

THREADING

50-2024

AUGUST 2024

METRIC

# NPA

New Product Announcement



PVD Coating



Different Types  
of Materials



High Wear  
Resistance



## **SOLIDTHREAD**

# New Line of Solid Thread Endmills for Machining Internal Threads in Hardened Materials

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## SOLIDTHREAD

### Highlights

#### Solid Thread Tools for Milling Internal Threads In Hardened Materials (Up to 62 HRC)

ISCAR has broadened the solid carbide Mill Thread tool family with the new **MTECH** line for machining hardened materials (up to 62 HRC).

The new thread endmills are made from **IC902** carbide grade.

#### IC902

Ultra-fine carbide grain, PVD coated with high wear resistance and toughness. High speed, medium feed and intended for up to 62 HRC hardened steel, Titanium, nickel-based alloys and stainless steel.

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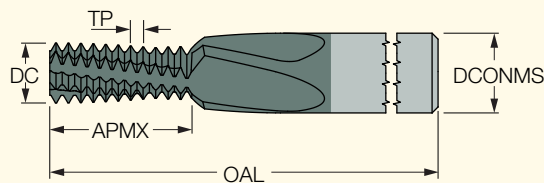
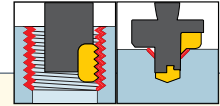
METRIC

## SOLIDTHREAD

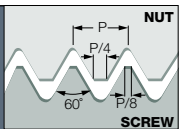
### MTECH-ISO

Small Diameter Solid Carbide Internal ISO Profile Threading and Chamfering Endmills, for Hard Materials

<https://www.iscar.com/eCatalog/Family.aspx?fnum=3528&mapp=TH&GFSTYP=M&srch=1>



Application: General engineering



#### Dimensions

Designation	TP <sup>(1)</sup>	M Coarse	M Fine	DCONMS	DC	NOF <sup>(2)</sup>	APMX	OAL	Shank <sup>(3)</sup>	THFT	IC902
MTECH 0806D14 1.25ISO	1.250	M8	M10	8.00	6.00	4	13.70	64.00	C	M60	●
MTECH 0604C9 0.8ISO	0.800	M5	>5.9	6.00	4.00	3	9.20	58.00	C	M60	●
MTECH 08048D10 1.0ISO	1.000	M6	>6.9	8.00	4.80	4	10.50	64.00	C	M60	●
MTECH 12095D20 1.75ISO 92	1.750	M12	-	12.00	9.50	4	20.10	84.00	C	M60	●

<sup>(1)</sup> Thread pitch

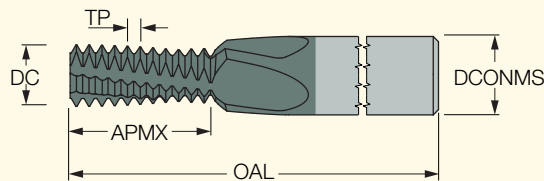
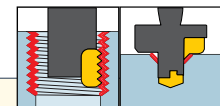
<sup>(2)</sup> Number of flutes

<sup>(3)</sup> C-Cylindrical

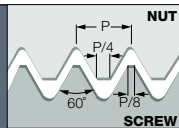
### MTECH-UN

Small Diameter Solid Carbide Internal UN Profile Threading and Chamfering Endmills, for Hard Materials

<https://www.iscar.com/eCatalog/Family.aspx?fnum=3529&mapp=TH&GFSTYP=M&srch=1>



Application: General engineering



#### Dimensions

Designation	TPI <sup>(1)</sup>	UNC	UNF	UNEF	DCONMS	DC	NOF <sup>(2)</sup>	APMX	OAL	Shank <sup>(3)</sup>	THFT	IC902
MTECH 06048C12 20UN	20.0	1/4	-	-	6.00	4.80	3	12.10	58.00	C	UN60	●
MTECH 08057C14 18UN	18.0	5/16	9/16, 5/8	11/16	8.00	5.70	3	14.80	64.00	C	UN60	●
MTECH 10074C16 16UN	16.0	3/8	3/4	-	10.00	7.40	3	16.70	73.00	C	UN60	●
MTECH 12094D22 13UN	13.0	1/2	-	-	12.00	9.40	4	22.50	84.00	C	UN60	●
MTECH 06026C5 32UN	32.0	6	999	999	6.00	2.60	3	6.70	58.00	C	un60	●

<sup>(1)</sup> Threads per inch

<sup>(2)</sup> Number of flutes

<sup>(3)</sup> C-Cylindrical