0	8	38.1	105

Order example: FMT 1616 H38 11W MT8

● First choice

○ Alternative

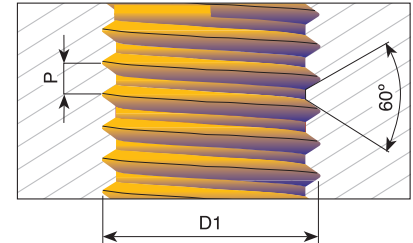
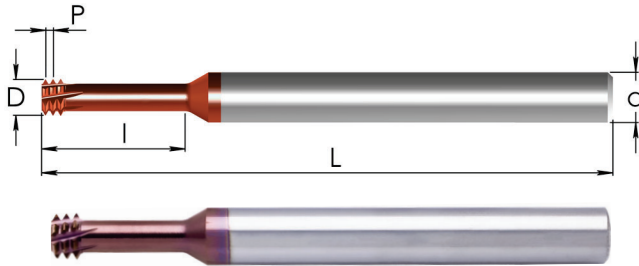
Cutting Data

FMT - Fast MT type

MT8 Sub Micron grade with advanced PVD triple coating (ISO K10-K20).
Extremely high heat resistant and smooth cutting operation, for high performance and normal machining conditions. General purpose for all materials.

ISO Standard	Materials	Cutting Speed m/min	Feed mm/tooth Cutting Diameter = D				
			Ø5	Ø6	Ø8	Ø10	Ø12
P	Low and Medium Carbon Steels < 0.55%C	100 - 250	0.03	0.06	0.07	0.08	0.09
	High Carbon Steels ≥ 0.55%C	110 - 180	0.03	0.05	0.06	0.07	0.08
	Alloy Steels, Treated Steels	90 - 60	0.02	0.03	0.04	0.05	0.05
M	Stainless Steel - Free Cutting	60 - 160	0.03	0.04	0.05	0.06	0.06
	Stainless Steel - Austenitic	60 - 120	0.01	0.03	0.04	0.05	0.05
	Cast Steels	130 - 170	0.02	0.03	0.04	0.05	0.05
K	Cast Iron	70 - 150	0.04	0.06	0.07	0.08	0.09
N	Aluminum ≤ 12%Si, Copper	150 - 350	0.04	0.06	0.07	0.08	0.09
	Aluminum > 12%Si	100 - 250	0.03	0.03	0.04	0.05	0.05
	Synthetics, Duroplastics, Thermoplastics	100 - 400	0.06	0.08	0.10	0.11	0.12
S	Nickel Alloys, Titanium Alloys.	20 - 80	0.02	0.03	0.03	0.03	0.03
H	Hardened Steel, 45-50HRc	60 - 70	0.02	0.03	0.03	0.03	0.03

FSH ISO Tools for Internal Thread



Left hand cutting
For CNC code use M04

Grade	P	M	K	N	S	H
MT3	●	○	○	○	●	≤65 HRc

Pitch mm	M Coarse	M Fine	Ordering Code	d	D	No. of Flutes	I	L	Thread depth
0.45	M2.5		FSH 0602 E5 0.45 ISO	6	1.95	5	5.5	58	2xD1
0.45	M2.5		FSH 0602 E8 0.45 ISO	6	1.95	5	8.0	58	3xD1
0.5	M3	M4,M5	FSH 06024 E6 0.5 ISO	6	2.40	5	6.5	58	2xD1
0.5	M3	M4,M5	FSH 06024 E9 0.5 ISO	6	2.40	5	9.5	58	3xD1
0.7	M4		FSH 06032 E8 0.7 ISO	6	3.20	5	8.7	58	2xD1
0.7	M4		FSH 06032 E12 0.7 ISO	6	3.20	5	12.7	58	3xD1
0.8	M5		FSH 0604 E10 0.8 ISO	6	4.00	5	10.8	58	2xD1
0.8	M5		FSH 0604 E15 0.8 ISO	6	4.00	5	15.8	58	3xD1
1.0	M6	M8	FSH 06048 F13 1.0 ISO	6	4.80	6	13.0	58	2xD1
1.0	M6	M8	FSH 06048 F19 1.0 ISO	6	4.80	6	19.0	58	3xD1
1.25	M8	M10,M12	FSH 08064 G17 1.25 ISO	8	6.40	7	17.3	64	2xD1
1.25	M8	M10,M12	FSH 08064 G25 1.25 ISO	8	6.40	7	25.3	64	3xD1

