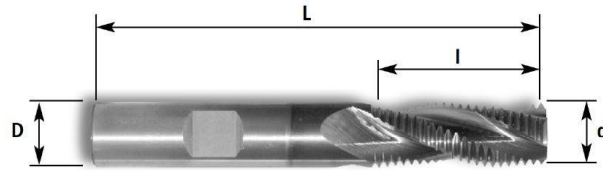


Premier

Manufacturers of Precision Ground Cutting Tools



Thread Milling
Tap-X
e - Catalogue



ISO Metric - Coarse 30° Helical flute internal thread mill

THREAD SIZE	PITCH	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thead forms	No of Flutes	Available Grade		
		Without coolant	With coolant							RS20	RS21	RS27
M3	0.5	HN06 B 023 0.5ISO		2.3	6.4	6	58	13	3	•	•	
M4	0.7	HN06 B 030 0.7ISO		3.0	8.4	6	58	12	3	•	•	
M4.5	0.75	HN06 B 033 0.75ISO		3.3	8.6	6	58	11	3	•	•	
M5	0.8	HN06 B 038 0.8ISO		3.8	9.2	6	58	11	3	•	•	
M6 M7	1.0	HN06 B 045 1.0ISO		4.5	10.5	6	58	10	3	•	•	
M8 M9	1.25	HN06 B 059 1.25ISO		5.9	13.8	6	58	11	3	•	•	
M10 M11	1.5	HN08 B 078 1.5ISO	CHN08 B 078 1.5ISO	7.8	16.5	8	64	11	4	•	•	
M12	1.75	HN10 B 095 1.75ISO	CHN10 B 095 1.75ISO	9.5	21.0	10	73	12	3	•	•	
M14	2.0	HN10 B 099 2.0ISO	CHN10 B 099 2.0ISO	9.9	26.0	10	73	13	3	•	•	
M14	2.0	HN12 B 110 2.0ISO	CHN12 B 110 2.0ISO	11.0	26.0	12	84	13	3	•	•	
M16	2.0	HN12 B 119 2.0ISO	CHN12 B 119 2.0ISO	11.9	30.0	12	84	15	4	•	•	
M18, M20, M22	2.5	HN14 B 139 2.5ISO	CHN14 B 139 2.5ISO	13.9	32.0	14	84	13	3	•	•	
M20, M22	2.5	HN16 B 159 2.5ISO	CHN16 B 159 2.5ISO	15.9	35.0	16	100	14	4	•	•	
M24	3.0	HN16 B 159 3.0ISO	CHN16 B 159 3.0ISO	15.9	39.0	16	100	13	4	•	•	
M24, M27	3.0	HN18 B 179 3.0ISO	CHN18 B 179 3.0ISO	17.9	42.0	18	100	14	4	•	•	
M24, M27	3.0	HN20 B 190 3.0ISO	CHN20 B 190 3.0ISO	19.0	45.0	20	125	15	4	•	•	
M30, M33	3.5	HN20 B 199 3.5ISO	CHN20 B 199 3.5ISO	19.9	52.5	20	125	15	4	•	•	
M33	3.5	HN25 B 249 3.5ISO	CHN25 B 249 3.5ISO	24.9	52.5	25	125	15	4	•	•	
M36, M39	4.0	HN20 B 199 4.0ISO	CHN20 B 199 4.0ISO	19.9	52.5	20	125	13	4	•	•	
M36, M39	4.0	HN25 B 249 4.0ISO	CHN25 B 249 4.0ISO	24.9	60.0	25	125	15	4	•	•	

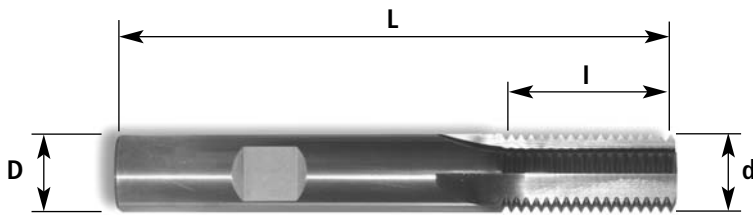
Premier Form Tools also offer a small selection of X2D threadmills. Please contact us to check availability.

Shank style

Premier Thread Mills come as standard with weldon shank to DIN6535HB.

For further shank options refer to technical information on page 34

For current stock availability, please contact us.



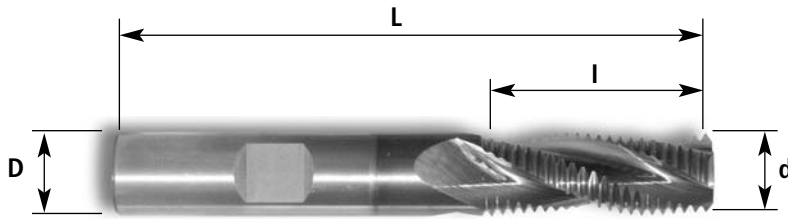
ISO Metric straight flute internal thread mill

