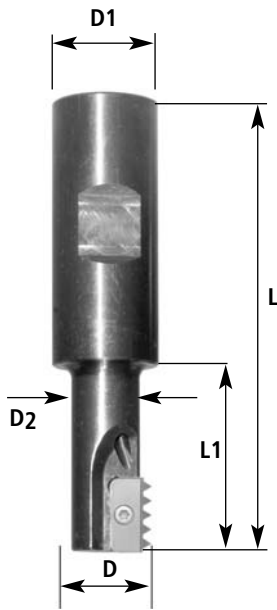


Premier

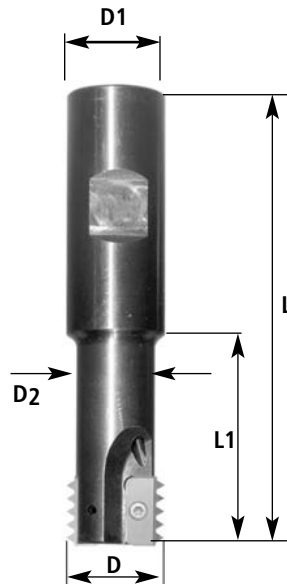
Manufacturers of Precision Ground Cutting Tools



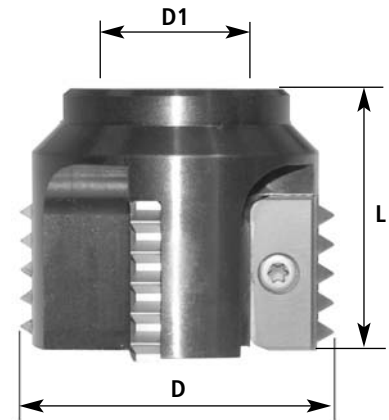
Thread Milling
F-Type
e - Catalogue



Tool style A



Tool style B



Tool style C

Thread milling toolholders

Part No	Insert type	D mm	D1 mm	D2 mm	L mm	L1 mm	No of inserts	Spares		Tool style
								Insert screw	Torx key	
F14S20B012X20-1 (1)	F14	12	20	8.6	75	20	1	M2.5X6	T7	A
F14S20B015X30-1	F14	15	20	11.2	75	30	1	M2.5X6	T7	A
F14S20B015X45-1	F14	15	20	11.2	85	45	1	M2.5X6	T7	A
F14S20B017X30-1	F14	17	20	12.8	85	30	1	M2.5X6	T7	A
F14S20B017X50-1	F14	17	20	12.8	105	50	1	M2.5X6	T7	A
F14S20B020X40-2	F14	20	20	15.8	95	40	2	M2.5X6	T7	B
F21S20B019X30-1 (2)	F21	19	20	15	85	30	1	M4 X10	T20	A
F21S20B019X45-1 (2)	F21	19	20	15	100	45	1	M4 X10	T20	A
F21S20B019X60-1 (2)	F21	19	20	15	115	60	1	M4 X10	T20	A
F21S20B020X40-1	F21	20	20	15.5	95	40	1	M4 X10	T20	A
F21S20B020X60-1	F21	20	20	15.5	115	60	1	M4 X10	T20	A
F21S25B030X50-2	F21	30	25	24.4	108	50	2	M4 X10	T20	B
F30S25B029X50-1	F30	29	25	22	110	50	1	M5 X12	T20	A
F30S25B029X85-1	F30	29	25	22	145	85	1	M5 X12	T20	A
F30S32B038X70-1	F30	38	32	31	130	70	1	M5 X12	T20	A
F30S32B038X105-1	F30	38	32	31	170	105	1	M5 X12	T20	A
F30S32B040X70-2	F30	40	32	33	130	70	2	M5 X12	T20	B
F30S22-063X50-4	F30	63	22	-	50	-	4	M5 X12	T20	C
F30S27-080X55-5	F30	80	27	-	55	-	5	M5 X12	T20	C
F30S32-100X60-5	F30	100	32	-	60	-	5	M5 X12	T20	C
F40S40B044X82-1	F40	44	40	35	153	82	1	M5 X12	T20	A
F40S40B050X82-2	F40	50	40	40	153	82	2	M5 X12	T20	B
F40S27-080X65-5	F40	80	27	-	65	-	5	M5 X12	T20	C
F40S32-100X70-5	F40	100	32	-	70	-	5	M5 X12	T20	C