Order example: FSH 0604 E10 0.8 ISO MT3

UN Tools for Internal Thread

Grade	P	M	K	N	S	H
MT3	●	○	○	○	●	≤65 HRc

Pitch TPI	UNC	UNF	Ordering Code	d	D	No. of Flutes	I	L	Thread depth
40	4		FSH 06021 D6 40 UN	6	2.10	4	6.3	58	2xD1
40	4		FSH 06021 D9 40 UN	6	2.10	4	9.2	58	3xD1
40	5	6	FSH 06024 D7 40 UN	6	2.45	4	7.0	58	2xD1
40	5	6	FSH 06024 D10 40 UN	6	2.45	4	10.2	58	3xD1
32	6		FSH 06025 D7 32 UN	6	2.55	4	7.8	58	2xD1
32	6		FSH 06025 D11 32 UN	6	2.55	4	11.3	58	3xD1
32	8		FSH 06032 D9 32 UN	6	3.20	4	9.1	58	2xD1
32	8		FSH 06032 D13 32 UN	6	3.20	4	13.3	58	3xD1
32		10	FSH 06038 E10 32 UN	6	3.80	5	10.5	58	2xD1
32		10	FSH 06038 E15 32 UN	6	3.80	5	15.3	58	3xD1
28		1/4	FSH 06052 F13 28 UN	6	5.20	6	13.6	58	2xD1
28		1/4	FSH 06052 F20 28 UN	6	5.20	6	20.0	58	3xD1
24		5/16, 3/8	FSH 08066 F16 24 UN	8	6.60	6	16.9	64	2xD1
24		5/16, 3/8	FSH 08066 F24 24 UN	8	6.60	6	24.9	64	3xD1
20	1/4		FSH 06048 E14 20 UN	6	4.80	5	14.0	58	2xD1
20	1/4		FSH 06048 E20 20 UN	6	4.80	5	20.3	58	3xD1

Order example: FSH 08066 F24 24 UN MT3

● First choice ○ Alternative

Cutting Data

Mini Mill-Thread FSH

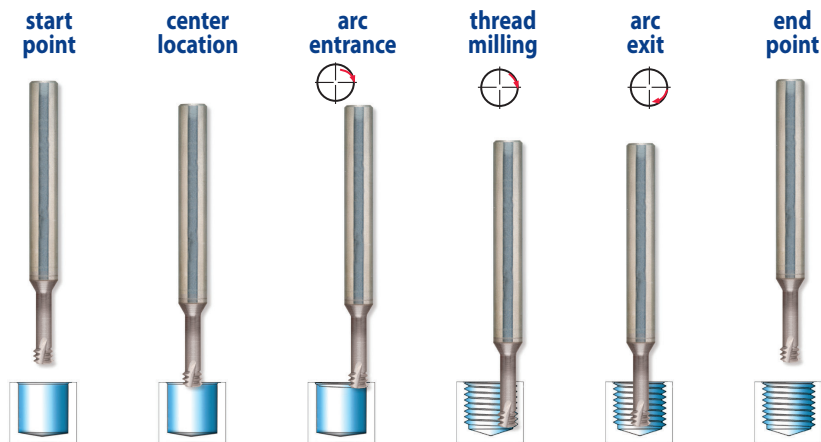
MT9 Sub-Micron Grade with advanced PVD triple coating.

