

A

DRILLING

**AccuThread® 856 Thread Mill Inserts**

Bolt-in Style | NPT / NPTF



B

BORING

| TPI (Pitch) | Insert              |                   |                     |                   | Part No.                 |
|-------------|---------------------|-------------------|---------------------|-------------------|--------------------------|
|             | L <sub>6</sub> inch | L <sub>6</sub> mm | T <sub>1</sub> inch | T <sub>1</sub> mm | NPT<br>Internal/External |
| 18          | 0.750               | 19.05             | 0.080               | 2.03              | <b>TP075K-NPT18</b>      |
| 14          | 1.000               | 25.40             | 0.140               | 3.56              | <b>TP100K-NPT14</b>      |



C

REAMING

| TPI (Pitch) | Insert              |                   |                     |                   | Part No.                  |
|-------------|---------------------|-------------------|---------------------|-------------------|---------------------------|
|             | L <sub>6</sub> inch | L <sub>6</sub> mm | T <sub>1</sub> inch | T <sub>1</sub> mm | NPTF<br>Internal/External |
| 18          | 0.750               | 19.05             | 0.080               | 2.03              | <b>TP075K-NPTF18</b>      |
| 14          | 1.000               | 25.40             | 0.140               | 3.56              | <b>TP100K-NPTF14</b>      |

D

BURNISHING

E

THREADING

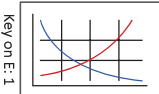
X

SPECIALS

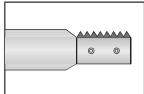
E: 60 - 63

E: 37

E: 43



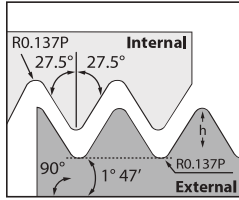




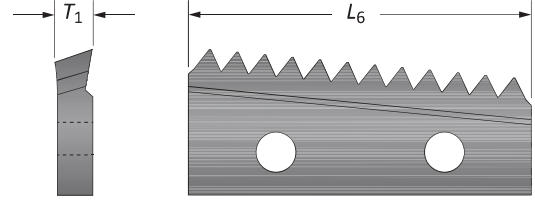
Inserts sold in quantities of 2

## AccuThread® 856 Thread Mill Inserts

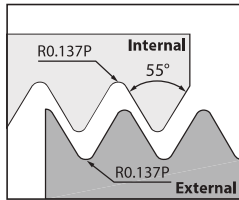
Bolt-in Style | BSPT / BSPP



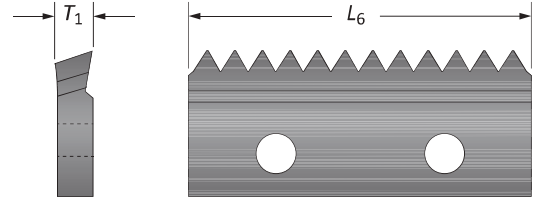
**BSPT**  
Internal / External



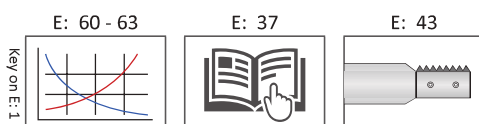
| TPI (Pitch) | Insert     |          |            |          | Part No.                  |
|-------------|------------|----------|------------|----------|---------------------------|
|             | $L_6$ inch | $L_6$ mm | $T_1$ inch | $T_1$ mm | BSPT<br>Internal/External |
| 19          | 0.750      | 19.05    | 0.080      | 2.03     | <b>TP075K-BSPT19</b>      |
| 19          | 1.000      | 25.40    | 0.140      | 3.56     | <b>TP100K-BSPT19</b>      |
| 14          | 1.000      | 25.40    | 0.140      | 3.56     | <b>TP100K-BSPT14</b>      |



**BSPP**  
Internal / External



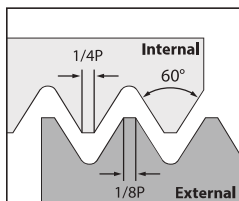
| TPI (Pitch) | Insert     |          |            |          | Part No.                  |
|-------------|------------|----------|------------|----------|---------------------------|
|             | $L_6$ inch | $L_6$ mm | $T_1$ inch | $T_1$ mm | BSPP<br>Internal/External |
| 19          | 0.750      | 19.05    | 0.080      | 2.03     | <b>TP075K-BSPP19</b>      |
| 19          | 1.000      | 25.40    | 0.140      | 3.56     | <b>TP100K-BSPP19</b>      |
| 14          | 1.000      | 25.40    | 0.140      | 3.56     | <b>TP100K-BSPP14</b>      |



