



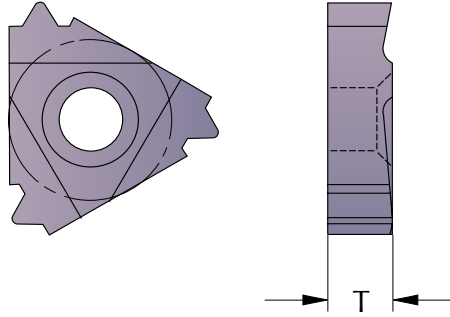
THREAD TURNING

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THREAD TURNING INSERTS

Thicker Thread Turning Inserts

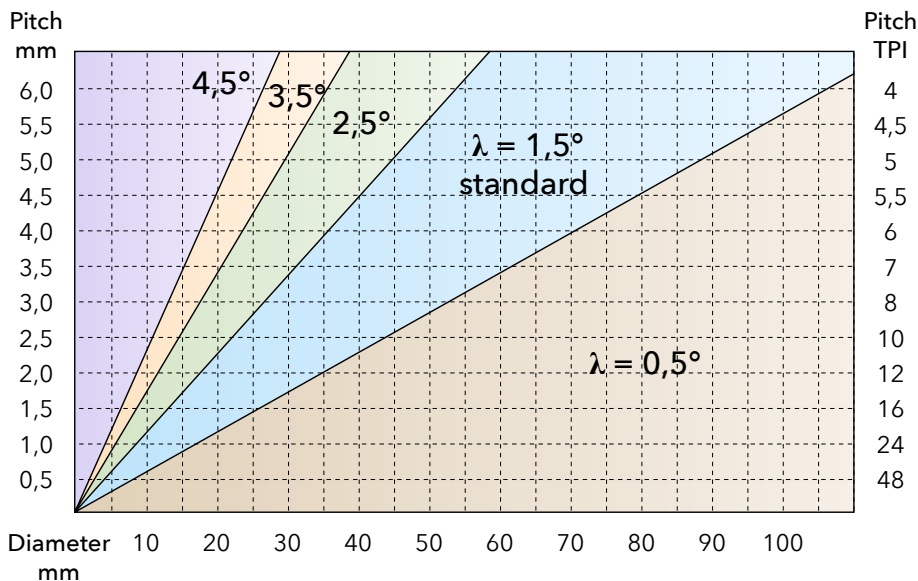


Standard		Thicker	
Insert	T (mm)	Insert	T (mm)
11	3,18	11T	3,32
16	3,68	16T	4,10
22	4,90	22T	5,76

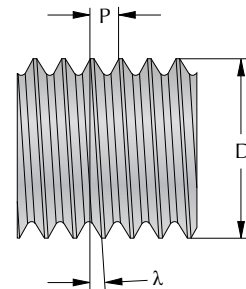
The thicker insert will not fit in toolholders from SmiCut, but can be used with holders for thicker inserts. The inserts are available in the most common profiles for external and internal threading. The price is 15% higher for thicker inserts.

Helix Angle

To get satisfied cutting conditions the threading insert has to be inclined in the toolholder about the same as the helix angle. The toolholder has always as standard an inclination of 1,5° which are the optimal for most threads. You will receive the correct inclination on the threading insert if you use an anvil according to the table below.

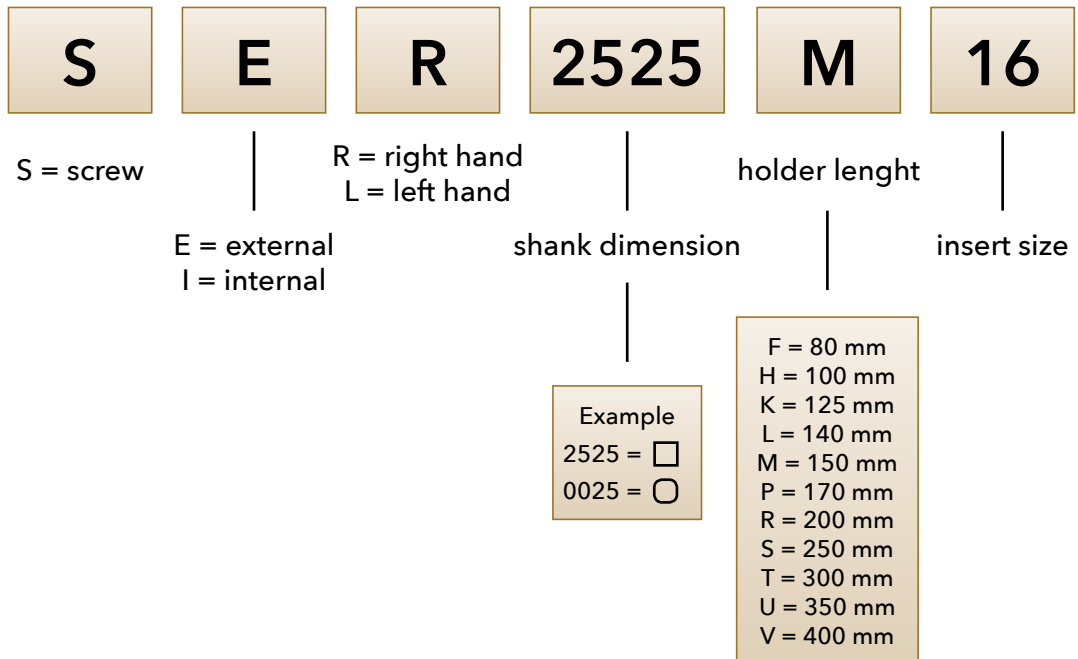


$$\tan \lambda = \frac{P}{\pi \times D}$$

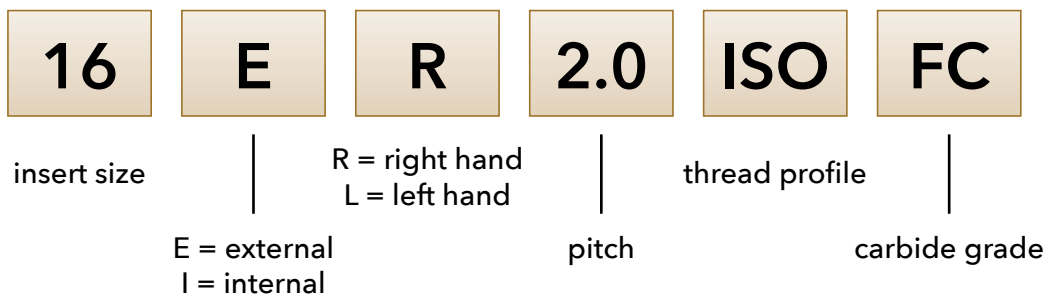


CODE KEY

Toolholders



















Inserts



Cutting Speed (V_c) and Material Factor (F_m)