Thread Size	Pitch	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
M3	0.5	SN06 B 023 0.5ISO		2.3	5.0	6	58	10	3	●	●	
M3.5	0.6	SN06 B 026 0.6ISO		2.6	6.0	6	58	10	3	●	●	
M4	0.7	SN06 B 030 0.7ISO		3.0	7.0	6	58	10	3	●	●	
M4.5	0.75	SN06 B 033 0.75ISO		3.3	7.5	6	58	10	3	●	●	
M5	0.8	SN06 B 038 0.8ISO		3.8	8.0	6	58	10	3	●	●	
M6, M7	1.0	SN06 B 045 1.0ISO		4.5	10.0	6	58	10	3	●	●	
M8, M9	1.25	SN06 B 059 1.25ISO		5.9	13.8	6	58	11	3	●	●	
M10, M11	1.5	SN08 B 078 1.5ISO	CSN08 B 078 1.5ISO	7.8	16.5	8	64	11	3	●	●	
M12	1.75	SN10 B 095 1.75ISO	CSN10 B 095 1.75ISO	9.5	19.3	10	73	11	4	●	●	
M14	2.0	SN10 B 099 2.0ISO	CSN10 B 099 2.0ISO	9.9	26.0	10	73	13	4	●	●	
M16	2.0	SN12 B 119 2.0ISO	CSN12 B 119 2.0ISO	11.9	26.0	12	84	13	4	●	●	
M18, M20 M22	2.5	SN14 B 139 2.5ISO	CSN14 B 139 2.5ISO	13.9	32.5	14	84	13	4	●	●	
M20, M22	2.5	SN16 B 159 2.5ISO	CSN16 B 159 2.5ISO	15.9	32.5	16	100	13	4	●	●	
M24, M27	3.0	SN16 B 159 3.0ISO	CSN16 B 159.0ISO	15.9	39.0	16	100	13	4	●	●	
M24, M27	3.0	SN18 B 179 3.0ISO	CSN18 B 179 3.0ISO	17.9	39.0	18	100	13	4	●	●	

Shank style

Premier Thread Mills 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



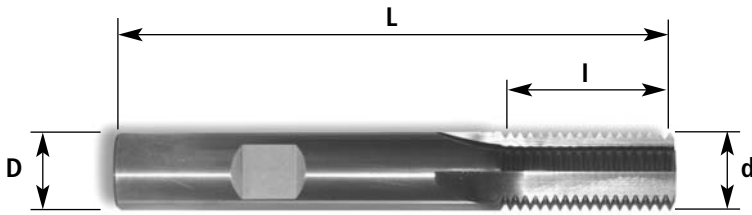
ISO Metric - FINE 30° helical flute internal thread mill

Thread Size	Pitch	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
M6	0.75	HN06 B 045 0.75ISO		4.5	11.2	6	58	15	3	●	●	
M7	0.75	HN06 B 055 0.75ISO		5.5	12.0	6	58	16	3	●	●	
M8	1.0	HN06 B 059 1.0ISO		5.9	21.0	6	58	21	3	●	●	
M10	1.0	HN08 B 079 1.0ISO	CHN08 B 079 1.0ISO	7.9	26.0	8	64	26	4	●	●	
M12	1.0	HN10 B 099 1.0ISO	CHN10 B 099 1.0ISO	9.9	26.0	10	73	26	4	●	●	
M14	1.0	HN12 B 119 1.0ISO	CHN12 B 119 1.0ISO	11.9	33.0	12	84	33	4	●	●	
M10, M12	1.25	HN08 B 079 1.25ISO	CHN08 B 079 1.25ISO	7.9	26.0	8	64	20	4	●	●	
M12, M14 M16, M18	1.5	HN10 B 099 1.5ISO	CHN10 B 099 1.5ISO	9.9	27.0	10	73	18	4	●	●	
M16, M18	1.5	HN12 B 119 1.5ISO	CHN12 B 119 1.5ISO	11.9	33.0	12	84	22	4	●	●	
M20, M22	1.5	HN16 B 159 1.5ISO	CHN16 B 159 1.5ISO	15.9	43.5	16	100	29	4	●	●	
M24, M27 M30, M33	2.0	HN16 B 159 2.0ISO	CHN16 B 159 2.0ISO	15.9	48.0	16	100	24	4	●	●	

Shank style

Premier Thread Mills 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



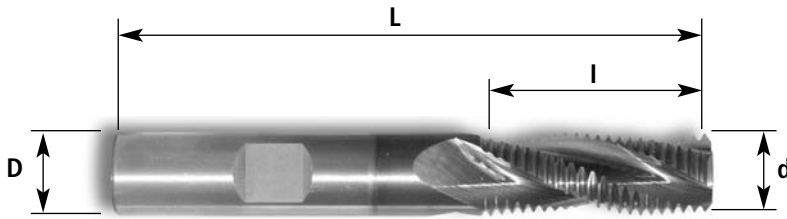
ISO Metric - FINE straight flute internal thread mill

Thread Size	Pitch	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
M5	0.5	SN06 B 040 0.5ISO		4.0	9.5	6	58	19	3	●	●	
M6	0.75	SN06 B 045 0.75ISO		4.5	11.3	6	58	15	3	●	●	
M7	0.75	SN06 B 055 0.75ISO		5.5	15.0	6	58	20	3	●	●	
M8	1.0	SN06 B 059 1.0ISO		5.9	14.0	6	58	14	3	●	●	
M10, M12	1.0	SN08 B 079 1.0ISO	CSN08 B 079 1.0ISO	7.9	21.0	8	64	21	4	●	●	
M10, M12	1.25	SN08 B 079 1.25ISO	CSN08 B 079 1.25ISO	7.9	18.8	8	64	15	4	●	●	
M12, M14 M16, M18	1.5	SN10 B 099 1.5ISO	CSN10 B 099 1.5ISO	9.9	25.5	10	73	17	4	●	●	
M16, M18	1.5	SN12 B 119 1.5ISO	CSN12 B 119 1.5ISO	11.9	25.5	12	84	17	4	●	●	

