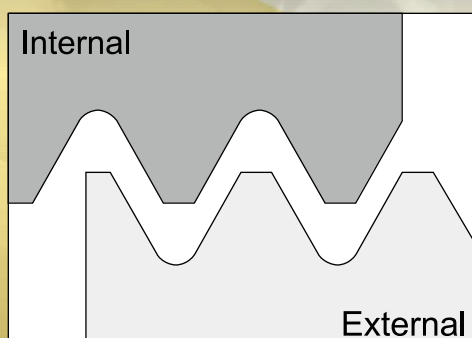
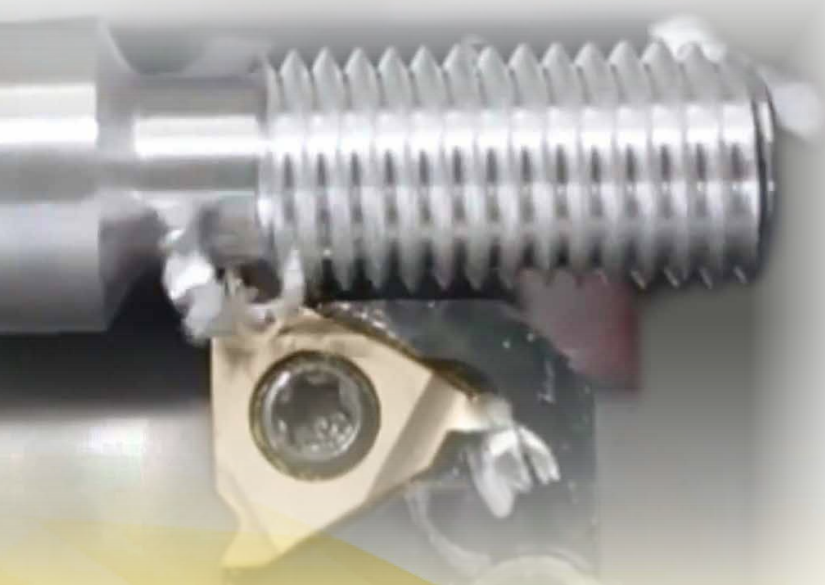


Threading Tools Thread Turning Inserts and Holders

2020.07

- **Positive chipbreaker design provides excellent chip control.**
- **Sharp edge and low cutting forces reduce burr and vibration.**
- **CX1555 and CX1560 grade are available.**
- **Welcome to order other thread types.**



W200706E

Designations For Threading Insert

16
①

I
②

R
③

A
④

60
⑤

① Insert Size

l (mm)	d (inch)
11	1/4
16	3/8

② Application

E	External
I	Internal

③ Hand of Tool

R	Right Hand
L	Left Hand

④ Thread Pitch or TPI

Partial Profile		
	TP (mm)	TPI
A	0.5 ~ 1.5	48 ~ 16
AG	0.5 ~ 3.0	48 ~ 8
G	1.75 ~ 3.0	14 ~ 8

Full Profile		
Value by number		
TP (mm)	TPI	
0.75	34	
⋮	⋮	
3.00	8	

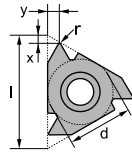
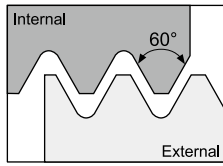
⑤ Thread Standard

Partial Profile	
55°	Partial Profile 55°
60°	Partial Profile 60°

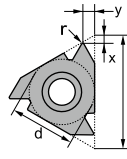
Full Profile	
ISO	ISO Metric 60°
UN	American UN 60°
W	Whitworth 55°

Threading Inserts - Partial Profile 60°

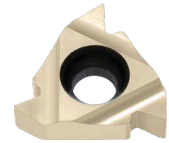
External



Right hand

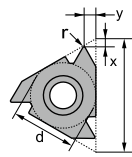
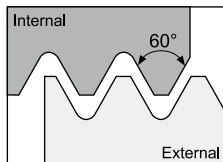