MATERIAL		Hardness HB	Tensile Strength N/mm ²	Cutting Speed (V_c) m/min	Material Factor (F_m)
Steel	Low carbon, C < 0,25%	< 120	< 400	150 - 200	1,2
	Medium carbon, C < 0,55%	< 200	< 700	120 - 170	1,1
	High carbon, C < 0,85%	< 250	< 850	110 - 150	1,0
	Low alloy	< 250	< 850	100 - 140	1,0
	High alloy	< 350	< 1200	70 - 110	0,9
	Hardened, HRC < 45			60 - 100	0,8
	Hardened, HRC < 55			30 - 60	0,7
	Hardened, HRC < 65			20 - 40	0,6
Cast iron	Lamellar graphite	< 150	< 500	130 - 180	1,2
	Lamellar graphite	< 300	< 1000	100 - 150	1,1
	Nodular graphite, malleable	< 200	< 700	100 - 150	1,0
	Nodular graphite, malleable	< 300	< 1000	80 - 120	0,9
Stainless steel	Free machining	< 250	< 850	130 - 180	1,0
	Austenitic	< 250	< 850	90 - 140	0,9
	Ferritic and austenitic	< 300	< 1000	80 - 120	0,8
Titanium	Unalloyed	< 200	< 700	60 - 80	0,8
	Alloyed	< 270	< 900	50 - 70	0,7
	Alloyed	< 350	< 1250	30 - 50	0,6
Nickel	Unalloyed	< 150	< 500	80 - 120	0,8
	Alloyed	< 270	< 900	60 - 80	0,7
	Alloyed	< 350	< 1250	50 - 70	0,6
Copper	Unalloyed	< 100	< 350	150 - 250	1,0
	Brass, bronze	< 200	< 700	130 - 180	1,0
	High strength bronze	< 470	< 1500	60 - 80	0,8
Aluminium	Unalloyed	< 100	< 350	500 - 900	1,4
	Alloyed, Si < 0.5%	< 150	< 500	400 - 800	1,3
	Alloyed, Si < 10%	< 120	< 400	300 - 500	1,2
	Alloyed, Si > 10%	< 120	< 400	200 - 400	1,1
Inconel	718	< 370		50 - 70	0,6
Graphite				300 - 500	1,0

Threading Methods

RIGHT HAND THREAD				LEFT HAND THREAD			
Tool	Anvil	Rotation	Direction	Tool	Anvil	Rotation	Direction
SER	AE +			SEL	AI +		
SEL	AI -			SER	AE -		
SIR	AI +			SIL	AE +		
SIL	AE -			SIR	AI -		

Number of Passes

ISO	Pitch			Material Factor (F_m)									
	UN	W	NPT	0,6	0,7	0,8	0,9	1,0	1,1	1,2	1,3	1,4	
0,5				7	6	5	4	4	4	4	4	4	
0,75	32	28		8	6	6	5	4	4	4	4	4	
1,0	28-24	19		8	7	6	6	5	5	4	4	4	
1,25	20			9	8	7	6	6	5	5	4	4	
1,5	18-16	14		10	9	8	7	6	5	5	5	4	
1,75	14			12	10	9	8	7	6	6	5	5	
2,0	13-12		27	14	12	11	9	8	8	7	7	6	
2,5	11-10	11	18	16	14	13	11	10	9	8	8	7	
3,0	9-8		14	18	16	14	12	11	10	9	8	8	
3,5	7			20	17	15	13	12	11	10	9	9	
4,0	6		11,5	22	19	16	14	13	12	11	10	9	
4,5				23	20	17	15	14	12	11	10	10	
5,0	5			24	20	18	16	14	13	12	11	10	
5,5	4,5		8	25	21	19	17	15	14	13	12	11	
6,0	4			27	23	20	18	16	15	13	12	11	

Radial Infeed Each Pass

PASS	Percentage of the total infeed																
	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
1	33	28	25	22	20	19	18	16	14	12	11	11	11	11	10	10	9
2	27	24	20	18	17	16	15	14	13	11	10	10	10	10	10	9	9
3	22	19	17	16	15	14	13	12	11	10	9	9	9	9	9	8	8
4	18	16	15	14	13	12	11	10	9	9	8	8	8	8	8	8	8
5		13	13	12	11	10	9	8	8	8	8	8	8	8	8	7	7
6			10	10	10	9	8	8	8	8	8	7	7	7	7	6	6
7				8	8	8	7	8	8	7	7	7	7	6	6	6	6
8					6	7	7	7	7	7	7	7	6	6	6	6	6
9						5	7	7	7	7	7	6	6	5	6	5	5
10							5	6	6	6	6	6	5	5	5	5	5
11								4	5	6	6	5	5	5	5	5	5
12									4	5	5	5	5	4	4	5	5
13										4	4	4	4	4	4	4	4
14											3	4	4	4	4	4	4
15												3	4	4	4	4	3
16													2	3	3	3	3
17														2	2	2	2
18															2	1,5	2
19																1,5	1,5
20																	1,5

Carbide Grades

FC

Micrograin Carbide with TiAlN coating. Allround Grade with high heat resistance. Use cutting data according to the tables.

BC

Micrograin Carbide with TiN coating. Suitable for internal thread turning of small dimensions. Cutting speed 40% less than FC.

THREAD TURNING TOOLHOLDERS

external



Insert mm	Part Number	B/H mm	L mm	F mm
16	SER_1212_F16	12	80	16
16	SER_1616_H16	16	100	16
16	SER_2020_K16	20	125	20
16	SER_2525_M16	25	150	25
16	SER_3232_P16	32	170	32
22	SER_2525_M22	25	150	25
22	SER_3232_P22	32	170	32
22	SER_4040_R22	40	200	40
27	SER_2525_M27	25	150	32
27	SER_3232_P27	32	170	32
27	SER_4040_R27	40	200	40

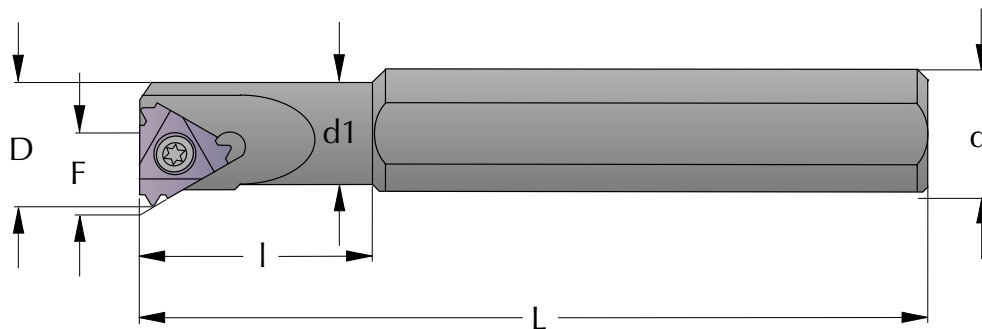
Spare Parts

Insert mm	Screw to insert	Torx key	Screw to anvil	Anvil
16	S16	K16	A16	AE16...
22	S22	K22	A22	AE22...
27	S27	K27	A27	AE27...

■ The Part Numbers are for Right Hand Toolholders. For Left Hand specify L instead of R. Give Helix Angle for Anvil, ex. AE16+0.5

THREAD TURNING TOOLHOLDERS

internal



Insert mm	D mm	Part Number	d mm	d1 mm	l mm	L mm	F mm
6	6,0	SIR_0005_H06*	12	5,1	12	100	4,3
8	7,8	SIR_0007_K08*	16	6,6	18	125	5,3
11	12	SIR_0010_H11*	10	10		100	7,4
11	12	SIR_0010_K11*	16	10	25	125	7,4
11	15	SIR_0013_L11*	16	13	32	140	8,9
16	16	SIR_0013_M16*	16	13	32	150	10,2
16	19	SIR_0016_P16*	20	16	40	170	11,7
16	24	SIR_0020_P16	20	20		170	13,7
16	29	SIR_0025_R16	25	25		200	16,2
16	36	SIR_0032_S16	32	32		250	19,7
16	44	SIR_0040_T16	40	40		300	23,7
22	24	SIR_0020_P22*	20	20		170	15,6
22	29	SIR_0025_R22	25	25		200	18,1
22	38	SIR_0032_S22	32	32		250	21,6
22	46	SIR_0040_T22	40	40		300	25,6
27	40	SIR_0032_S27	32	32		250	22,6
27	48	SIR_0040_T27	40	40		300	26,6
27	58	SIR_0050_U27	50	50		350	31,6
27	68	SIR_0060_V27	60	60		400	36,6