Shank style

Premier Thread Mills 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



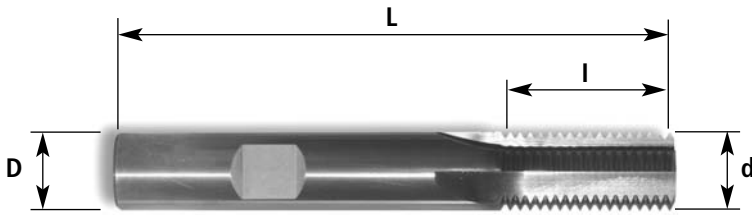
UNC 30° helical flute internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
No 8	32	HN06 B 030 32UNC		3.0	8.0	6	58	10	3	●	●	
1/4"	20	HN06 B 045 20UNC		4.5	10.8	6	58	8	3	●	●	
5/16"	18	HN06 B 053 18UNC		5.3	12.7	6	58	9	3	●	●	
3/8"	16	HN08 B 065 16UNC	CHN08 B 065 16UNC	6.5	14.8	8	64	9	3	●	●	
7/16"	14	HN08 B 079 14UNC	CHN08 B 079 14UNC	7.9	18.1	8	64	10	3	●	●	
1/2"	13	HN10 B 090 13UNC	CHN10 B 090 13UNC	9.0	21.4	10	73	11	3	●	●	
9/16"	12	HN10 B 099 12UNC	CHN10 B 099 12UNC	9.9	23.3	10	73	11	3	●	●	
5/8"	11	HN12 B 119 11UNC	CHN12 B 119 11UNC	11.9	29.0	12	84	12	3	●	●	
3/4"	10	HN12 B 119 10UNC	CHN12 B 119 10UNC	11.9	33.0	12	84	13	4	●	●	
3/4"	10	HN16 B 144 10UNC	CHN16 B 144 10UNC	14.4	33.0	16	100	13	4	●	●	
7/8"	9	HN16 B 159 9UNC	CHN16 B 159 9UNC	15.9	36.7	16	100	13	4	●	●	
1"	8	HN20 B 199 8UNC	CHN20 B 199 8UNC	19.9	50.8	20	120	16	5	●	●	
1-1/8"	7	HN20 B 199 7UNC	CHN20 B 199 7UNC	19.9	43.5	20	120	12	4	●	●	
1-1/2"												
1-1/2"	6	HN20 B 199 6UNC	CHN20 B 199 6UNC	19.9	52.5	25	120	12	4	●	●	

Shank style

Premier Thread Mills 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



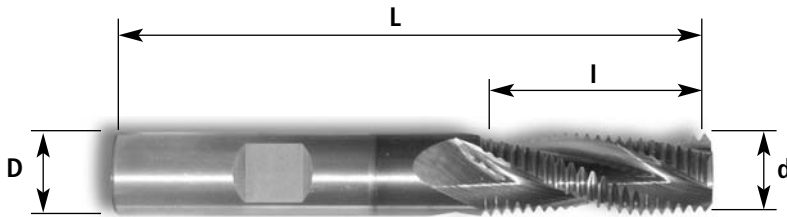
UNC straight flute internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
No 8	32	SN06 B 030 32UNC		3.0	6.4	6	58	8	3	●	●	
1/4"	20	SN06 B 045 20UNC		4.5	10.2	6	58	8	3	●	●	
5/16"	18	SN06 B 053 18UNC		5.3	12.7	6	58	9	3	●	●	
3/8"	16	SN08 B 065 16UNC	CSN08 B 065 16UNC	6.5	14.3	8	64	9	3	●	●	
7/16"	14	SN08 B 079 14UNC	CSN08 B 079 14UNC	7.9	16.3	8	64	9	4	●	●	
1/2"	13	SN10 B 090 13UNC	CSN10 B 090 13UNC	9.0	19.5	10	73	10	4	●	●	
9/16"	12	SN10 B 099 12UNC	CSN10 B 099 12UNC	9.9	21.2	10	73	10	4	●	●	
5/8"	11	SN12 B 119 11UNC	CSN12 B 119 11UNC	11.9	23.1	12	84	10	4	●	●	
3/4"	10	SN12 B 119 10UNC	CSN12 B 119 10UNC	11.9	27.9	12	84	10	4	●	●	

Shank style

Premier Thread Mills 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



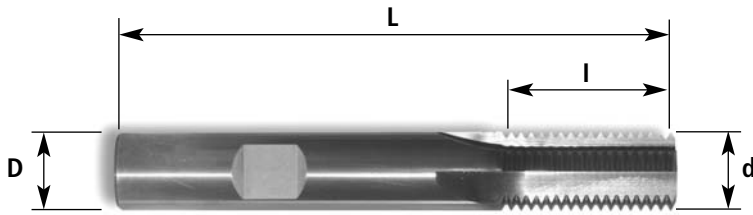
UNF 30° helical flute internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
No 8	36	HN06 B 030 36UNF		3.0	6.4	6	58	9	3	●	●	
No 10	32	HN06 B 038 32UNF		3.8	12.0	6	58	14	3	●	●	
No 12	28	HN06 B 040 28UNF		4.0	9.0	6	58	9	3	●	●	
1/4"	28	HN06 B 048 28UNF		4.8	12.2	6	58	13	3	●	●	
5/16" 3/8"	24	HN06 B 058 24UNF		5.8	14.8	6	58	14	3	●	●	
3/8"	24	HN08 B 072 24UNF	CHN08 B 072 24UNF	7.2	19.0	8	64	18	3	●	●	
7/16" 1/2"	20	HN08 B 079 20UNF	CHN08 B 079 20UNF	7.9	22.9	8	64	18	3	●	●	
7/16" 1/2"	20	HN10 B 085 20UNF	CHN10 B 085 20UNF	8.5	22.9	10	73	18	3	●	●	
9/16" 5/8"	18	HN10 B 099 18UNF	CHN10 B 099 18UNF	9.9	25.4	10	73	18	3	●	●	
9/16" 5/8"	18	HN12 B 113 18UNF	CHN12 B 113 18UNF	11.3	25.4	12	84	18	4	●	●	
3/4"	16	HN12 B 119 16UNF	CHN12 B 119 16UNF	11.9	32.0	12	84	20	4	●	●	
3/4"	16	HN16 B 156 16UNF	CHN16 B 156 16UNF	15.6	36.5	16	100	23	4	●	●	
7/8"	14	HN16 B 159 14UNF	CHN16 B 159 14UNF	15.9	39.9	16	100	22	4	●	●	
1" 1-1/2"	12	HN12 B119 12UNF	CHN12 B 119 12UNF	11.9	32.0	12	84	15	4	●	●	
1" 1-1/2"	12	HN16 B 159 12UNF	CHN16 B 159 12UNF	15.9	38.1	16	100	18	4	●	●	