Left hand

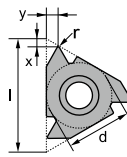


Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I16ERA601555	16ERA60-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ERA601560	16ERA60-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		●	●
I16ELA601555	16ELA60-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ELA601560	16ELA60-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		●	●
I16ERAG601555	16ERAG60-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ERAG601560	16ERAG60-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		●	●
I16ELAG601555	16ELAG60-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ELAG601560	16ELAG60-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		●	●
I16ERG601555	16ERG60-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16ERG601560	16ERG60-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		●	●
I16ELG601555	16ELG60-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16ELG601560	16ELG60-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		●	●

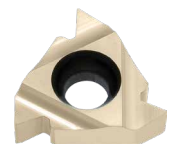
Internal



Right hand



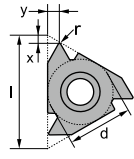
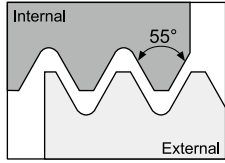
Left hand



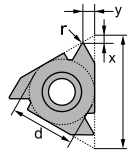
Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I16IRA601555	16IRA60-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16IRA601560	16IRA60-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		●	●
I16ILA601555	16ILA60-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ILA601560	16ILA60-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		●	●
I16IRAG601555	16IRAG60-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16IRAG601560	16IRAG60-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		●	●
I16ILAG601555	16ILAG60-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ILAG601560	16ILAG60-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		●	●
I16IRG601555	16IRG60-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○
I16IRG601560	16IRG60-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		●	●
I16ILG601555	16ILG60-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○
I16ILG601560	16ILG60-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		●	●

Threading Inserts - Partial Profile 55°

External



Right hand

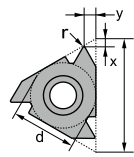
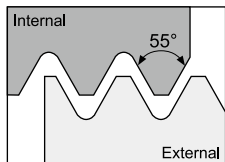


Left hand

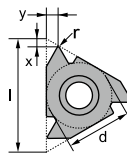


Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I16ERA551555	16ERA55-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ERA551560	16ERA55-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		●	●
I16ELA551555	16ELA55-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ELA551560	16ELA55-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		●	●
I16ERAG551555	16ERAG55-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ERAG551560	16ERAG55-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		●	●
I16ELAG551555	16ELAG55-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ELAG551560	16ELAG55-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		●	●
I16ERG551555	16ERG55-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16ERG551560	16ERG55-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		●	●
I16ELG551555	16ELG55-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16ELG551560	16ELG55-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		●	●

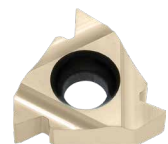
Internal



Right hand



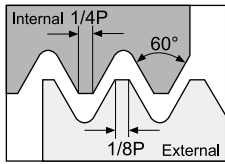
Left hand



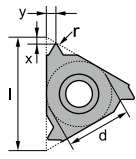
Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I16IRA551555	16IRA55-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16IRA551560	16IRA55-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		●	●
I16ILA551555	16ILA55-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ILA551560	16ILA55-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		●	●
I16IRAG551555	16IRAG55-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16IRAG551560	16IRAG55-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		●	●
I16ILAG551555	16ILAG55-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ILAG551560	16ILAG55-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		●	●
I16IRG551555	16IRG55-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○
I16IRG551560	16IRG55-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		●	●
I16ILG551555	16ILG55-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○
I16ILG551560	16ILG55-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		●	●