with Carbide Shank and Internal Coolant

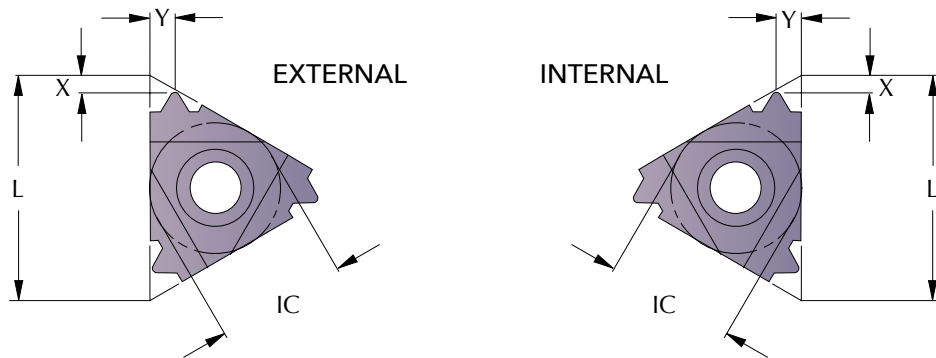
Insert mm	D mm	Part Number	d mm	d1 mm	l mm	L mm	F mm
6	6,0	SIR_0005_H06CB*	6	5,1	26	100	4,3
8	7,8	SIR_0007_K08CB*	8	6,6	31	125	5,3
11	12	SIR_0010_M11CB*	10	10		150	7,4
11	15	SIR_0012_P11CB*	12	12		170	8,4
16	19	SIR_0016_R16CB*	16	16		200	11,7
16	23	SIR_0020_S16CB	20	20		250	13,7
16	28	SIR_0025_S16CB	25	25		250	16,2
22	24,5	SIR_0020_S22CB*	20	20		250	15,6

Spare Parts

Insert mm	Screw to Insert	Torx key	Screw to anvil	Anvil
06	S6	K6		
08	S8	K8		
11	S11	K11		
16	S16	K16	A16	AI16...
22	S22	K22	A22	AI22...
27	S27	K27	A27	AI27...

*Toolholder without anvil

THREAD TURNING INSERTS



M

METRIC

Pitch mm	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
0,5	6	5/32				061R_0.5ISO_BC	0,9	0,5
0,5	16	3/8	16ER_0.5ISO_FC	0,6	0,6			
0,7	16	3/8	16ER_0.7ISO_FC	0,6	0,6			
0,75	6	5/32				061R_0.75ISO_BC	0,8	0,5
0,75	8	3/16				081R_0.75ISO_BC	0,6	0,5
0,75	16	3/8	16ER_0.75ISO_FC	0,6	0,6			
0,8	16	3/8	16ER_0.8ISO_FC	0,6	0,6			
1,0	6	5/32				061R_1.0ISO_BC	0,7	0,6
1,0	8	3/16				081R_1.0ISO_BC	0,6	0,6
1,0	11	1/4				111R_1.0ISO_FC	0,6	0,7
1,0	16	3/8	16ER_1.0ISO_FC	0,7	0,7	161R_1.0ISO_FC	0,6	0,7
1,25	6	5/32				061R_1.25ISO_BC	0,6	0,6
1,25	8	3/16				081R_1.25ISO_BC	0,6	0,7
1,25	11	1/4				111R_1.25ISO_FC	0,8	0,8
1,25	16	3/8	16ER_1.25ISO_FC	0,8	0,9	161R_1.25ISO_FC	0,8	0,9
1,5	8	3/16				081R_1.5ISO_BC	0,6	0,7
1,5	11	1/4				111R_1.5ISO_FC	0,8	1,0
1,5	16	3/8	16ER_1.5ISO_FC	0,8	1,0	161R_1.5ISO_FC	0,8	1,0
1,75	8	3/16				081R_1.75ISO_BC	1,0	0,8
1,75	16	3/8	16ER_1.75ISO_FC	0,9	1,2			
2,0	11	1/4				111R_2.0ISO_FC	0,8	0,9
2,0	16	3/8	16ER_2.0ISO_FC	1,0	1,3	161R_2.0ISO_FC	1,0	1,3
2,5	16	3/8	16ER_2.5ISO_FC	1,1	1,5	161R_2.5ISO_FC	1,1	1,5
3,0	16	3/8	16ER_3.0ISO_FC	1,2	1,6	161R_3.0ISO_FC	1,1	1,5
3,5	16	3/8	16ER_3.5ISO_FC	1,2	1,7	161R_3.5ISO_FC	1,2	1,7
3,5	22	1/2	22ER_3.5ISO_FC	1,6	2,3	221R_3.5ISO_FC	1,6	2,3
4,0	22	1/2	22ER_4.0ISO_FC	1,6	2,3	221R_4.0ISO_FC	1,6	2,3
4,5	22	1/2	22ER_4.5ISO_FC	1,7	2,4	221R_4.5ISO_FC	1,6	2,4
5,0	22	1/2	22ER_5.0ISO_FC	1,7	2,5	221R_5.0ISO_FC	1,6	2,3
5,5	22	1/2	22ER_5.5ISO_FC	1,7	2,6	221R_5.5ISO_FC	1,6	2,3
5,5	27	5/8	27ER_5.5ISO_FC	1,9	2,7	271R_5.5ISO_FC	1,6	2,3
6,0	22	1/2	22ER_6.0ISO_FC	1,9	2,7	221R_6.0ISO_FC	1,6	2,4
6,0	27	5/8	27ER_6.0ISO_FC	2,0	2,9	271R_6.0ISO_FC	1,8	2,5
WITH SINTERED CHIPBREAKER								
1,0	16	3/8	16ER_1.0ISOFCB_FC	0,7	0,7	161R_1.0ISOFCB_FC	0,6	0,7
1,25	16	3/8	16ER_1.25ISOFCB_FC	0,8	0,9			
1,5	16	3/8	16ER_1.5ISOFCB_FC	0,8	1,0	161R_1.5ISOFCB_FC	0,8	1,0
1,75	16	3/8	16ER_1.75ISOFCB_FC	0,9	1,2			
2,0	16	3/8	16ER_2.0ISOFCB_FC	1,0	1,3	161R_2.0ISOFCB_FC	1,0	1,3
2,5	16	3/8	16ER_2.5ISOFCB_FC	1,1	1,5	161R_2.5ISOFCB_FC	1,1	1,5
3,0	16	3/8	16ER_3.0ISOFCB_FC	1,2	1,6	161R_3.0ISOFCB_FC	1,1	1,5
MULTITOOTH								
1,0	16	3/8	16ER_1.0ISO3M_FC	1,7	2,5	161R_1.0ISO3M_FC	1,7	2,5
1,5	16	3/8	16ER_1.5ISO2M_FC	1,5	2,3	161R_1.5ISO2M_FC	1,5	2,3
1,5	22	1/2	22ER_1.5ISO3M_FC	2,3	3,7	221R_1.5ISO3M_FC	2,3	3,7
2,0	22	1/2	22ER_2.0ISO2M_FC	2,0	3,0	221R_2.0ISO2M_FC	2,0	3,0
2,0	22	1/2	22ER_2.0ISO3M_FC	3,1	5,0	221R_2.0ISO3M_FC	3,1	5,0
3,0	27	5/8	27ER_3.0ISO2M_FC	2,9	4,5	271R_3.0ISO2M_FC	2,9	4,5