Inserts sold in quantities of 2

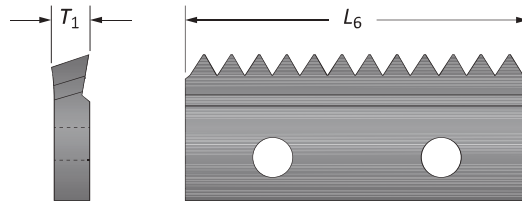
AccuThread® 856 Thread Mill Inserts

Bolt-in Style | UN



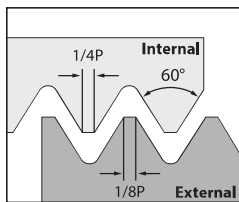
UN

Internal



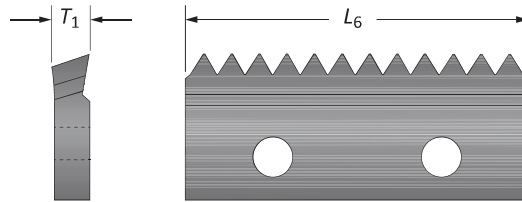
| TPI (Pitch) | Insert              |                   |                     |                   | Part No.      |
|-------------|---------------------|-------------------|---------------------|-------------------|---------------|
|             | L <sub>6</sub> inch | L <sub>6</sub> mm | T <sub>1</sub> inch | T <sub>1</sub> mm | UN Internal   |
| 32          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN32I  |
| 32          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN32I  |
| 24          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN24I  |
| 24          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN24I  |
| 20          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN20I  |
| 20          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN20I  |
| 18          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN18I  |
| 18          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN18I  |
| 16          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN16I  |
| 16          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN16I  |
| 14          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN14I  |
| 13          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN13I  |
| 12          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN12I  |
| 10*         | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN10I* |

\*This item is only used with THN-0611-1F100. The reduced body allows a 3/4"-10 UN/UNJ to be produced.



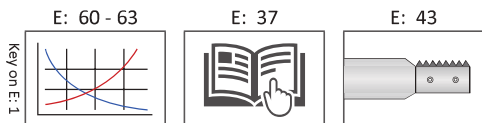
UN

External



| TPI (Pitch) | Insert              |                   |                     |                   | Part No.      |
|-------------|---------------------|-------------------|---------------------|-------------------|---------------|
|             | L <sub>6</sub> inch | L <sub>6</sub> mm | T <sub>1</sub> inch | T <sub>1</sub> mm | UN External   |
| 32          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN32E  |
| 32          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN32E  |
| 24          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN24E  |
| 24          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN24E  |
| 20          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN20E  |
| 20          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN20E  |
| 18          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN18E  |
| 18          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN18E  |
| 16          | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-UN16E  |
| 16          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN16E  |
| 14          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN14E  |
| 13          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN13E  |
| 12          | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN12E  |
| 10*         | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-UN10E* |

\*This item is only used with THN-0611-1F100. The reduced body allows a 3/4"-10 UN/UNJ to be produced.