Threading Inserts - ISO Metric 60°

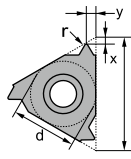
External



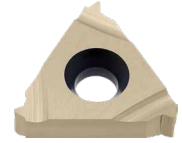
Tolerance Class : 6g/6H



Right hand



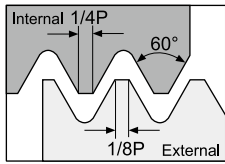
Left hand



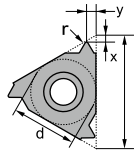
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TP (mm)	d	l	r	x	y	P	M	K	N	S	H
I16ER075ISO1555	16ER0.75ISO-CX1555	0.75	3/8"	16	0.08	0.6	0.6	●	●	●		○	○
I16ER075ISO1560	16ER0.75ISO-CX1560	0.75	3/8"	16	0.08	0.6	0.6	●	●	●		●	●
I16EL075ISO1555	16EL0.75ISO-CX1555	0.75	3/8"	16	0.08	0.6	0.6	●	●	●		○	○
I16EL075ISO1560	16EL0.75ISO-CX1560	0.75	3/8"	16	0.08	0.6	0.6	●	●	●		●	●
I16ER080ISO1555	16ER0.80ISO-CX1555	0.80	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16ER080ISO1560	16ER0.80ISO-CX1560	0.80	3/8"	16	0.09	0.6	0.6	●	●	●		●	●
I16EL080ISO1555	16EL0.80ISO-CX1555	0.80	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16EL080ISO1560	16EL0.80ISO-CX1560	0.80	3/8"	16	0.09	0.6	0.6	●	●	●		●	●
I16ER100ISO1555	16ER1.00ISO-CX1555	1.00	3/8"	16	0.12	0.7	0.7	●	●	●		○	○
I16ER100ISO1560	16ER1.00ISO-CX1560	1.00	3/8"	16	0.12	0.7	0.7	●	●	●		●	●
I16EL100ISO1555	16EL1.00ISO-CX1555	1.00	3/8"	16	0.12	0.7	0.7	●	●	●		○	○
I16EL100ISO1560	16EL1.00ISO-CX1560	1.00	3/8"	16	0.12	0.7	0.7	●	●	●		●	●
I16ER125ISO1555	16ER1.25ISO-CX1555	1.25	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16ER125ISO1560	16ER1.25ISO-CX1560	1.25	3/8"	16	0.15	0.8	0.9	●	●	●		●	●
I16EL125ISO1555	16EL1.25ISO-CX1555	1.25	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16EL125ISO1560	16EL1.25ISO-CX1560	1.25	3/8"	16	0.15	0.8	0.9	●	●	●		●	●