THREAD TURNING INSERTS



UN

UNIFIED

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
32	6	5/32				06IR_32UN_BC	0,8	0,5
32	8	3/16				08IR_32UN_BC	0,6	0,5
32	11	1/4				11IR_32UN_FC	0,6	0,6
32	16	3/8	16ER_32UN_FC	0,6	0,6	16IR_32UN_FC	0,6	0,6
28	6	5/32				06IR_28UN_BC	0,8	0,6
28	8	3/16				08IR_28UN_BC	0,6	0,6
28	11	1/4				11IR_28UN_FC	0,6	0,7
28	16	3/8	16ER_28UN_FC	0,6	0,7	16IR_28UN_FC	0,6	0,7
24	6	5/32				06IR_24UN_BC	0,7	0,6
24	8	3/16				08IR_24UN_BC	0,6	0,6
24	11	1/4				11IR_24UN_FC	0,7	0,8
24	16	3/8	16ER_24UN_FC	0,7	0,8			
20	6	5/32				06IR_20UN_BC	0,6	0,6
20	8	3/16				08IR_20UN_BC	0,6	0,7
20	11	1/4				11IR_20UN_FC	0,8	0,9
20	16	3/8	16ER_20UN_FC	0,8	0,9	16IR_20UN_FC	0,8	0,9
18	6	5/32				06IR_18UN_BC	0,6	0,7
18	11	1/4				11IR_18UN_FC	0,8	1,0
18	16	3/8	16ER_18UN_FC	0,8	1,0			
16	8	3/16				08IR_16UN_BC	0,6	0,7
16	11	1/4				11IR_16UN_FC	0,9	1,1
16	16	3/8	16ER_16UN_FC	0,9	1,1	16IR_16UN_FC	0,9	1,1
14	8	3/16				08IR_14UN_BC	0,6	0,8
14	16	3/8	16ER_14UN_FC	1,0	1,2	16IR_14UN_FC	0,9	1,2
13	16	3/8	16ER_13UN_FC	1,0	1,3			
12	11	1/4				11IR_12UN_FC	0,9	1,1
12	16	3/8	16ER_12UN_FC	1,1	1,4	16IR_12UN_FC	1,1	1,4
11	11	1/4				11IR_11UN_FC	0,8	1,1
11	16	3/8	16ER_11UN_FC	1,1	1,5			
10	16	3/8	16ER_10UN_FC	1,1	1,5	16IR_10UN_FC	1,1	1,5
9	16	3/8	16ER_9UN_FC	1,2	1,7	16IR_9UN_FC	1,2	1,7
8	16	3/8	16ER_8UN_FC	1,2	1,6	16IR_8UN_FC	1,1	1,5
7	22	1/2	22ER_7UN_FC	1,6	2,3	22IR_7UN_FC	1,6	2,3
6	22	1/2	22ER_6UN_FC	1,6	2,3	22IR_6UN_FC	1,6	2,3
5	22	1/2	22ER_5UN_FC	1,7	2,5	22IR_5UN_FC	1,6	2,3
4,5	27	5/8	27ER_4.5UN_FC	1,9	2,7	27IR_4.5UN_FC	1,7	2,4
4	27	5/8	27ER_4UN_FC	2,1	3,0	27IR_4UN_FC	1,8	2,7
MULTITOOTH								
16	16	3/8	16ER_16UN2M_FC	1,5	2,3	16IR_16UN2M_FC	1,5	2,3
16	16	3/8	22ER_16UN3M_FC	2,5	4,0	22IR_16UN3M_FC	2,5	4,0
12	22	1/2	22ER_12UN2M_FC	2,2	3,4	22IR_12UN2M_FC	2,2	3,4
12	22	1/2	22ER_12UN3M_FC	3,3	5,3	22IR_12UN3M_FC	3,3	5,3
8	27	5/8	27ER_8UN2M_FC	3,1	4,9	27IR_8UN2M_FC	3,1	4,9

- The Part Numbers are for Right Hand Inserts. For Left Hand specify L instead of R. The Price is 10% higher for L.
- The Price is 15% Higher for Thicker Thread Turning Inserts. Ex 16TER...
- All Inserts have ground profile and chipbreaker if nothing else is indicated.

THREAD TURNING INSERTS

G

WHITWORTH PIPE THREAD

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
28	8	3/16				08IR_28W_BC	0,6	0,6
28	16	3/8	16ER_28W_FC	0,6	0,7			
19	8	3/16				08IR_19W_BC	0,6	0,7
19	11	1/4				11IR_19W_FC	0,8	1,0
19	16	3/8	16ER_19W_FC	0,8	1,0			
14	16	3/8	16ER_14W_FC	1,0	1,2	16IR_14W_FC	1,0	1,2
11	16	3/8	16ER_11W_FC	1,1	1,5	16IR_11W_FC	1,1	1,5
WITH SINTERED CHIPBREAKER								
19	16	3/8	16ER_19WCB_FC	0,8	1,0			
14	16	3/8	16ER_14WCB_FC	1,0	1,2	16IR_14WCB_FC	1,0	1,2
11	16	3/8	16ER_11WCB_FC	1,1	1,5	16IR_11WCB_FC	1,1	1,5
MULTITOOTH								
14	16	3/8	16ER_14W2M_FC	1,7	2,7	16IR_14W2M_FC	1,7	2,7
14	22	1/2	22ER_14W3M_FC	2,8	4,5	22IR_14W3M_FC	2,8	4,5
11	22	1/2	22ER_11W2M_FC	2,3	3,4	22IR_11W2M_FC	2,3	3,4

■ A wider program of whitworth profiles are available.

BSPT

BSPT PIPE THREAD

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
14	16	3/8	16ER_14BSPT_FC	1,0	1,2	16IR_14BSPT_FC	1,0	1,2
11	16	3/8	16ER_11BSPT_FC	1,1	1,5	16IR_11BSPT_FC	1,1	1,5

NPT

NPT PIPE THREAD

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
27	6	5/32				06IR_27NPT_BC	0,6	0,6
27	8	3/16				08IR_27NPT_BC	0,6	0,6
27	16	3/8	16ER_27NPT_FC	0,7	0,8			
18	8	3/16				08IR_18NPT_BC	0,6	0,6
18	11	1/4				11IR_18NPT_FC	0,8	1,0
18	16	3/8	16ER_18NPT_FC	0,8	1,0			
14	16	3/8	16ER_14NPT_FC	0,9	1,2	16IR_14NPT_FC	0,9	1,2
11,5	16	3/8	16ER_11.5NPT_FC	1,1	1,5	16IR_11.5NPT_FC	1,1	1,5
8	16	3/8	16ER_8NPT_FC	1,3	1,8	16IR_8NPT_FC	1,3	1,8
MULTITOOTH								
11,5	22	1/2	22ER_11.5NPT2M_FC	2,3	3,5	22IR_11.5NPT2M_FC	2,3	3,5
11,5	27	5/8	27ER_11.5NPT3M_FC	3,3	5,5	27IR_11.5NPT3M_FC	3,3	5,5
8	27	5/8	27ER_8NPT2M_FC	3,1	5,0	27IR_8NPT2M_FC	3,1	5,0

NPTF

NPTF DRYSEAL PIPE THREAD

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
27	6	5/32				06IR_27NPTF_BC	0,7	0,6
27	8	3/16				08IR_27NPTF_BC	0,6	0,6
27	16	3/8	16ER_27NPTF_FC	0,7	0,7			
18	8	3/16				08IR_18NPTF_BC	0,6	0,6
18	11	1/4				11IR_18NPTF_FC	0,8	1,0
18	16	3/8	16ER_18NPTF_FC	0,8	1,0			
14	16	3/8	16ER_14NPTF_FC	0,9	1,2	16IR_14NPTF_FC	0,9	1,2
11,5	16	3/8	16ER_11.5NPTF_FC	1,1	1,5	16IR_11.5NPTF_FC	1,1	1,5
8	16	3/8	16ER_8NPTF_FC	1,3	1,8	16IR_8NPTF_FC	1,3	1,8