Shank style

Premier Thread Mills 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



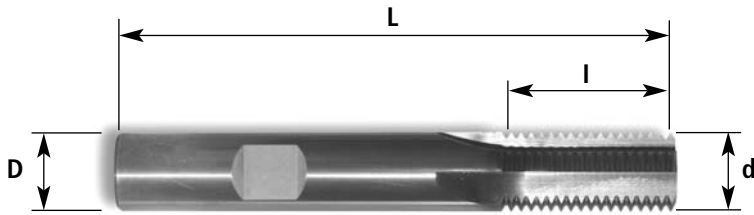
UNF straight flute internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
No 6	40	SN06 B 026 40UNF		2.6	5.3	6	58	8	3	●	●	
No 8	36	SN06 B 030 36UNF		3.0	6.4	6	58	9	3	●	●	
No 10	32	SN06 B 038 32UNF		3.8	12.0	6	58	9	3	●	●	
No 12	28	SN06 B 040 28UNF		4.0	8.2	6	58	9	3	●	●	
1/4"	28	SN06 B 048 28UNF		4.8	10.9	6	58	12	3	●	●	
3/8" 5/16"	24	SN06 B 058 24UNF		5.8	18.0	6	58	17	3	●	●	
3/8"	24	SN08 B 072 24UNF	CSN08 B 072 24UNF	7.2	18.0	8	64	17	3	●	●	
7/16" 1/2"	20	SN08 B 079 20UNF	CSN08 B 079 20UNF	7.9	22.9	8	64	18	4	●	●	
7/16" 1/2"	20	SN10 B 085 20UNF	CSN10 B 085 20UNF	8.5	22.9	10	73	18	4	●	●	
9/16" 5/8"	18	SN12 B 113 18UNF	CSN12 B 113 18UNF	11.3	28.2	12	84	20	4	●	●	
3/4"	16	SN12 B 119 16UNF	CSN12 B 119 16UNF	11.9	31.75	12	84	20	4	●	●	
3/4"	16	SN16 B 156 16UNF	CSN16 B 156 16UNF	15.6	31.75	16	100	20	4	●	●	
7/8"	14	SN16 B 159 14UNF	CSN16 B 159 14UNF	15.9	27.2	16	100	15	4	●	●	
1"	12	SN12 B 119 12UNF	CSN12 B 119 12UNF	11.9	29.6	12	84	14	4	●	●	
1"	12	SN16 B 159 12UNF	CSN16 B 159 12UNF	15.9	29.6	16	100	14	4	●	●	

Shank style

Premier Thread Mills 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



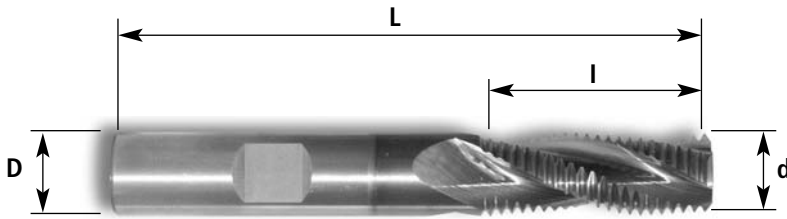
UNEF straight flute internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
5/16" 3/8"	32	SN06 B 059 32UNEF		5.9	14.3	6	58	18	3	●	●	
7/16" 1/2"	28	SN08 B 079 28UNEF	CSN08 B 079 28UNEF	7.9	20.0	8	64	22	4	●	●	
3/4" 7/8"	20	SN10 B 099 20UNEF	CSN10 B 099 20UNEF	9.9	22.9	10	73	18	4	●	●	

Shank style

Premier Thread Mills 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



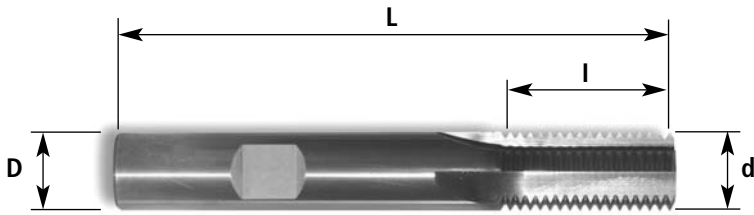
UNJF 30° helical flute internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
1/4"	28	HN06 B 048 28UNJ		4.8	12.2	6	58	13	3	●	●	
5/16" 3/8"	24	HN06 B 058 24UNJ		5.8	14.8	6	58	14	3	●	●	
3/8"	24	HN08 B 072 24UNJ	CHN08 B 072 24UNJ	7.2	19.0	8	64	18	3	●	●	
1/2" 7/16"	20	HN10 B 085 20UNJ	CHN10 B 085 20UNJ	8.5	22.9	10	73	18	3	●	●	
9/16" 5/8"	18	HN12 B 113 18UNJ	CHN12 B 113 18UNJ	11.3	25.4	12	84	18	3	●	●	
3/4"	16	HN16 B 156 16UNJ	CHN16 B 156 16UNJ	15.6	36.5	16	100	23	4	●	●	
7/8"	14	HN16 B 159 14UNJ	CHN16 B 159 14UNJ	15.9	39.9	16	100	22	4	●	●	
1"	12	HN16 B 159 12UNJ	CHN16 B 159 12UNJ	15.9	38.1	16	100	18	4	●	●	