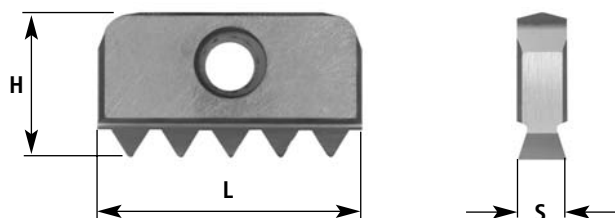
(1) Recommended solely for non-ferrous materials

(2) Recommended solely for INTERNAL M24 X 3p ISO and 1" - 8 UNC threads

For current stock availability, refer to our latest price list

Premier

*F-Type*TM
Indexable Insert
Thread Milling

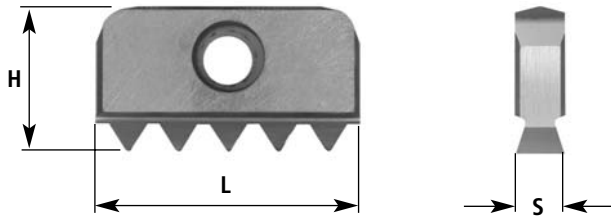


Cutting edges

Premier Thread Milling Inserts have two cutting edges except tapered threading inserts and some coarse thread forms which are designated with an S to indicate a single cutting edge after the edge length ie, F14S

ISO Metric parallel thread milling inserts

Pitch	External/ Internal Thread Form	INSERT CUTTING EDGE LENGTH L mm								Available Grades		
		14		21		30		40		RS20	RS21	RS27
		H= 8,02	S=3,1	H=12,74	S=4,7	H=16,84	S=5,5	H=20,95	S=6,3			
		Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms			
0.5	External	F14E 0.5ISO	28							●	●	
	Internal	F14N 0.5ISO								●	●	
0.75	External	F14E 0.75ISO	18					F40E 0.75ISO	53	●	●	
	Internal	F14N 0.75ISO								●	●	
0.8	External	F14E 0.8ISO	14							●	●	
	Internal	F14N 0.8ISO								●	●	
1.0	External	F14E 1.0ISO	14	F21E 1.0ISO	21	F30E 1.0ISO	30	F40E 1.0ISO	40	●	●	
	Internal	F14N 1.0ISO		F21N 1.0ISO		F30N 1.0ISO		F40N 1.0ISO		●	●	
1.25	External	F14E 1.25ISO	11	F21E 1.25ISO	16	F30E 1.25ISO	24			●	●	
	Internal	F14N 1.25ISO		F21N 1.25ISO		F30N 1.25ISO				●	●	
1.5	External	F14E 1.5ISO	9	F21E 1.5ISO	14	F30E 1.5ISO	20	F40E 1.5ISO	26	●	●	
	Internal	F14N 1.5ISO		F21N 1.5ISO		F30N 1.5ISO		F40N 1.5ISO		●	●	
1.75	External	F14E 1.75ISO	8	F21E 1.75ISO	12	F30E 1.75ISO	17	F40E 1.75ISO	22	●	●	
	Internal	F14N 1.75ISO		F21N 1.75ISO		F30N 1.75ISO		F40N 1.75ISO		●	●	
2.0	External	F14SE 2.0ISO	7	F21E 2.0ISO	10	F30E 2.0ISO	15	F40E 2.0ISO	20	●	●	
	Internal	F14N 2.0ISO		F21N 2.0ISO		F30N 2.0ISO		F40N 2.0ISO		●	●	
2.5	External	F14SE 2.5ISO	5	F21E 2.5ISO	8	F30E 2.5ISO	12	F40E 2.5ISO	16	●	●	
	Internal	F14SN 2.5ISO		F21N 2.5ISO		F30N 2.5ISO		F40N 2.5ISO		●	●	
3.0	External			F21E 3.0ISO	7	F30E 3.0ISO	10	F40E 3.0ISO	13	●	●	
	Internal			F21N 3.0ISO		F30N 3.0ISO		F40N 3.0ISO		●	●	
3.5	External			F21SE 3.5ISO	6	F30E 3.5ISO	8	F40E 3.5ISO	11	●	●	
	Internal			F21SN 3.5ISO		F30N 3.5ISO		F40N 3.5ISO		●	●	
4.0	External			F21SE 4.0ISO	5	F30E 4.0ISO	7	F40E 4.0ISO	10	●	●	
	Internal			F21SN 4.0ISO		F30N 4.0ISO		F40N 4.0ISO		●	●	
4.5	External					F30SE 4.5ISO	6	F40E 4.5ISO	8	●	●	
	Internal					F30SN 4.5ISO		F40N 4.5ISO		●	●	
5.0	External					F30SE 5.0ISO	6	F40E 5.0ISO	8	●	●	
	Internal					F30SN 5.0ISO		F40N 5.0ISO		●	●	
5.5	External					F30SE 5.5ISO	5	F40E 5.5ISO	7	●	●	
	Internal					F30SN 5.5ISO		F40N 5.5 ISO		●	●	
6.0	External					F30SE 6.0ISO	5	F40E 6.0ISO	6	●	●	
	Internal					F30SN 6.0ISO		F40N 6.0ISO		●	●	