THREAD TURNING INSERTS



60°

PARTIAL PROFILE 60°

Pitch mm	TPI	L mm	IC inch	EXTERNAL Part Number	INTERNAL Part Number	X mm	Y mm
0,5-1,25	48-20	6	5/32		06IR_A60_BC	0,6	0,6
0,5-1,5	48-16	8	3/16		08IR_A60_BC	0,6	0,7
0,5-1,5	48-16	11	1/4		11IR_A60_FC	0,8	0,9
0,5-1,5	48-16	16	3/8	16ER_A60_FC	16IR_A60_FC	0,8	0,9
1,75-3,0	14-8	16	3/8	16ER_G60_FC	16IR_G60_FC	1,2	1,7
0,5-3,0	48-8	16	3/8	16ER_AG60_FC	16IR_AG60_FC	1,2	1,7
3,5-5,0	7-5	22	1/2	22ER_N60_FC	22IR_N60_FC	1,7	2,5
5,5-6,0	4,5-4	27	5/8	27ER_Q60_FC	27IR_Q60_FC	2,1	3,1

55°

PARTIAL PROFILE 55°

Pitch mm	TPI	L mm	IC inch	EXTERNAL Part Number	INTERNAL Part Number	X mm	Y mm
0,5-1,25	48-20	6	5/32		06IR_A55_BC	0,5	0,6
0,5-1,5	48-16	8	3/16		08IR_A55_BC	0,6	0,7
0,5-1,5	48-16	11	1/4		11IR_A55_FC	0,8	0,9
0,5-1,5	48-16	16	3/8	16ER_A55_FC	16IR_A55_FC	0,8	0,9
1,75-3,0	14-8	16	3/8	16ER_G55_FC	16IR_G55_FC	1,2	1,7
0,5-3,0	48-8	16	3/8	16ER_AG55_FC	16IR_AG55_FC	1,2	1,7
3,5-5,0	7-5	22	1/2	22ER_N55_FC	22IR_N55_FC	1,7	2,5
5,5-6,0	4,5-4	27	5/8	27ER_Q55_FC	27IR_Q55_FC	2,0	2,9

ABUT

AMERICAN BUTTRESS

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
20	11	1/4				11IR_20ABUT_FC	1,0	1,3
16	11	1/4				11IR_16ABUT_FC	1,0	1,5
20	16	3/8	16ER_20ABUT_FC	1,0	1,3	16IR_20ABUT_FC	1,0	1,3
16	16	3/8	16ER_16ABUT_FC	1,0	1,5	16IR_16ABUT_FC	1,0	1,5
12	16	3/8	16ER_12ABUT_FC	1,4	2,0	16IR_12ABUT_FC	1,4	2,0
10	16	3/8	16ER_10ABUT_FC	1,5	2,3	16IR_10ABUT_FC	1,5	2,3
8	22	1/2	22ER_8ABUT_FC	2,1	3,3	22IR_8ABUT_FC	2,1	3,3
6	22	1/2	22ER_6ABUT_FC	2,1	3,4	22IR_6ABUT_FC	2,1	3,4

SG

BUTTRESS (SÄGENGEWINDE) DIN 513

Pitch mm	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
2,0	16	3/8	16ER_2.0SG_FC	1,1	1,6	16IR_2.0SG_FC	1,2	1,7
3,0	22	3/8	22ER_3.0SG_FC	1,5	2,4	22IR_3.0SG_FC	1,9	2,9
4,0	22	1/2	22ER_4.0SG_FC	1,9	3,1	22IR_4.0SG_FC	2,3	3,5

PG

STEEL CONDUIT THREAD DIN 40430

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
20	8	3/16				08IR_20PG_BC	0,6	0,7
18	11	1/4				11IR_18PG_FC	0,8	0,9
20	16	3/8	16ER_20PG_FC	0,7	0,8		0,7	0,8
18	16	3/8	16ER_18PG_FC	0,8	0,9	16IR_18PG_FC	0,8	0,9
16	16	3/8	16ER_16PG_FC	0,8	1,0	16IR_16PG_FC	0,8	1,0

■ The Part Numbers are for Right Hand Inserts. For Left Hand specify L instead of R. The Price is 10% higher for L.

THREAD TURNING INSERTS

TR

TRAPEZ DIN 103

Pitch mm	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
1,5	16	3/8	16ER_1.5TR_FC	1,0	1,1			
2,0	16	3/8	16ER_2.0TR_FC	1,0	1,3	16IR_2.0TR_FC	1,0	1,3
3,0	16	3/8	16ER_3.0TR_FC	1,3	1,5	16IR_3.0TR_FC	1,3	1,5
4,0	22	1/2	22ER_4.0TR_FC	1,8	1,9	22IR_4.0TR_FC	1,8	1,9
5,0	22	1/2	22ER_5.0TR_FC	2,0	2,4	22IR_5.0TR_FC	2,0	2,4
6,0	22	1/2	22ER_6.0TR_FC	2,0	2,4	22IR_6.0TR_FC	2,0	2,4
6,0	27	5/8	27ER_6.0TR_FC	2,3	2,7	27IR_6.0TR_FC	2,3	2,7
7,0	27	5/8	27ER_7.0TR_FC	2,2	2,6	27IR_7.0TR_FC	2,2	2,6

RD

ROUND DIN 405

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
10	16	3/8	16ER_10RD_FC	1,1	1,2	16IR_10RD_FC	1,1	1,2
8	16	3/8	16ER_8RD_FC	1,4	1,3	16IR_8RD_FC	1,4	1,4
6	16	3/8	16ER_6RD_FC	1,5	1,7	16IR_6RD_FC	1,4	1,5
6	22	1/2	22ER_6RD_FC	1,5	1,7	22IR_6RD_FC	1,5	1,7
4	22	1/2	22ER_4RD_FC	2,2	2,3	22IR_4RD_FC	2,2	2,3
4	27	5/8	27ER_4RD_FC	2,2	2,3	27IR_4RD_FC	2,2	2,3

ACME

ACME

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
16	11	1/4				11IR_16ACME_FC	0,9	1,0
16	16	3/8	16ER_16ACME_FC	0,9	1,0	16IR_16ACME_FC	0,9	1,0
14	16	3/8	16ER_14ACME_FC	1,0	1,2	16IR_14ACME_FC	1,0	1,2
12	16	3/8	16ER_12ACME_FC	1,1	1,2	16IR_12ACME_FC	1,1	1,2
10	16	3/8	16ER_10ACME_FC	1,3	1,3	16IR_10ACME_FC	1,3	1,3
8	16	3/8	16ER_8ACME_FC	1,5	1,5	16IR_8ACME_FC	1,5	1,5
6	16	3/8	16ER_6ACME_FC	1,7	1,8	16IR_6ACME_FC	1,7	1,8
6	22	1/2	22ER_6ACME_FC	1,8	2,1	22IR_6ACME_FC	1,8	2,1
5	22	1/2	22ER_5ACME_FC	2,0	2,3	22IR_5ACME_FC	2,0	2,3
4	27	5/8	27ER_4ACME_FC	2,3	2,7	27IR_4ACME_FC	2,3	2,7

STACME

STUB ACME

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
16	16	3/8	16ER_16STACME_FC	1,0	1,0	16IR_16STACME_FC	1,0	1,0
14	16	3/8	16ER_14STACME_FC	1,1	1,1	16IR_14STACME_FC	1,1	1,1
12	16	3/8	16ER_12STACME_FC	1,2	1,2	16IR_12STACME_FC	1,2	1,2
10	16	3/8	16ER_10STACME_FC	1,3	1,3	16IR_10STACME_FC	1,3	1,3
8	16	3/8	16ER_8STACME_FC	1,5	1,5	16IR_8STACME_FC	1,5	1,5
6	16	1/2	16ER_6STACME_FC	1,8	1,8	16IR_6STACME_FC	1,8	1,8
5	22	1/2	22ER_5STACME_FC	2,0	2,3	22IR_5STACME_FC	2,0	2,3
4	27	5/8	27ER_4STACME_FC	2,3	2,4	27IR_4STACME_FC	2,3	2,4
3	27	5/8	27ER_3STACME_FC	2,8	2,9	27IR_3STACME_FC	2,8	2,9

■ The Part Numbers are for Right Hand Inserts. For Left Hand specify L instead of R. The Price is 10% higher for L.