Shank style

Premier Thread Mills 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



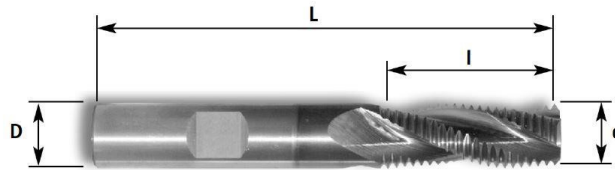
Pg straight flute external / internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
Pg7	20	SX08 B 079 20PG	CSX08 B 079 20PG	7.9	19.1	8	64	15	4	●	●	
Pg9 to Pg16	18	SX10 B 099 18PG	CSX10 B 099 18PG	9.9	25.4	10	73	18	4	●	●	
Pg21 to Pg48	16	SX12 B 119 16PG	CSX12 B 119 16PG	11.9	28.6	12	84	18	4	●	●	

Shank style

Premier Thread Mills come as standard with weldon shank to DIN6535HB. For further shank options refer to Technical Information pageAA30

For current stock availability, refer to our latest price list



BSW 30° Helical flute external / internal thread mill

THREAD SIZE	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thead forms	No of Flutes	Available Grade		
		Without coolant	With coolant							RS20	RS21	RS27
1/4"	20	HX06 B 045 20BSW		4.5	11.4	6	58	9	3	•	•	
5/16"	18	HX06 B 055 18BSW		5.5	14.1	6	58	10	3	•	•	
3/8"	16	HX08 B 070 16BSW	CHX08 B 070 16BSW	7.0	15.9	8	64	10	3	•	•	
7/16"	14	HX08 B 079 14BSW	CHX08 B 079 14BSW	7.9	18.1	8	64	10	4	•	•	
1/2"	12	HX10 B 095 12BSW	CHX10 B 095 12BSW	9.5	23.3	10	73	11	4	•	•	
5/8"	11	HX12 B 119 11BSW	CHX12 B 119 11BSW	11.9	28.8	12	84	12	4	•	•	
11/16"	26	HX12 B 119 26BSW	CHX12 B 119 26BSW	11.9	25.0	12	84	20	4	•	•	
3/4"	10	HX12 B 119 10BSW	CHX12 B 119 10BSW	11.9	33.0	12	84	13	4	•	•	
3/4"	10	HX16 B 139 10BSW	CHX16 B 139 10BSW	13.9	33.0	16	100	13	4	•	•	
7/8"	9	HX16 B 159 9BSW	CHX16 B 159 9BSW	15.9	36.7	16	100	13	4	•	•	

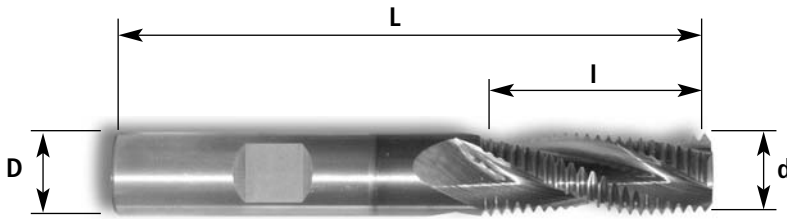
Premier Form Tools also offer a small selection of X2D threadmills. Please contact us to check availability.

Shank style

Premier Thread Mills come as standard with weldon shank to DIN6535HB.

For further shank options refer to technical information on page 34

For current stock availability, please contact us.



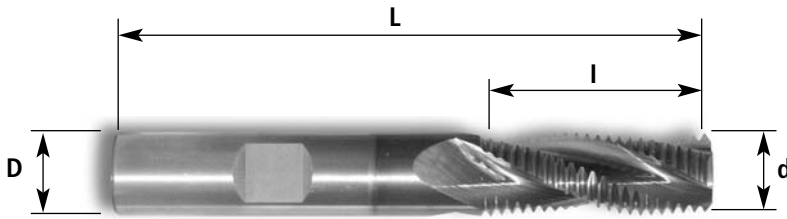
BSF 30° helical flute external/internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
1/4"	26	HX06 B 047 26BSF		4.7	10.8	6	58	11	3	●	●	
5/16"	22	HX06 B 059 22BSF		5.9	13.9	6	58	12	3	●	●	
3/8"	20	HX08 B 075 20BSF	CHX08 B 075 20BSF	7.5	16.5	8	64	13	3	●	●	
7/16"	18	HX08 B 079 18BSF	CHX08 B 079 18BSF	7.9	19.0	8	64	13	3	●	●	
1/2" 9/16"	16	HX10 B 099 16BSF	CHX10 B 099 16BSF	9.9	22.2	10	73	14	3	●	●	
5/8" 11/16"	14	HX12 B 119 14BSF	CHX12 B 119 14BSF	11.9	29.0	12	84	15	3	●	●	
3/4" 13/16"	12	HX16 B 150 12BSF	CHX16 B 150 12BSF	15.0	33.9	16	100	16	4	●	●	
7/8"	11	HX16 B 159 11BSF	CHX16 B 159 11BSF	15.9	36.8	16	100	16	4	●	●	
1"	10	HX16 B 159 10BSF	CHX16 B 159 10BSF	15.9	40.6	16	100	16	4	●	●	
1 -1/8" 1 -1/4"	9	HX06 B 047 26BSF	CHX16 B 159 9BSF	15.9	39.5	16	100	14	4	●	●	