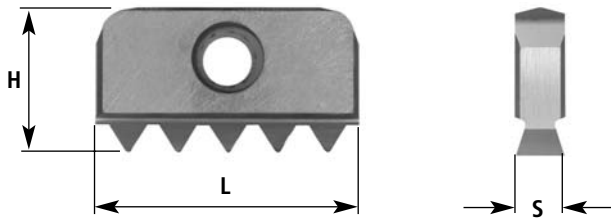
Cutting edges

Premier Thread Milling Inserts have two cutting edges except tapered threading inserts and some coarse thread forms which are designated with an S to indicate a single cutting edge after the edge length ie, F14S

UN parallel thread milling inserts (UNC, UNF, UNEF, UNS (Not suitable for UNJ))

TPI	External/ Internal Thread Form	INSERT CUTTING EDGE LENGTH L										Available Grades		
		14		21		30		40						
		H=8,02	S=3,1	H=12,74	S=4,7	H=16,84	S=5,5	H=20,95	S=6,3	RS20	RS21	RS27		
		Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms					
40	External Internal	F14E 40UN F14N 40UN	22								●	●		
32	External Internal	F14E 32UN F14N 32UN	17								●	●		
28	External Internal	F14E 28UN F14N 28UN	15			F30E 28UN F30N 28UN	33				●	●		
27	External Internal	F14E 27UN F14N 27UN	14 15								●	●		
24	External Internal	F14E 24UN F14N 24UN	13								●	●		
20	External Internal	F14E 20UN F14N 20UN	11	F21E 20UN F21N 20UN	16	F30E 20UN F30N 20UN	23				●	●		
18	External Internal	F14E 18UN F14N 18UN	10	F21E 18UN F21N 18UN	15	F30E 18UN F30N 18UN	21	F40E 18UN F40N 18UN	31		●	●		
16	External Internal	F14E 16UN F14N 16UN	8 9	F21E 16UN F21N 16UN	13	F30E 16UN F30N 16UN	19	F40E 16UN F40N 16UN	25		●	●		
14	External Internal	F14E 14UN F14N 14UN	7	F21E 14UN F21N 14UN	11	F30E 14UN F30N 14UN	16	F40E 14UN F40N 14UN	22		●	●		
12	External Internal	F14SE 12UN F14SN 12UN	6	F21E 12UN F21N 12UN	10	F30E 12UN F30N 12UN	14	F40E 12UN F40N 12UN	18 19		●	●		
11	External Internal	F14SE 11UN F14SN 11UN	6	F21E 11UN F21N 11UN	9	F30E 11UN F30N 11UN	13	F40E 11UN F40N 11UN	17		●	●		
10	External Internal	F14SN 10UN F14SN 10UN	5	F21E 10UN F21N 10UN	8	F30E 10UN F30N 10UN	11 12	F40E 10UN F40N 10UN	15		●	●		
9	External Internal			F21E 9UN F21N 9UN	7	F30E 9UN F30N 9UN	10	F40E 9UN F40N 9UN	14		●	●		
8	External Internal			F21E 8UN F21N 8UN	6	F30E 8UN F30N 8UN	9	F40E 8UN F40N 8UN	12		●	●		