THREAD TURNING INSERTS



API RD

API ROUND OIL THREAD

Pitch TPI	L mm	IC inch	Taper IPF	EXTERNAL Part Number	INTERNAL Part Number	X mm	Y mm
10	16	3/8	0,75	16ER_10APIRD_FC	16IR_10APIRD_FC	1,5	1,4
8	16	3/8	0,75	16ER_8APIRD_FC	16IR_8APIRD_FC	1,3	1,6
MULTITOOTH							
10	22	1/2	0,75	22ER_10APIRD2M_FC	22IR_10APIRD2M_FC	2,4	3,7
10	27	5/8	0,75	27ER_10APIRD3M_FC	27IR_10APIRD3M_FC	3,8	6,2
8	27	5/8	0,75	27ER_8APIRD2M_FC	27IR_8APIRD2M_FC	3,0	4,5

V-0.040

V-0.040 OIL THREAD

Pitch TPI	L mm	IC inch	Taper IPF	EXTERNAL Part Number	INTERNAL Part Number	X mm	Y mm	Connection or Size
5	22	1/2	3	22ER_5API403_FC	22IR_5API403_FC	1,8	2,5	2 3/8 - 4 1/2 REG

V-0.038R

V-0.038R OIL THREAD

Pitch TPI	L mm	IC inch	Taper IPF	EXTERNAL Part Number	INTERNAL Part Number	X mm	Y mm	Connection or Size
4	27	5/8	2	27ER_4API382_FC	27IR_4API382_FC	2,1	2,8	NC23-NC50
4	27	5/8	3	27ER_4API383_FC	27IR_4API383_FC	2,1	2,8	NC56-NC77

V-0.050

V-0.050 OIL THREAD

Pitch TPI	L mm	IC inch	Taper IPF	EXTERNAL Part Number	INTERNAL Part Number	X mm	Y mm	Connection or Size
4	27	5/8	2	27ER_4API502_FC	27IR_4API502_FC	2,0	3,0	6 5/8 REG
4	27	5/8	3	27ER_4API503_FC	27IR_4API503_FC	2,0	3,0	5 1/2, 7 5/8, 8 5/8 REG

EL

EXTREME - LINE CASING OIL THREAD

Pitch TPI	L mm	IC inch	Taper IPF	EXTERNAL Part Number	INTERNAL Part Number	X mm	Y mm	Connection or Size
6	22	1/2	1,50	22ER_6EL1.5_FC	22IR_6EL1.5_FC	1,9	1,9	5 - 7 5/8
5	22	1/2	1,25	22ER_5EL1.25_FC	22IR_5EL1.25_FC	2,4	2,3	8 5/8 - 10 3/4

BUT

BUTTRESS CASING OIL THREAD

Pitch TPI	L mm	IC inch	Taper IPF	EXTERNAL Part Number	INTERNAL Part Number	X mm	Y mm	Connection or Size
5	22	1/2	0,75	22ER_5BUT0.75_FC	22IR_5BUT0.75_FC	2,2	2,4	4 1/2 - 13 3/8
5	22	1/2	1,00	22ER_5BUT1.0_FC	22IR_5BUT1.0_FC	2,3	2,4	16 - 20

THREAD TURNING INSERTS

MJ

METRIC

Pitch mm	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
1,0	11	1/4				11IR_1.0MJ_FC	0,6	0,7
1,0	16	3/8	16ER_1.0MJ_FC	0,7	0,7	16IR_1.0MJ_FC	0,6	0,7
1,25	11	1/4				11IR_1.25MJ_FC	0,8	0,8
1,25	16	3/8	16ER_1.25MJ_FC	0,8	0,9	16IR_1.25MJ_FC	0,8	0,9
1,5	11	1/4				11IR_1.5MJ_FC	0,8	1,0
1,5	16	3/8	16ER_1.5MJ_FC	0,8	1,0	16IR_1.5MJ_FC	0,8	1,0
2,0	11	1/4				11IR_2.0MJ_FC	0,8	0,9
2,0	16	3/8	16ER_2.0MJ_FC	1,0	1,3	16IR_2.0MJ_FC	1,0	1,3

UNJ

UNIFIED

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
32	11	1/4				11IR_32UNJ_FC	0,6	0,6
32	16	3/8	16ER_32UNJ_FC	0,6	0,6	16IR_32UNJ_FC	0,6	0,6
28	11	1/4				11IR_28UNJ_FC	0,6	0,7
28	16	3/8	16ER_28UNJ_FC	0,6	0,7	16IR_28UNJ_FC	0,6	0,7
24	11	1/4				11IR_24UNJ_FC	0,7	0,8
24	16	3/8	16ER_24UNJ_FC	0,7	0,8			
20	11	1/4				11IR_20UNJ_FC	0,8	0,9
20	16	3/8	16ER_20UNJ_FC	0,8	0,9	16IR_20UNJ_FC	0,8	0,9
18	11	1/4				11IR_18UNJ_FC	0,8	1,0
18	16	3/8	16ER_18UNJ_FC	0,8	1,0			
16	11	1/4				11IR_16UNJ_FC	0,9	1,1
16	16	3/8	16ER_16UNJ_FC	0,9	1,1	16IR_16UNJ_FC	0,9	1,1
14	16	3/8	16ER_14UNJ_FC	1,0	1,2	16IR_14UNJ_FC	0,9	1,2
13	16	3/8	16ER_13UNJ_FC	1,0	1,3			
12	16	3/8	16ER_12UNJ_FC	1,1	1,4	16IR_12UNJ_FC	1,1	1,4
11	16	3/8	16ER_11UNJ_FC	1,1	1,5			
10	16	3/8	16ER_10UNJ_FC	1,1	1,5	16IR_10UNJ_FC	1,1	1,5
9	16	3/8	16ER_9UNJ_FC	1,2	1,7	16IR_9UNJ_FC	1,2	1,7
8	16	3/8	16ER_8UNJ_FC	1,2	1,6	16IR_8UNJ_FC	1,1	1,5

THREAD TURNING INSERTS

Kit with Different Inserts



External Thread Turning Inserts

Part Number 10X16ER_FC			Part Number 10X22ER_FC			
1 st. 16ER_0.75ISO_FC	M4,5	MF6-12	1 st. 16ER_2.0ISO_FC	M14-16	MF18-100	
1 st. 16ER_1.0ISO_FC	M6-7	MF8-30	1 st. 16ER_2.5ISO_FC	M18-22		
1 st. 16ER_1.25ISO_FC	M8-9	MF10-12	1 st. 16ER_3.0ISO_FC	M24-27	MF30-100	
1 st. 16ER_1.5ISO_FC	M10-11	MF12-60	1 st. 16ER_AG55_FC	P0,5-3,0		
1 st. 16ER_1.75ISO_FC	M12		1 st. 16ER_AG60_FC	P0,5-3,0		
					2 st. 22ER_3.5ISO_FC	M30-33
					2 st. 22ER_4.0ISO_FC	M36-39 MF42-100
					2 st. 22ER_4.5ISO_FC	M42-45
					2 st. 22ER_5.0ISO_FC	M48-52
					2 st. 22ER_N60_FC	P3,5-5,0