Shank style

Premier Thread Mills 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



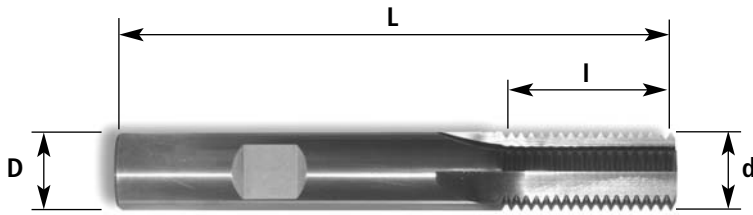
BSP/G 30° helical flute external/internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
G1/16" G1/8"	28	HX06 B 059 28BSP		5.9	9.1	6	58	10	3	●	●	
G1/8"	28	HX08 B 079 28BSP	CHX08 B 079 28BSP	7.9	15.9	8	64	17	3	●	●	
G1/4" G3/8"	19	HX08 B 079 19BSP	CHX08 B 079 19BSP	7.9	13.4	8	64	10	3	●	●	
G1/4" G3/8"	19	HX10 B 099 19BSP	CHX10 B 099 19BSP	9.9	21.4	10	73	16	4	●	●	
G1/2" to G7/8"	14	HX12 B 119 14BSP	CHX12 B 119 14BSP	11.9	26.0	12	84	14	3	●	●	
G1/2" to G7/8"	14	HX16 B 159 14BSP	CHX16 B 159 14BSP	15.9	39.0	16	100	21	4	●	●	
G1" to G3"	11	HX16 B 159 11BSP	CHX16 B 159 11BSP	15.9	36.9	16	100	16	4	●	●	
G1" to G4"	11	HX20 B 199 11BSP	CHX20 B 199 11BSP	19.9	41.6	20	120	19	4	●	●	

Shank style

Premier Thread Mills 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



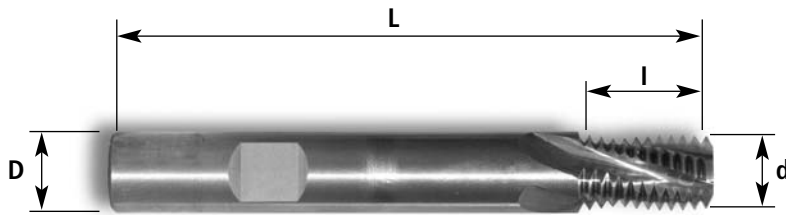
BSP/G straight flute external/internal thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
G 1/16" G 1/8"	28	SX06 B 059 28BSP		5.9	9.1	6	58	10	3	●	●	
G 1/4" G 3/8"	19	SX08 B 079 19BSP	CSX08 B 079 19BSP	7.9	13.4	8	64	10	4	●	●	
G 1/4" G 3/8"	19	SX10 B 099 19BSP	CSX10 B 099 19BSP	9.9	19.4	10	73	14	4	●	●	
G 1/2" to G 7/8"	14	SX12 B 119 14BSP	CSX12 B 119 14BSP	11.9	18.1	12	84	10	4	●	●	
G 1/2" to G 7/8"	14	SX16 B 159 14BSP	CSX16 B 159 14BSP	15.9	18.1	16	100	10	4	●	●	
G 1" to G 3"	11	SX16 B 159 11BSP	CSX16 B 159 11BSP	15.9	36.9	16	100	16	4	●	●	

Shank style

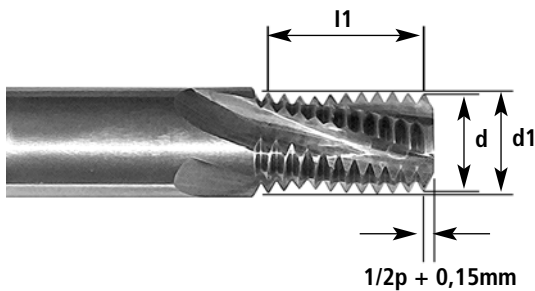
Premier Thread Mills come as standard with weldon shank to DIN6535HB. For further shank options refer to Technical Information page AA30

For current stock availability, refer to our latest price list



BSPT/R 20° helical flute external/internal tapered thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
R1/8"	28	HX08 B 069 28BSPT	CHX08 B 069 28BSPT	6.9	11.0	8	64	12	4	●	●	
R1/4" R3/8"	19	HX10 B 089 19BSPT	CHX10 B 089 19BSPT	8.9	16.1	10	73	12	4	●	●	
R1/2" R3/4"	14	HX12 B 105 14BSPT	CHX12 B 105 14BSPT	10.5	22.0	12	84	12	4	●	●	
R1/2" R3/4"	14	HX16 B 145 14BSPT	CHX16 B 145 14BSPT	14.5	22.0	16	100	12	5	●	●	
R1" to R4"	11	HX16 B 139 11BSPT	CHX16 B 139 11BSPT	13.9	32.2	16	100	14	4	●	●	
R1" to R4"	11	HX20 B 173 11BSPT	CHX20 B 173 11BSPT	17.3	41.5	20	120	18	4	●	●	



To calculate effective cutting diameter d1 at any position l1 from the crest of the first full pitch

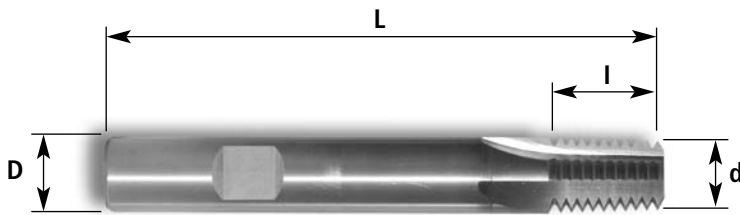
$$d1 = d + (0.0625 \times l1)$$

Premier Form Tools 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

Shank style

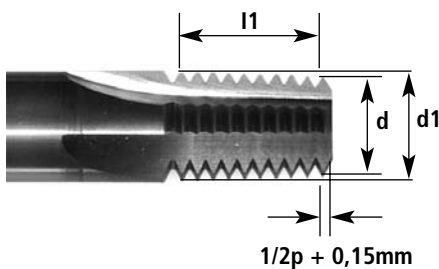
Premier Thread Mills come as standard with weldon shank to DIN6535HB. For further shank options refer to Technical Information page 32