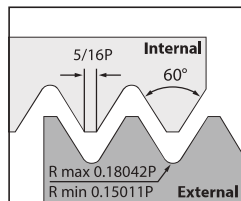


Inserts sold in quantities of 2

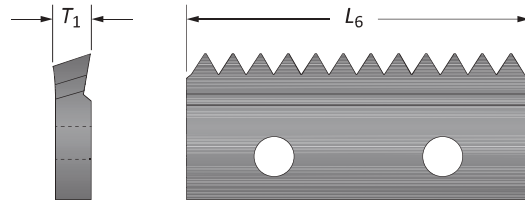


# AccuThread® 856 Thread Mill Inserts

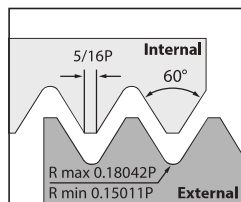
Bolt-in Style | UNJ



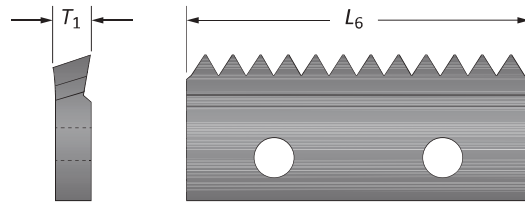
UNJ  
Internal



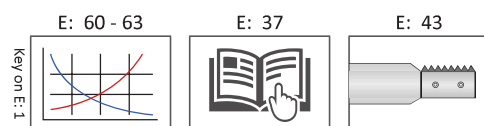
| TPI (Pitch) | Insert     |          |            |          | Part No.        |
|-------------|------------|----------|------------|----------|-----------------|
|             | $L_6$ inch | $L_6$ mm | $T_1$ inch | $T_1$ mm | UNJ<br>Internal |
| 32          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ32I   |
| 32          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ32I   |
| 24          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ24I   |
| 24          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ24I   |
| 20          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ20I   |
| 20          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ20I   |
| 18          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ18I   |
| 18          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ18I   |
| 16          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ16I   |
| 16          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ16I   |
| 14          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ14I   |
| 12          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ12I   |



UNJ  
External



| TPI (Pitch) | Insert     |          |            |          | Part No.        |
|-------------|------------|----------|------------|----------|-----------------|
|             | $L_6$ inch | $L_6$ mm | $T_1$ inch | $T_1$ mm | UNJ<br>External |
| 32          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ32E   |
| 32          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ32E   |
| 24          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ24E   |
| 24          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ24E   |
| 20          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ20E   |
| 20          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ20E   |
| 18          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ18E   |
| 18          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ18E   |
| 16          | 0.750      | 19.05    | 0.080      | 2.03     | TP075K-UNJ16E   |
| 16          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ16E   |
| 12          | 1.000      | 25.40    | 0.140      | 3.56     | TP100K-UNJ12E   |



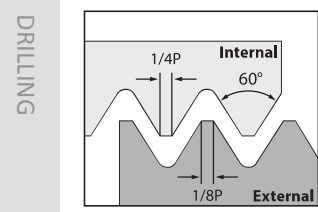
Inserts sold in quantities of 2

A

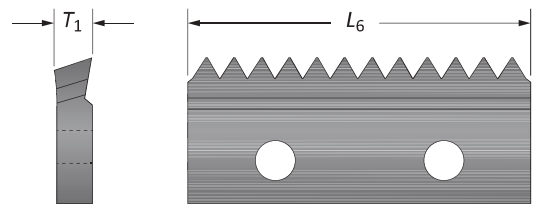
DRILLING

AccuThread® 856 Thread Mill Inserts

Bolt-in Style | ISO



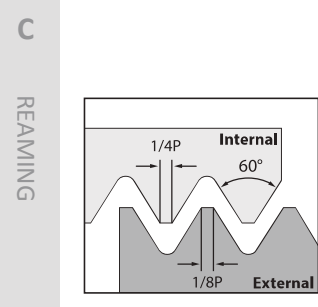
ISO  
Internal



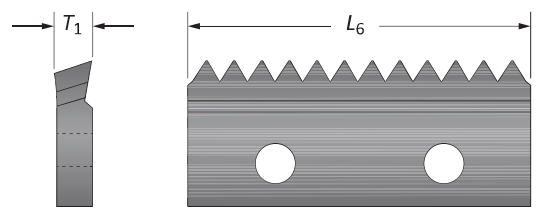
B

BORING

| Pitch | Insert              |                   |                     |                   | Part No.      |
|-------|---------------------|-------------------|---------------------|-------------------|---------------|
|       | L <sub>6</sub> inch | L <sub>6</sub> mm | T <sub>1</sub> inch | T <sub>1</sub> mm | ISO Internal  |
| 0.5   | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-M0.5I  |
| 1.0   | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-M1.0I  |
| 1.0   | 1.000               | 24.40             | 0.140               | 3.56              | TP100K-M1.0I  |
| 1.25  | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-M1.25I |
| 1.5   | 0.750               | 19.05             | 0.080               | 2.03              | TP075K-M1.5I  |
| 1.5   | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-M1.5I  |
| 2.0   | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-M2.0I  |



ISO  
External



D

BURNISHING

| Pitch | Insert              |                   |                     |                   | Part No.     |
|-------|---------------------|-------------------|---------------------|-------------------|--------------|
|       | L <sub>6</sub> inch | L <sub>6</sub> mm | T <sub>1</sub> inch | T <sub>1</sub> mm | ISO External |
| 1.0   | 1.000               | 24.40             | 0.140               | 3.56              | TP100K-M1.0E |
| 1.5   | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-M1.5E |
| 2.0   | 1.000               | 25.40             | 0.140               | 3.56              | TP100K-M2.0E |