Internal Thread Turning Inserts

Part Number 10X06IR_Ø5_BC		Part Number 10X08IR_Ø7_BC		Part Number 10X11IR_Ø10_FC	
2 st. 06IR_0.5ISO_BC	MF8	2 st. 08IR_1.0ISO_BC	MF10-30	2 st. 11IR_1.0ISO_FC	MF14-30
2 st. 06IR_0.75ISO_BC	MF7-12	2 st. 08IR_1.5ISO_BC	M10-11 MF12-60	2 st. 11IR_1.5ISO_FC	MF14-60
2 st. 06IR_1.0ISO_BC	M7 MF8-30	2 st. 08IR_1.75ISO_BC	M12	2 st. 11IR_2.0ISO_FC	M14-16 MF18-100
2 st. 06IR_1.25ISO_BC	M8-9 MF10-12	2 st. 08IR_28W_BC	G1/8	2 st. 11IR_19W_FC	G1/4-3/8
2 st. 06IR_A60_BC	P0,5-1,25	2 st. 08IR_A60_BC	P0,5-1,5	2 st. 11IR_A60_FC	P0,5-1,5
■ Recommended holder: SIR_0005_H06		■ Recommended holder: SIR_0007_K08		■ Recommended holder: SIR_0010_K11	
Part Number 10X16IR_Ø13_FC		Part Number 10X16IR_Ø20_FC		Part Number 10X22IR_Ø25_FC	
2 st. 16IR_1.5ISO_FC	MF18-60	2 st. 16IR_1.5ISO_FC	MF27-60	2 st. 22IR_3.5ISO_FC	M30-33
2 st. 16IR_2.0ISO_FC	MF18-100	2 st. 16IR_2.0ISO_FC	MF27-100	2 st. 22IR_4.0ISO_FC	M36-39 MF42-100
2 st. 16IR_2.5ISO_FC	M18-22	2 st. 16IR_3.0ISO_FC	M27 MF30-100	2 st. 22IR_4.5ISO_FC	M42-45
2 st. 16IR_3.0ISO_FC	M24-27 MF30-100	2 st. 16IR_11W_FC	G1-6	2 st. 22IR_5.0ISO_FC	M48-52
2 st. 16IR_14W_FC	G1/2-7/8	2 st. 16IR_AG60_FC	P0,5-3,0	2 st. 22IR_N60_FC	P3,5-5,0
■ Recommended holder: SIR_0013_M16		■ Recommended holder: SIR_0020_P16		■ Recommended holder: SIR_0025_R22	

U-TOOLHOLDERS

external



Insert mm	Part Number	B/H mm	L mm	F mm
22	SER_2525_M22U	25	150	28
22	SER_3232_P22U	32	170	32
22	SER_4040_R22U	40	200	40
27	SER_2525_M27U	25	150	32
27	SER_3232_P27U	32	170	32
27	SER_4040_R27U	40	200	40
33	SER_2525_M33U	25	150	32
33	SER_3232_P33U	32	170	32

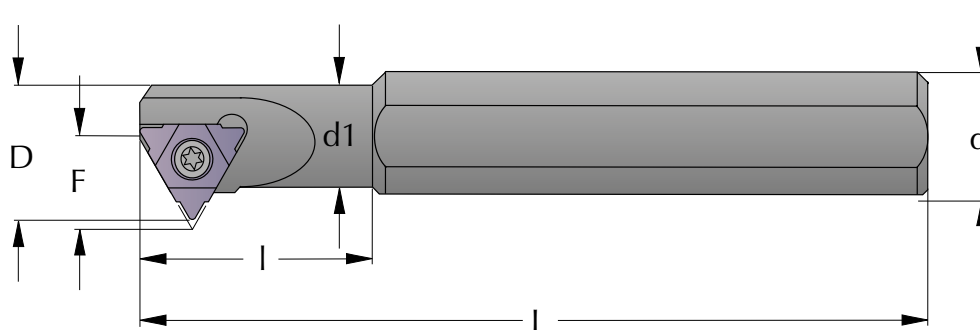
Spare Parts

Insert mm	Screw to insert	Torx key	Screw to anvil	Anvil
22	S22	K22	A22	AE22U...
27	S27	K27	A27	AE27U...
33	S33	K33		

■ The Part Numbers are for Right Hand Toolholders. For Left Hand specify L instead of R. Give Helix Angle for Anvil, ex. AE22U+0.5

U-TOOLHOLDERS

internal



Insert mm	D mm	Part Number	d mm	d1 mm	l mm	L mm	F mm
8	9	SIR_0008_K08U*	16	7,3	21	125	6,6
22	38	SIR_0032_S22U	32	32	-	250	24,4
22	46	SIR_0040_T22U	40	40	-	300	28,1
27	40	SIR_0032_S27U	32	32	-	250	25,8
27	48	SIR_0040_T27U	40	40	-	300	29,4
27	58	SIR_0050_U27U	50	50	-	350	34,3
27	68	SIR_0060_V27U	60	60	-	400	39,7
33	62	SIR_0050_U33U	50	50	-	350	37,5

with Carbide Shank and Internal Coolant

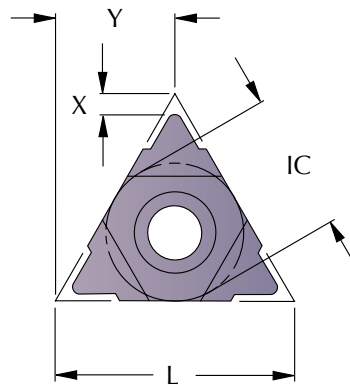
Insert mm	D mm	Part Number	d mm	d1 mm	l mm	L mm	F mm
8	9	SIR_0008_K08UCB*	8	7,3	35	125	6,6

Spare Parts

Insert mm	Screw to insert	Torx key	Screw to anvil	Anvil
08	S8	K8		
22	S22	K22	A22	AI22U...
27	S27	K27	A27	AI27U...
33	S33	K33		

*Toolholder without anvil

U-THREAD TURNING INSERTS



M METRIC

Pitch mm	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
2,0	8	3/16				08UI_2.0ISO_BC	0,9	4,0
5,5	22	1/2	22UE_5.5ISO_FC	2,3	11,0	22UI_5.5ISO_FC	2,4	11,0
6,0	22	1/2	22UE_6.0ISO_FC	2,6	11,0	22UI_6.0ISO_FC	2,1	11,0
8,0	27	5/8	27UE_8.0ISO_FC	2,4	13,7	27UI_8.0ISO_FC	2,4	13,7
12,0	33	3/4	33UE_12.0ISO_FC	2,5	16,5	33UI_12.0ISO_FC	3,5	16,9

UN UNIFIED

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
13	8	3/16				08UI_13UN_BC	1,0	4,0
12	8	3/16				08UI_12UN_BC	0,9	4,0
11	8	3/16				08UI_11UN_BC	0,9	4,0
4,5	22	1/2	22UE_4.5UN_FC	2,0	11,0	22UI_4.5UN_FC	2,4	11,0
4	22	1/2	22UE_4UN_FC	2,0	11,0	22UI_4UN_FC	2,4	11,0
3	27	5/8	27UE_3UN_FC	2,5	13,7	27UI_3UN_FC	2,7	13,7
2	33	3/4	33UE_2UN_FC	2,8	16,5	33UI_2UN_FC	3,6	16,9

TR TRAPEZ DIN 103

Pitch mm	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
2,0	8					08UI_2.0TR_BC	0,9	4,0
6,0	22	1/2	22UE_6.0TR_FC	2,0	11,0	22UI_6.0TR_FC	2,0	11,0
7,0	22	1/2	22UE_7.0TR_FC	2,3	11,0	22UI_7.0TR_FC	2,3	11,0
8,0	22	1/2	22UE_8.0TR_FC	2,5	11,0	22UI_8.0TR_FC	2,5	11,0
8,0	27	5/8	27UE_8.0TR_FC	2,5	13,7	27UI_8.0TR_FC	2,5	13,7
9,0	27	5/8	27UE_9.0TR_FC	3,0	13,7	27UI_9.0TR_FC	3,0	13,7
10,0	27	5/8	27UE_10.0TR_FC*	3,2	13,7	27UI_10.0TR_FC*	3,2	13,7
12,0	33	3/4	33UE_12.0TR_FC	3,9	16,9	33UI_12.0TR_FC	3,9	16,9