For current stock availability, refer to our latest price list



BSPT/R straight flute external/internal tapered thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
R1/8"	28	SX06 B 053 28BSPT		5.3	9.2	6	58	10	3	●	●	
R1/8"	28	SX08 B 070 28BSPT	CSX08 B 070 28BSPT	7.0	10.0	8	64	11	4	●	●	
R1/4" R3/8"	19	SX08 B 070 19BSPT	CSX08 B 070 19BSPT	7.0	14.7	8	64	11	4	●	●	
R1/4" R3/8"	19	SX10 B 090 19BSPT	CSX10 B 090 19BSPT	9.0	14.7	10	73	11	4	●	●	
R1/2" R3/4"	14	SX12 B 104 14BSPT	CSX12 B 104 14BSPT	10.4	23.6	12	84	13	4	●	●	
R1/2" R3/4"	14	SX16 B 144 14BSPT	CSX16 B 144 14BSPT	14.4	23.6	16	100	13	4	●	●	
R1" to R4"	11	SX16 B 136 11BSPT	CSX16 B 136 11BSPT	13.6	36.9	16	100	16	4	●	●	



To calculate effective cutting diameter d1 at any position l1 from the crest of the first full pitch

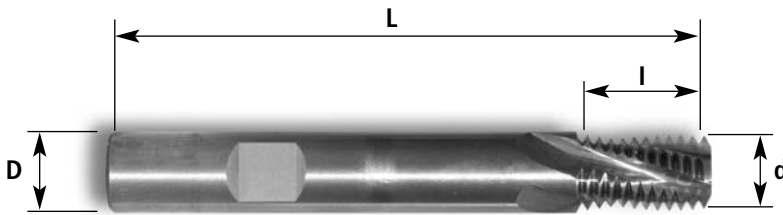
$$d1 = d + (0.0625 \times l1)$$

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

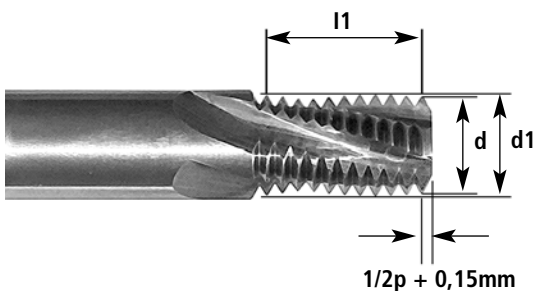
Shank style
 Premier Thread Mills come as standard with weldon shank to DIN6535HB. For further shank options refer to Technical Information page AA30

For current stock availability, refer to our latest price list



NPT 20° helical flute external/internal tapered thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
1/4" 3/8"	18	HX10 B 090 18NPT	CHX10 B 090 18NPT	9.0	14.2	10	73	10	4	●	●	
1/4" 3/8"	18	HX10 B 088 L18NPT	CHX10 B 088 L18NPT	8.8	17.0	10	73	13	4	●	●	
1/2" 3/4"	14	HX12 B 105 14NPT	CHX12 B 105 14NPT	10.5	22.0	12	84	12	4	●	●	
1/2" 3/4"	14	HX16 B 145 14NPT	CHX16 B 145 14NPT	14.5	22.0	16	100	12	5	●	●	
1" to 2"	11.5	HX16 B 140 11.5NPT	CHX16 B 140 11.5NPT	14.0	28.9	16	100	13	4	●	●	
1" to 2"	11.5	HX20 B 180 11.5NPT	CHX20 B 180 11.5NPT	18.0	31.0	20	120	14	5	●	●	



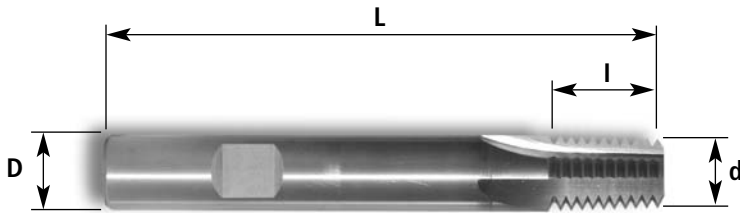
To calculate effective cutting diameter d1 at any position l1 from the crest of the first full pitch
 $d1 = d + (0.0625 \times l1)$

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

Shank style

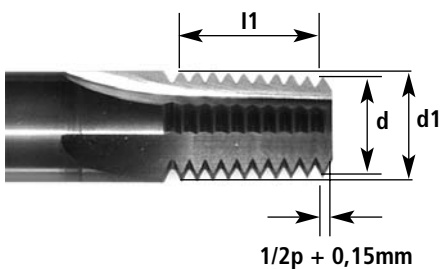
Premier Thread Mills come as standard with weldon shank to DIN6535HB. For further shank options refer to Technical Information page AA30

For current stock availability, refer to our latest price list



NPT straight flute external/internal tapered thread mill

Thread Size	TPI	Part No.		d -0.05 mm	l mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
1/16" 1/8"	27	SX06 B 053 27NPT		5.3	9.4	6	58	10	3	●	●	
1/8"	27	SX08 B 070 27NPT	CSX08 B 070 27NPT	7.0	9.4	8	64	10	4	●	●	
1/4" 3/8"	18	SX08 B 070 18NPT	CSX08 B 070 18NPT	7.0	14.1	8	64	10	4	●	●	
1/4" 3/8"	18	SX10 B 090 18NPT	CSX10 B 090 18NPT	9.0	14.1	10	73	10	4	●	●	
1/2" 3/4"	14	SX12 B 107 14NPT	CSX12 B 107 14NPT	10.7	20.0	12	84	11	4	●	●	
1/2" 3/4"	14	SX16 B 147 14NPT	CSX16 B 147 14NPT	14.7	20.0	16	100	11	4	●	●	
1" to 2"	11.5	SX16 B 142 11.5NPT	CSX16 B 142 11.5NPT	14.2	26.5	16	100	12	4	●	●	



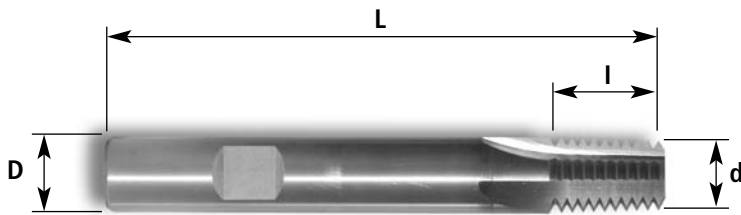
To calculate effective cutting diameter d1 at any position l1 from the crest of the first full pitch
 $d1 = d + (0.0625 \times l1)$

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.