7	External Internal			F21SE 7UN F21SN 7UN	5 6	F30E 7UN F30N 7UN	8	F40E 7UN F40N 7UN	11		●	●		
6	External Internal					F30E 6UN F30N 6UN	7	F40E 6UN F40N 6UN	9		●	●		
5	External Internal					F30SE 5UN F30SN 5UN	5 6	F40E 5UN F40N 5UN	7		●	●		
4.5	External Internal					F30SE 4.5UN F30SN 4.5UN	5	F40E 4.5UN F40N 4.5UN	7		●	●		
4	External Internal							F40SE 4UN F40SN 4UN	6		●	●		

For current stock availability, refer to our latest price list



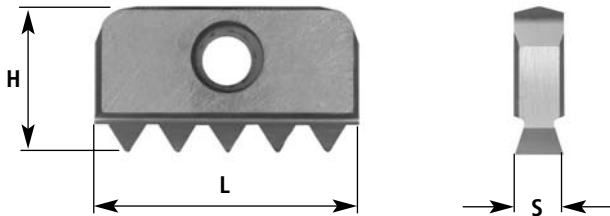
Cutting edges

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WHITWORTH (BSW, BSF, BSP/G) parallel thread milling inserts

TPI	External/ Internal Thread Form	INSERT CUTTING EDGE LENGTH L mm								Available Grades		
		14		21		30		40				
		H=8,02	S=3,1	H=12,74	S=4,7	H=16,84	S=5,5	H=20,95	S=6,3			
		Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms	RS20	RS21	RS27
40	External Internal	F14X 40W	22									
32	External Internal	F14X 32W	17							●	●	
28	External Internal	F14X 28W	15							●	●	
26	External Internal	F14X 26W	14							●	●	
24	External Internal	F14X 24W	13							●	●	
20	External Internal	F14X 20W	11	F21X 20W	16					●	●	
19	External Internal	F14X 19W	10	F21X 19W	15					●	●	
18	External Internal	F14X 18W	10	F21X 18W	15					●	●	
16	External Internal	F14X 16W	8	F21X 16W	13	F30X 16W	19			●	●	
14	External Internal	F14X 14W	7	F21X 14W	11	F30X 14W	16			●	●	
12	External Internal	F14SX 12W	6	F21X 12W	9	F30X 12W	14			●	●	
11	External Internal	F14SX 11W	6	F21X 11W	9	F30X 11W	13	F40X 11W	17	●	●	
10	External Internal	F14SX 10W	5	F21X 10W	8	F30X 10W	11	F40X 10W	15	●	●	
9	External Internal			F21X 9W	7	F30X 9W	10	F40X 9W	14	●	●	
8	External Internal			F21SX 8W	6	F30X 8W	9	F40X 8W	12	●	●	
7	External Internal							F40X 7W	11	●	●	
6	External Internal							F40X 6W	9	●	●	
5	External Internal							F40X 5W	7	●	●	
4	External Internal							F40SX 4W	6	●	●	