I16ER150ISO1555	16ER1.50ISO-CX1555	1.50	3/8"	16	0.18	0.8	1.0	●	●	●		○	○
I16ER150ISO1560	16ER1.50ISO-CX1560	1.50	3/8"	16	0.18	0.8	1.0	●	●	●		●	●
I16EL150ISO1555	16EL1.50ISO-CX1555	1.50	3/8"	16	0.18	0.8	1.0	●	●	●		○	○
I16EL150ISO1560	16EL1.50ISO-CX1560	1.50	3/8"	16	0.18	0.8	1.0	●	●	●		●	●
I16ER175ISO1555	16ER1.75ISO-CX1555	1.75	3/8"	16	0.21	0.9	1.2	●	●	●		○	○
I16ER175ISO1560	16ER1.75ISO-CX1560	1.75	3/8"	16	0.21	0.9	1.2	●	●	●		●	●
I16EL175ISO1555	16EL1.75ISO-CX1555	1.75	3/8"	16	0.21	0.9	1.2	●	●	●		○	○
I16EL175ISO1560	16EL1.75ISO-CX1560	1.75	3/8"	16	0.21	0.9	1.2	●	●	●		●	●
I16ER200ISO1555	16ER2.00ISO-CX1555	2.00	3/8"	16	0.25	1.0	1.3	●	●	●		○	○
I16ER200ISO1560	16ER2.00ISO-CX1560	2.00	3/8"	16	0.25	1.0	1.3	●	●	●		●	●
I16EL200ISO1555	16EL2.00ISO-CX1555	2.00	3/8"	16	0.25	1.0	1.3	●	●	●		○	○
I16EL200ISO1560	16EL2.00ISO-CX1560	2.00	3/8"	16	0.25	1.0	1.3	●	●	●		●	●
I16ER250ISO1555	16ER2.50ISO-CX1555	2.50	3/8"	16	0.31	1.1	1.5	●	●	●		○	○
I16ER250ISO1560	16ER2.50ISO-CX1560	2.50	3/8"	16	0.31	1.1	1.5	●	●	●		●	●
I16EL250ISO1555	16EL2.50ISO-CX1555	2.50	3/8"	16	0.31	1.1	1.5	●	●	●		○	○
I16EL250ISO1560	16EL2.50ISO-CX1560	2.50	3/8"	16	0.31	1.1	1.5	●	●	●		●	●
I16ER300ISO1555	16ER3.00ISO-CX1555	3.00	3/8"	16	0.38	1.2	1.6	●	●	●		○	○
I16ER300ISO1560	16ER3.00ISO-CX1560	3.00	3/8"	16	0.38	1.2	1.6	●	●	●		●	●
I16EL300ISO1555	16EL3.00ISO-CX1555	3.00	3/8"	16	0.38	1.2	1.6	●	●	●		○	○
I16EL300ISO1560	16EL3.00ISO-CX1560	3.00	3/8"	16	0.38	1.2	1.6	●	●	●		●	●