MT6 Ultra-Fine carbide grade with high hardness and toughness provides an excellent solution for machining steels, stainless steels, and super alloys Ni or Ti base. With a universal PVD multi-layer coating, provides high heat and wear resistance.

MT3 Ultra-Fine carbide grade with PVD multi-layer coating for machining Super Alloys and Hard materials up to 65 HRc. Provides supreme edge stability with high heat and wear resistance. For increased productivity and high performance.

Left hand cutting for CNC code use M04

ISO	Materials	Hardness HRc	Cutting Speed m/min	Feed mm/tooth															
				Cutting Diameter = D															
				Ø1	Ø1.5	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø12	Ø14	Ø16		
S	Nickel Alloys, Titanium Alloys and High Temp. Alloys		20-40	0.03	0.03	0.03	0.04	0.04	0.05	0.06	0.06	0.06	0.07	0.07	0.07	0.07	0.08	0.08	
H	Hardened Steels	45 - 50	60 - 70	0.03	0.04	0.04	0.05	0.05	0.06	0.06	0.07	0.07	0.08	0.08	0.09	0.10	0.11		
		51 - 55	50 - 60	0.02	0.03	0.03	0.04	0.04	0.05	0.05	0.06	0.06	0.07	0.07	0.08	0.09	0.10		
		56 - 62	40 - 50	0.01	0.02	0.02	0.03	0.03	0.04	0.04	0.05	0.05	0.06	0.06	0.07	0.08	0.09		



Case Study

Application	Internal Thread M4 X 0.7
Thread Depth	8.0 mm
Workpiece Material	Tool Steel: D2
Hardness	60-62 (HRc)
Cutter Description	MTSH06031C9 0.7 ISO
Machining Conditions	Cutting Speed: 44 m / min Feed: 0.03 mm / tooth
Machine	Mori Seiki VN5000
Control	Fanuc
Cooling Lubricant	Emulsion
Tool Life (No. of Threads)	84

FMTI Multi Flute

CPT has designed a unique line of solid carbide thread milling tools FMTI for increased productivity and high performance.

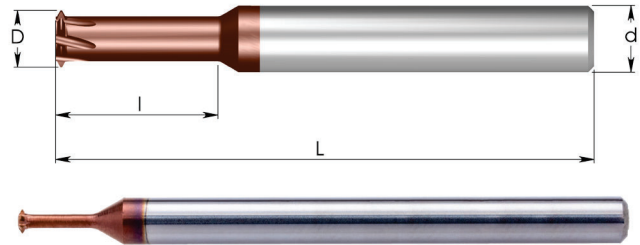
Large number of flutes enables to achieve significant shorter machining time.

Carbide grade: MT6

Ultra-Fine carbide grade with high hardness and toughness provides an excellent solution for machining steels, stainless steels, and super alloys Ni or Ti base. With a universal PVD multi-layer coating, provides high heat and wear resistance.

ISO

Tools for Internal Thread



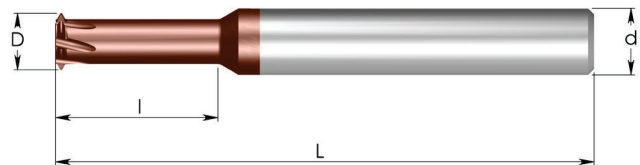
Grade	P	M	K	N	S	H
MT6	●	●	○	○	●	≤58 HRc

Pitch mm	M Coarse	M Fine	Ordering Code	d	D	No. of Flutes	I	L	Thread Depth
0.35	M1.6, M1.8	M2	FMTI 03012 E3 0.35 ISO	3	1.20	5	3.6	38	2xD1
0.4	M2		FMTI 03016 F4 0.4 ISO	3	1.55	6	4.4	38	2xD1
0.45	M2.5		FMTI 0302 F5 0.45 ISO	3	1.95	6	5.5	38	2xD1
0.5	M3	M4, M5	FMTI 03024 F6 0.5 ISO	3	2.40	6	6.5	38	2xD1
0.7	M4		FMTI 04032 F8 0.7 ISO	4	3.20	6	8.7	50	2xD1
0.8	M5		FMTI 0404 G10 0.8 ISO	4	4.00	7	10.8	50	2xD1
1.0	M6	M8	FMTI 06048 G13 1.0 ISO	6	4.80	7	13.0	57	2xD1