For current stock availability, refer to our latest price list



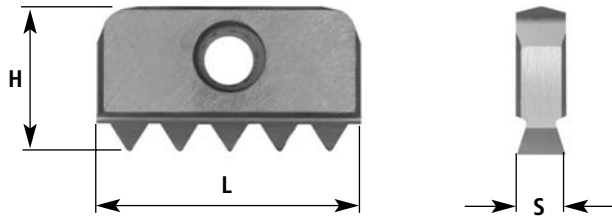
Cutting edges

Premier Thread Milling Inserts have two cutting edges except tapered threading inserts and some coarse thread forms which are designated with an S to indicate a single cutting edge after the edge length ie, F14S

BSPT/R tapered thread milling inserts

TPI	External/ Internal Thread Form	INSERT CUTTING EDGE LENGTH L								Available Grades		
		14		21		30		40				
		H=7,5	S=3,1	H=12,0	S=4,7	H=16,0	S=5,5	H=20,0	S=6,3			
		Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms			
28	External Internal	F14X 28BSPT	15							●	●	
19	External Internal	F14X 19BSPT	10							●	●	
14	External Internal	F14X 14BSPT	7	F21X 14BSPT	11					●	●	
11	External Internal			F21X 11BSPT	9	F30X 11BSPT	13	F40X 11BSPT	17	●	●	

Premier recommend the use of a taper cutter to produce the 1:16 taper form prior to cutting NPT / NPTF / BSPT taper threads.
Refer to page AA23



Cutting edges

Premier Thread Milling Inserts have two cutting edges except tapered threading inserts and some coarse thread forms which are designated with an S to indicate a single cutting edge after the edge length ie, F14S

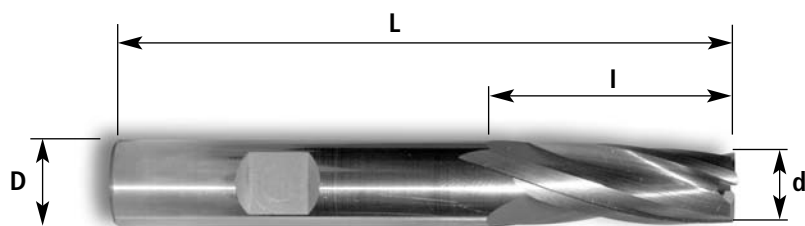
NPT tapered thread milling inserts

TPI	External/ Internal Thread Form	INSERT CUTTING EDGE LENGTH L mm								Available Grades		
		14		21		30		40				
		H=7,5	S=3,1	H=12,0	S=4,7	H=16,0	S=5,5	H=20,0	S=6,3			
		Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms			
18	External Internal	F14X 18NPT	9	F21X 18NPT	14					●	●	
14	External Internal	F14X 14NPT	7	F21X 14NPT	11					●	●	
11.5	External Internal			F21X 11.5NPT	9	F30X 11.5NPT	13	F40X 11.5NPT	17	●	●	
8	External Internal					F30X 8NPT	9	F40X 8NPT	12	●	●	

NPTF tapered thread milling inserts

TPI	External/ Internal Thread Form	INSERT CUTTING EDGE LENGTH L mm										Available Grades		
		14		21		30		40						
		H=7,5	S=3,1	H=12,0	S=4,7	H=16,0	S=5,5	H=20,0	S=6,3					
		Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms	Part No	No of thread forms	RS20	RS21	RS27		
18	External Internal	F14X 18NPTF	9	F21X 18NPTF	14					●	●			
14	External Internal	F14X 14NPTF	7	F21X 14NPTF	11					●	●			
11.5	External Internal			F21X 11.5NPTF	9	F30X 11.5NPTF	13	F40X 11.5NPTF	17	●	●			
8	External Internal					F30X 8NPTF	9	F40X 8NPTF	12	●	●			