Threading Inserts - ISO Metric 60°

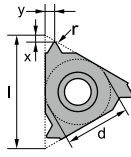
Internal



Tolerance Class : 6g/6H



Right hand



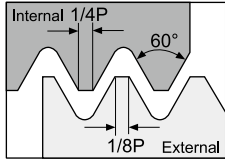
Left hand



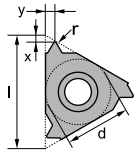
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TP (mm)	d	l	r	x	y	P	M	K	N	S	H
I16IR075ISO1555	16IR0.75ISO-CX1555	0.75	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IR075ISO1560	16IR0.75ISO-CX1560	0.75	3/8"	16	0.04	0.6	0.6	●	●	●		●	●
I16IL075ISO1555	16IL0.75ISO-CX1555	0.75	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IL075ISO1560	16IL0.75ISO-CX1560	0.75	3/8"	16	0.04	0.6	0.6	●	●	●		●	●
I16IR080ISO1555	16IR0.80ISO-CX1555	0.80	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IR080ISO1560	16IR0.80ISO-CX1560	0.80	3/8"	16	0.04	0.6	0.6	●	●	●		●	●
I16IL080ISO1555	16IL0.80ISO-CX1555	0.80	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IL080ISO1560	16IL0.80ISO-CX1560	0.80	3/8"	16	0.04	0.6	0.6	●	●	●		●	●
I16IR100ISO1555	16IR1.00ISO-CX1555	1.00	3/8"	16	0.05	0.6	0.7	●	●	●		○	○
I16IR100ISO1560	16IR1.00ISO-CX1560	1.00	3/8"	16	0.05	0.6	0.7	●	●	●		●	●
I16IL100ISO1555	16IL1.00ISO-CX1555	1.00	3/8"	16	0.05	0.6	0.7	●	●	●		○	○
I16IL100ISO1560	16IL1.00ISO-CX1560	1.00	3/8"	16	0.05	0.6	0.7	●	●	●		●	●
I16IR125ISO1555	16IR1.25ISO-CX1555	1.25	3/8"	16	0.07	0.8	0.9	●	●	●		○	○
I16IR125ISO1560	16IR1.25ISO-CX1560	1.25	3/8"	16	0.07	0.8	0.9	●	●	●		●	●
I16IL125ISO1555	16IL1.25ISO-CX1555	1.25	3/8"	16	0.07	0.8	0.9	●	●	●		○	○
I16IL125ISO1560	16IL1.25ISO-CX1560	1.25	3/8"	16	0.07	0.8	0.9	●	●	●		●	●
I16IR150ISO1555	16IR1.50ISO-CX1555	1.50	3/8"	16	0.10	0.8	1.0	●	●	●		○	○
I16IR150ISO1560	16IR1.50ISO-CX1560	1.50	3/8"	16	0.10	0.8	1.0	●	●	●		●	●
I16IL150ISO1555	16IL1.50ISO-CX1555	1.50	3/8"	16	0.10	0.8	1.0	●	●	●		○	○
I16IL150ISO1560	16IL1.50ISO-CX1560	1.50	3/8"	16	0.10	0.8	1.0	●	●	●		●	●
I16IR175ISO1555	16IR1.75ISO-CX1555	1.75	3/8"	16	0.12	0.9	1.2	●	●	●		○	○
I16IR175ISO1560	16IR1.75ISO-CX1560	1.75	3/8"	16	0.12	0.9	1.2	●	●	●		●	●
I16IL175ISO1555	16IL1.75ISO-CX1555	1.75	3/8"	16	0.12	0.9	1.2	●	●	●		○	○
I16IL175ISO1560	16IL1.75ISO-CX1560	1.75	3/8"	16	0.12	0.9	1.2	●	●	●		●	●
I16IR200ISO1555	16IR2.00ISO-CX1555	2.00	3/8"	16	0.13	1.0	1.3	●	●	●		○	○
I16IR200ISO1560	16IR2.00ISO-CX1560	2.00	3/8"	16	0.13	1.0	1.3	●	●	●		●	●
I16IL200ISO1555	16IL2.00ISO-CX1555	2.00	3/8"	16	0.13	1.0	1.3	●	●	●		○	○
I16IL200ISO1560	16IL2.00ISO-CX1560	2.00	3/8"	16	0.13	1.0	1.3	●	●	●		●	●
I16IR250ISO1555	16IR2.50ISO-CX1555	2.50	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16IR250ISO1560	16IR2.50ISO-CX1560	2.50	3/8"	16	0.15	1.1	1.5	●	●	●		●	●
I16IL250ISO1555	16IL2.50ISO-CX1555	2.50	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16IL250ISO1560	16IL2.50ISO-CX1560	2.50	3/8"	16	0.15	1.1	1.5	●	●	●		●	●
I16IR300ISO1555	16IR3.00ISO-CX1555	3.00	3/8"	16	0.18	1.1	1.5	●	●	●		○	○
I16IR300ISO1560	16IR3.00ISO-CX1560	3.00	3/8"	16	0.18	1.1	1.5	●	●	●		●	●
I16IL300ISO1555	16IL3.00ISO-CX1555	3.00	3/8"	16	0.18	1.1	1.5	●	●	●		○	○
I16IL300ISO1560	16IL3.00ISO-CX1560	3.00	3/8"	16	0.18	1.1	1.5	●	●	●		●	●