E

THREADING

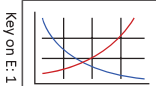
X

SPECIALS

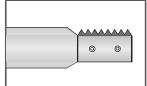
E: 60 - 63

E: 37

E: 43



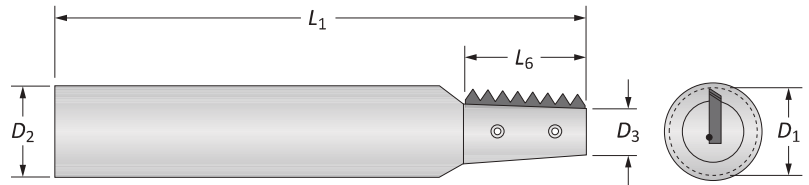




Inserts sold in quantities of 2

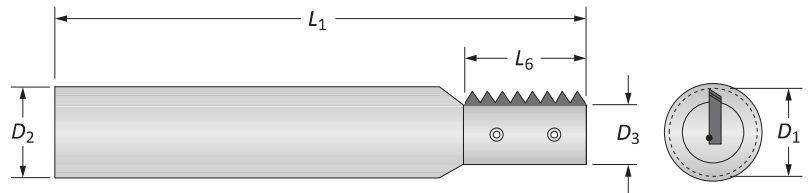
## AccuThread® 856 Thread Mill Insert Holders

Bolt-in Style



### Tapered Insert Holders | NPT / NPTF / BSPT

|   | Holder |       |       |       |       |        |                        |           |         |        |
|---|--------|-------|-------|-------|-------|--------|------------------------|-----------|---------|--------|
|   | $D_1$  | $D_3$ | $D_2$ | $L_6$ | $L_1$ | Flutes | Part No.               | Inserts   | Screw   | Wrench |
| i | 0.400  | 0.229 | 0.500 | 0.750 | 3.000 | 1      | <b>THT-0400-1F075</b>  | TP075K... | TMS-250 | 8T-8   |
|   | 0.659  | 0.379 | 0.500 | 1.000 | 3.000 | 1      | <b>THT-0659-1F100</b>  | TP100K... | TMS-45  | 8T-9   |
| m | 10.16  | 5.82  | 13.00 | 19.05 | 76.20 | 1      | <b>THT-0400-1F075M</b> | TP075K... | TMS-250 | 8T-8   |
|   | 16.74  | 9.65  | 13.00 | 25.40 | 76.20 | 1      | <b>THT-0659-1F100M</b> | TP100K... | TMS-45  | 8T-9   |



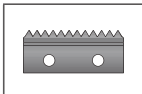
### Straight Insert Holders | BSPP / UN / UNJ / ISO

|   | Holder |       |       |       |       |        |                        |           |         |        |
|---|--------|-------|-------|-------|-------|--------|------------------------|-----------|---------|--------|
|   | $D_1$  | $D_3$ | $D_2$ | $L_6$ | $L_1$ | Flutes | Part No.               | Inserts   | Screw   | Wrench |
| i | 0.394  | 0.250 | 0.500 | 0.750 | 3.000 | 1      | <b>THN-0394-1F075</b>  | TP075K... | TMS-250 | 8T-8   |
|   | 0.611  | 0.383 | 0.750 | 1.000 | 3.500 | 1      | <b>THN-0611-1F100</b>  | *SEE NOTE | TMS-40  | 8T-9   |
|   | 0.625  | 0.454 | 0.750 | 1.000 | 3.500 | 1      | <b>THN-0625-1F100</b>  | TP100K... | TMS-40  | 8T-9   |
| m | 10.01  | 6.35  | 13.00 | 19.05 | 76.20 | 1      | <b>THN-0394-1F075M</b> | TP075K... | TMS-250 | 8T-8   |
|   | 15.88  | 11.58 | 20.00 | 25.40 | 88.90 | 1      | <b>THN-0625-1F100M</b> | TP100K... | TMS-40  | 8T-9   |

\*NOTE: Only UN/UNJ 10 TPI inserts can be used in this holder. Please refer to inserts on pages E: 38-39.

E: 37

E: 38 - 42



i = Imperial (in)  
m = Metric (mm)