Shank style

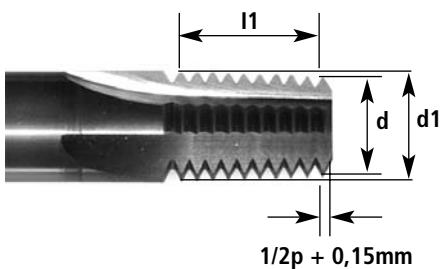
Premier Thread Mills come as standard with weldon shank to DIN6535HB. For further shank options refer to Technical Information page AA30

For current stock availability, refer to our latest price list



NPTF straight flute external/internal tapered thread mill

Thread Size	TPI	Part No.		d -0.05 mm	I mm	D h6 mm	L +0.05 mm	No of thread forms	No of teeth	Available Grades		
		Without Coolant	With Coolant							RS20	RS21	RS27
1/8"	27	SX06 B 053 27NPTF		5.3	9.4	6	58	10	3	●	●	
1/8"	27	SX08 B 070 27NPTF	CSX08 B 070 27NPTF	7.0	9.4	8	64	10	4	●	●	
1/4" 3/8"	18	SX08 B 070 18NPTF	CSX08 B 070 18NPTF	7.0	14.1	8	64	10	4	●	●	
1/4" 3/8"	18	SX10 B 090 18NPTF	CSX10 B 090 18NPTF	9.0	14.1	10	73	10	4	●	●	
1/2" 3/4"	14	SX12 B 107 14NPTF	CSX12 B 107 14NPTF	10.7	20.0	12	84	11	4	●	●	
1/2" 3/4"	14	SX16 B 147 14NPTF	CSX16 B 147 14NPTF	14.7	20.0	16	100	11	4	●	●	
1" to 2"	11.5	SX16 B 142 11.5NPTF	CSX16 B 142 11.5NPTF	14.2	26.5	16	100	12	4	●	●	



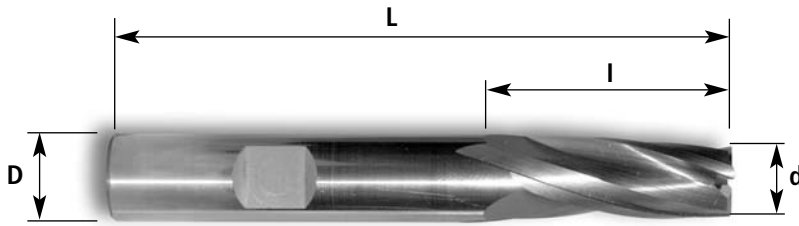
To calculate effective cutting diameter d1 at any position l1 from the crest of the first full pitch
 $d1 = d + (0.0625 \times l1)$

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

Shank style

Premier Thread Mills 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



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.

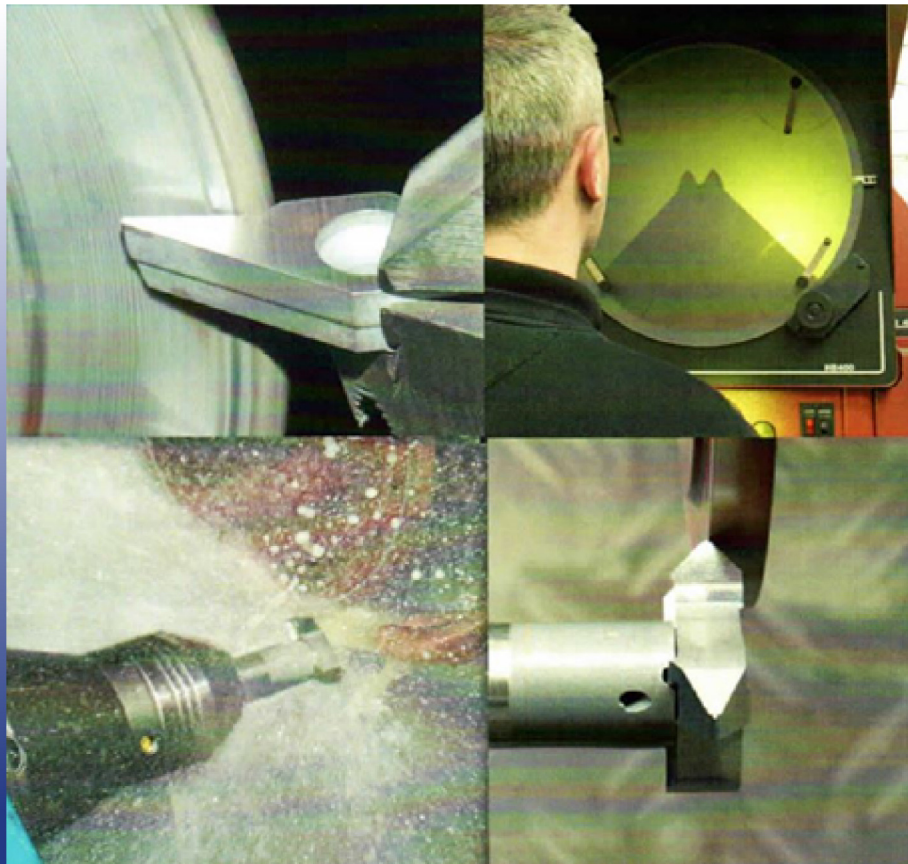
Shank style

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



Premier Form Tools Ltd

Lancaster Road, Bowerhill, Melksham, Wiltshire, SN12 6SS, UK

Tel: +44 (0)1225 702584 Fax: +44 (0)1225 790026

e-mail: enquiries@premierformtools.co.uk

Full details of our products are available at
www.premierformtools.co.uk