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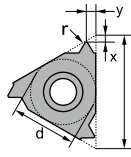
External



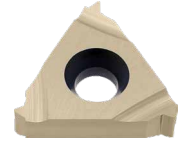
Tolerance Class : 2A/2B



Right hand



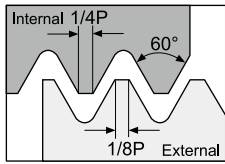
Left hand



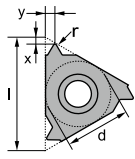
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I16ER40UN1555	16ER40UN-CX1555	40	3/8"	16	0.06	0.6	0.6	●	●	●		○	○
I16ER40UN1560	16ER40UN-CX1560	40	3/8"	16	0.06	0.6	0.6	●	●	●		●	●
I16EL40UN1555	16EL40UN-CX1555	40	3/8"	16	0.06	0.6	0.6	●	●	●		○	○
I16EL40UN1560	16EL40UN-CX1560	40	3/8"	16	0.06	0.6	0.6	●	●	●		●	●
I16ER36UN1555	16ER36UN-CX1555	36	3/8"	16	0.07	0.6	0.6	●	●	●		○	○
I16ER36UN1560	16ER36UN-CX1560	36	3/8"	16	0.07	0.6	0.6	●	●	●		●	●
I16EL36UN1555	16EL36UN-CX1555	36	3/8"	16	0.07	0.6	0.6	●	●	●		○	○
I16EL36UN1560	16EL36UN-CX1560	36	3/8"	16	0.07	0.6	0.6	●	●	●		●	●
I16ER32UN1555	16ER32UN-CX1555	32	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16ER32UN1560	16ER32UN-CX1560	32	3/8"	16	0.09	0.6	0.6	●	●	●		●	●
I16EL32UN1555	16EL32UN-CX1555	32	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16EL32UN1560	16EL32UN-CX1560	32	3/8"	16	0.09	0.6	0.6	●	●	●		●	●
I16ER28UN1555	16ER28UN-CX1555	28	3/8"	16	0.10	0.6	0.7	●	●	●		○	○
I16ER28UN1560	16ER28UN-CX1560	28	3/8"	16	0.10	0.6	0.7	●	●	●		●	●
I16EL28UN1555	16EL28UN-CX1555	28	3/8"	16	0.10	0.6	0.7	●	●	●		○	○
I16EL28UN1560	16EL28UN-CX1560	28	3/8"	16	0.10	0.6	0.7	●	●	●		●	●
I16ER26UN1555	16ER26UN-CX1555	26	3/8"	16	0.11	0.7	0.8	●	●	●		○	○
I16ER26UN1560	16ER26UN-CX1560	26	3/8"	16	0.11	0.7	0.8	●	●	●		●	●
I16EL26UN1555	16EL26UN-CX1555	26	3/8"	16	0.11	0.7	0.8	●	●	●		○	○
I16EL26UN1560	16EL26UN-CX1560	26	3/8"	16	0.11	0.7	0.8	●	●	●		●	●
I16ER24UN1555	16ER24UN-CX1555	24	3/8"	16	0.12	0.7	0.8	●	●	●		○	○
I16ER24UN1560	16ER24UN-CX1560	24	3/8"	16	0.12	0.7	0.8	●	●	●		●	●
I16EL24UN1555	16EL24UN-CX1555	24	3/8"	16	0.12	0.7	0.8	●	●	●		○	○
I16EL24UN1560	16EL24UN-CX1560	24	3/8"	16	0.12	0.7	0.8	●	●	●		●	●
I16ER20UN1555	16ER20UN-CX1555	20	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16ER20UN1560	16ER20UN-CX1560	20	3/8"	16	0.15	0.8	0.9	●	●	●		●	●
I16EL20UN1555	16EL20UN-CX1555	20	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16EL20UN1560	16EL20UN-CX1560	20	3/8"	16	0.15	0.8	0.9	●	●	●		●	●
I16ER18UN1555	16ER18UN-CX1555	18	3/8"	16	0.17	0.8	1.0	●	●	●		○	○
I16ER18UN1560	16ER18UN-CX1560	18	3/8"	16	0.17	0.8	1.0	●	●	●		●	●
I16EL18UN1555	16EL18UN-CX1555	18	3/8"	16	0.17	0.8	1.0	●	●	●		○	○
I16EL18UN1560	16EL18UN-CX1560	18	3/8"	16	0.17	0.8	1.0	●	●	●		●	●
I16ER16UN1555	16ER16UN-CX1555	16	3/8"	16	0.18	0.9	1.1	●	●	●		○	○
I16ER16UN1560	16ER16UN-CX1560	16	3/8"	16	0.18	0.9	1.1	●	●	●		●	●
I16EL16UN1555	16EL16UN-CX1555	16	3/8"	16	0.18	0.9	1.1	●	●	●		○	○
I16EL16UN1560	16EL16UN-CX1560	16	3/8"	16	0.18	0.9	1.1	●	●	●		●	●