*Only one cutting edge

U-THREAD TURNING INSERTS



ACME

ACME

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
14	8	3/16				08UI_14ACME_BC	0,8	4,0
12	8	3/16				08UI_12ACME_BC	0,8	4,0
10	8	3/16				08UI_10ACME_BC	0,8	4,0
4	22	1/2	22UE_4ACME_FC	2,3	11,0	22UI_4ACME_FC	2,3	11,0
3	27	5/8	27UE_3ACME_FC	2,8	13,7	27UI_3ACME_FC	2,8	13,7
2	33	3/4	33UE_2ACME_FC	4,3	16,9	33UI_2ACME_FC	4,3	16,9

STACME

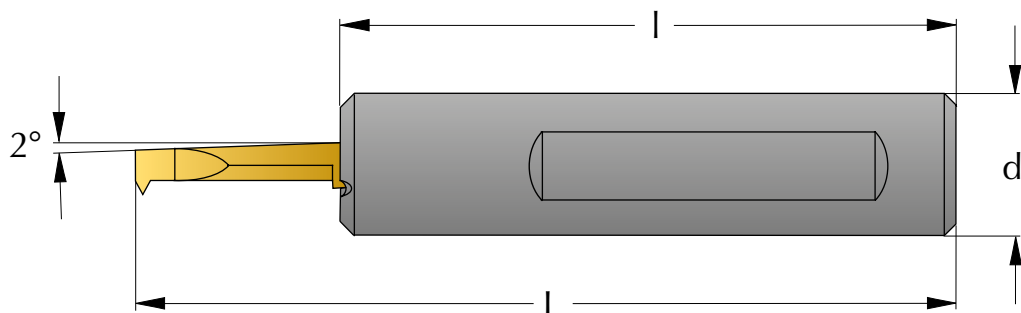
STUB ACME

Pitch TPI	L mm	IC inch	EXTERNAL Part Number	X mm	Y mm	INTERNAL Part Number	X mm	Y mm
14	8	3/16				08UI_14STACME_BC	0,8	4,0
12	8	3/16				08UI_12STACME_BC	0,9	4,0
10	8	3/16				08UI_10STACME_BC	1,0	4,0
4	22	1/2	22UE_4STACME_FC	2,5	11,0	22UI_4STACME_FC	2,5	11,0
3	22	1/2	22UE_3STACME_FC	3,3	11,0	22UI_3STACME_FC	3,3	11,0
2	33	3/4	33UE_2STACME_FC	5,0	16,9	33UI_2STACME_FC	5,0	16,9



THREAD TURNING TOOLHOLDERS

Micro



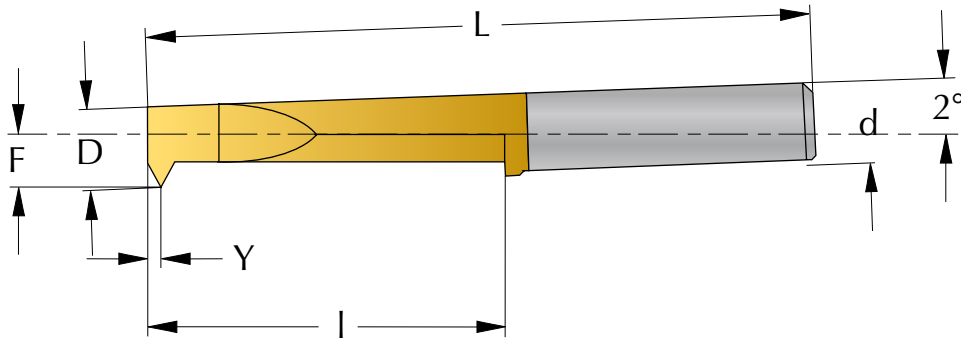
Insert mm	Part Number	d mm	l mm	L mm
3,0	WRC3N_0012E-2	12	70	82
3,0	WRC3N_0016F-2	16	80	92
3,0	WRC3N_0020H-2	20	100	112
3,0	WRC3N_0022J-2	22	110	122
3,0	WRC3N_0025J-2	25	110	122
4,0	WRC4N_0012E-2	12	70	86,5
4,0	WRC4N_0016F-2	16	80	96,5
4,0	WRC4N_0020H-2	20	100	116,5
4,0	WRC4N_0022J-2	22	110	126,5
4,0	WRC4N_0025J-2	25	110	126,5
5,0	WRC5N_0016F-2	16	80	101
5,0	WRC5N_0020H-2	20	100	121
5,0	WRC5N_0022J-2	22	110	131
5,0	WRC5N_0025J-2	25	110	131
6,0	WRC6N_0016F-2	16	80	106
6,0	WRC6N_0020H-2	20	100	126
6,0	WRC6N_0022J-2	22	110	136
6,0	WRC6N_0025J-2	25	110	136
8,0	WRC8N_0020H-2	20	100	145
8,0	WRC8N_0022J-2	22	110	155
8,0	WRC8N_0025J-2	25	110	155

Also available in other types of Toolholder



THREAD TURNING INSERTS

Micro



60°

PARTIAL PROFILE 60°

Pitch mm	TPI	D mm	INTERNAL Part Number	d mm	l mm	L mm	F mm	Y mm
0,2-0,4	80 - 64	0,8	WR308_P60_BC	3	4	24	0,5	0,2
0,2-0,6	80 - 44	1,6	WR316_P60_BC	3	7	24	0,75	0,3
0,2-0,8	80 - 32	2,2	WR322_P60_BC	3	10	24	1,25	0,4
0,2-1,0	80 - 28	3,0	WR330_P60_BC	3	12	24	1,5	0,5
0,25-1,25	80 - 20	4,0	WR440_P60_BC	4	16,5	32	2	0,6
0,25-1,5	80 - 18	5,0	WR550_P60_BC	5	21	40	2,5	0,7
0,25-1,75	80 - 14	6,0	WR660_P60_BC	6	27	48	3	0,8
0,35-2,5	72 - 10	8,0	WR880_P60_BC	8	45	72	4	1,2

55°

PARTIAL PROFILE 55°

Pitch mm	TPI	D mm	INTERNAL Part Number	d mm	l mm	L mm	F mm	Y mm
0,25-1,25	80 - 20	4,0	WR440_P55_BC	4	16,5	32	2	0,6
0,25-1,75	80 - 18	6,0	WR660_P55_BC	6	27	48	3	0,8

Also available for Grooving and Turning

Minimum Bore Diameter

To obtain highest possible stability the threading inserts are ground in an angle of 2°. Therefore the minimum bore diameter is dependent on the thread length according to the table below.

D mm	Thread Length (mm)															
	2	4	6	8	10	12	14	16	18	21	24	27	30	35	40	45
0,8	0,87	0,94														
1,6	1,67	1,74	1,81													
2,2	2,27	2,34	2,41	2,48	2,55											
3,0	3,07	3,14	3,21	3,28	3,35	3,42										
4,0	4,07	4,14	4,21	4,28	4,35	4,42	4,49	4,56								
5,0	5,07	5,14	5,21	5,28	5,35	5,42	5,49	5,56	5,63	5,74						
6,0	6,07	6,14	6,21	6,28	6,35	6,42	6,49	6,56	6,63	6,74	6,84	6,95				
8,0	8,07	8,14	8,21	8,28	8,35	8,42	8,49	8,56	8,63	8,74	8,84	8,95	9,05	9,23	9,40	9,58

Minimum Bore Diameter = D + (thread length x 0,035)