Order example: FMTI 03024 F6 0.5 ISO MT6

UN

Tools for Internal Thread



Grade	P	M	K	N	S	H
MT6	●	●	○	○	●	≤58 HRc

Pitch TPI	UNC	UNF	Ordering Code	d	D	No. of Flutes	I	L	Thread Depth
72		1	FMTI 03015 E4 72 UN	3	1.45	5	4.1	38	2xD1
56	2	3	FMTI 03017 F4 56 UN	3	1.65	6	4.8	38	2xD1
40	4		FMTI 03021 F6 40 UN	3	2.10	6	6.3	38	2xD1
32		10	FMTI 04038 F10 32 UN	4	3.80	6	10.5	50	2xD1
28		1/4	FMTI 06052 G13 28 UN	6	5.20	7	13.6	57	2xD1

Order example: FMTI 03017 F4 56 UN MT6

● First choice

○ Alternative

Cutting Data

FMTI types

- MT6** Ultra-Fine carbide grade with high hardness and toughness provides an excellent solution for machining steels, stainless steels, and super alloys Ni or Ti base. With a universal PVD multi-layer coating, provides high heat and wear resistance.
- MT7** Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.
- MT8** Sub-Micron Grade with Aluminum Titanium Nitride (AlTiN) multi-layer coating (ISO K10-K20). Extremely high heat resistant and smooth cutting operation, for high performance, and normal machining conditions. General purpose for all materials.
- MT11** Ultra-fine Sub-Micron grade with advanced PVD triple coating.

ISO Standard	Materials	Cutting Speed m/min	Feed mm/tooth													
			Cutting Diameter = D													
			Ø1	Ø1.5	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø12	Ø14	Ø16
P	Low and Medium Carbon Steels < 0.55%C	60-120	0.04	0.05	0.05	0.07	0.09	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.18	0.18
	High Carbon Steels ≥ 0.55%C	60- 90	0.03	0.04	0.05	0.06	0.08	0.09	0.10	0.12	0.13	0.14	0.14	0.16	0.17	0.18
	Alloy Steels, Treated Steels	50- 80	0.03	0.04	0.04	0.05	0.05	0.06	0.07	0.07	0.08	0.09	0.10	0.12	0.13	0.14
M	Stainless Steels - Free Cutting	70-100	0.02	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.10	0.11	0.12	0.13
	Stainless Steels - Austenitic	60- 90	0.02	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.10	0.11	0.12	0.13
	Cast Steels	70- 90	0.03	0.04	0.04	0.05	0.05	0.06	0.07	0.07	0.08	0.09	0.10	0.12	0.13	0.14
K	Cast Iron	40- 80	0.04	0.05	0.05	0.07	0.09	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.18	0.18
N	Aluminum ≤12%Si, Copper	100-200	0.04	0.05	0.05	0.07	0.09	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.18	0.18
	Aluminum >12% Si	60-140	0.03	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.10	0.11	0.13	0.14
	Synthetics, Duroplastics, Thermoplastics	50-200	0.09	0.10	0.11	0.12	0.14	0.16	0.18	0.19	0.19	0.19	0.19	0.20	0.20	0.20
S	Nickel Alloys and Titanium Alloys	20- 40	0.03	0.03	0.03	0.04	0.04	0.05	0.06	0.06	0.06	0.07	0.07	0.07	0.08	0.08