Premier recommend the use of a taper cutter to produce the 1:16 taper form prior to cutting NPT / NPTF / BSPT taper threads.
Refer to page AA23



Taper Cutter 20° helical flute milling cutter for preparation of 1:16 tapered threads

For thread sizes	Part number	d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of teeth	Available Grades		
							RS20	RS21	RS27
1/16" NPT	HX06 B 050 T0625	5.0	18	6	58	4	●	●	
1/8" – 3/8" NPT / BSPT	HX08 B 070 T0625	7.0	14	8	64	4	●	●	
1/2" – 2" NPT / BSPT	HX12 B 103 T0625	10.3	25	12	84	4	●	●	
2-1/2" – 4" NPT 2-1/2" – 3-1/2" BSPT	HX16 B 137 T0625	13.7	36	16	100	4	●	●	

Premier recommend the use of a taper cutter to produce the 1:16 taper form prior to cutting NPT / NPTF / BSPT taper threads.

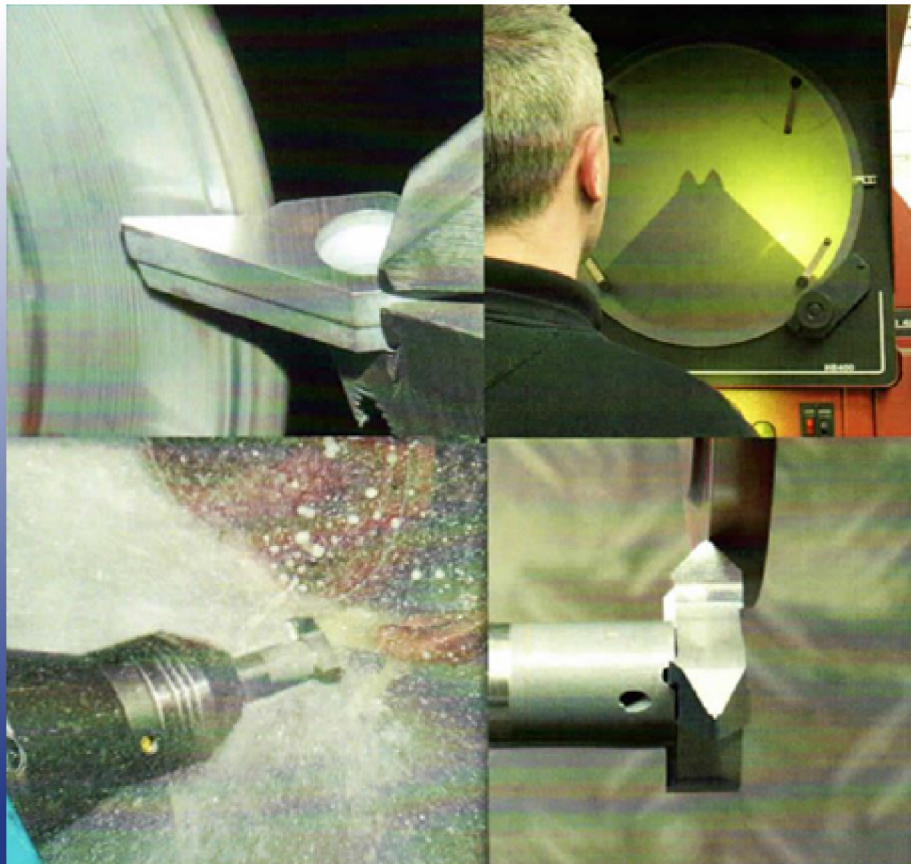
Shank style

Premier Taper Cutters come as standard with weldon shank to DIN6535HB. For further shank options refer to Technical Information page AA30

For current stock availability, refer to our latest price list



Manufacturers of Precision Ground Cutting Tools



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