Threading Inserts - American UN 60°

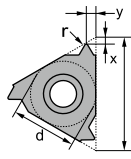
External



Tolerance Class : 2A/2B



Right hand



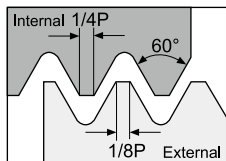
Left hand



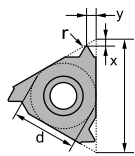
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I16ER14UN1555	16ER14UN-CX1555	14	3/8"	16	0.22	1.0	1.2	●	●	●		○	○
I16ER14UN1560	16ER14UN-CX1560	14	3/8"	16	0.22	1.0	1.2	●	●	●		●	●
I16EL14UN1555	16EL14UN-CX1555	14	3/8"	16	0.22	1.0	1.2	●	●	●		○	○
I16EL14UN1560	16EL14UN-CX1560	14	3/8"	16	0.22	1.0	1.2	●	●	●		●	●
I16ER13UN1555	16ER13UN-CX1555	13	3/8"	16	0.24	1.0	1.3	●	●	●		○	○
I16ER13UN1560	16ER13UN-CX1560	13	3/8"	16	0.24	1.0	1.3	●	●	●		●	●
I16EL13UN1555	16EL13UN-CX1555	13	3/8"	16	0.24	1.0	1.3	●	●	●		○	○
I16EL13UN1560	16EL13UN-CX1560	13	3/8"	16	0.24	1.0	1.3	●	●	●		●	●
I16ER12UN1555	16ER12UN-CX1555	12	3/8"	16	0.26	1.1	1.4	●	●	●		○	○
I16ER12UN1560	16ER12UN-CX1560	12	3/8"	16	0.26	1.1	1.4	●	●	●		●	●
I16EL12UN1555	16EL12UN-CX1555	12	3/8"	16	0.26	1.1	1.4	●	●	●		○	○
I16EL12UN1560	16EL12UN-CX1560	12	3/8"	16	0.26	1.1	1.4	●	●	●		●	●
I16ER11.5UN1555	16ER11.5UN-CX1555	11.5	3/8"	16	0.27	1.1	1.5	●	●	●		○	○
I16ER11.5UN1560	16ER11.5UN-CX1560	11.5	3/8"	16	0.27	1.1	1.5	●	●	●		●	●
I16EL11.5UN1555	16EL11.5UN-CX1555	11.5	3/8"	16	0.27	1.1	1.5	●	●	●		○	○
I16EL11.5UN1560	16EL11.5UN-CX1560	11.5	3/8"	16	0.27	1.1	1.5	●	●	●		●	●
I16ER11UN1555	16ER11UN-CX1555	11	3/8"	16	0.28	1.1	1.5	●	●	●		○	○
I16ER11UN1560	16ER11UN-CX1560	11	3/8"	16	0.28	1.1	1.5	●	●	●		●	●
I16EL11UN1555	16EL11UN-CX1555	11	3/8"	16	0.28	1.1	1.5	●	●	●		○	○
I16EL11UN1560	16EL11UN-CX1560	11	3/8"	16	0.28	1.1	1.5	●	●	●		●	●
I16ER10UN1555	16ER10UN-CX1555	10	3/8"	16	0.32	1.1	1.5	●	●	●		○	○
I16ER10UN1560	16ER10UN-CX1560	10	3/8"	16	0.32	1.1	1.5	●	●	●		●	●
I16EL10UN1555	16EL10UN-CX1555	10	3/8"	16	0.32	1.1	1.5	●	●	●		○	○
I16EL10UN1560	16EL10UN-CX1560	10	3/8"	16	0.32	1.1	1.5	●	●	●		●	●
I16ER9UN1555	16ER9UN-CX1555	9	3/8"	16	0.36	1.2	1.7	●	●	●		○	○
I16ER9UN1560	16ER9UN-CX1560	9	3/8"	16	0.36	1.2	1.7	●	●	●		●	●
I16EL9UN1555	16EL9UN-CX1555	9	3/8"	16	0.36	1.2	1.7	●	●	●		○	○
I16EL9UN1560	16EL9UN-CX1560	9	3/8"	16	0.36	1.2	1.7	●	●	●		●	●
I16ER8UN1555	16ER8UN-CX1555	8	3/8"	16	0.41	1.2	1.6	●	●	●		○	○
I16ER8UN1560	16ER8UN-CX1560	8	3/8"	16	0.41	1.2	1.6	●	●	●		●	●
I16EL8UN1555	16EL8UN-CX1555	8	3/8"	16	0.41	1.2	1.6	●	●	●		○	○
I16EL8UN1560	16EL8UN-CX1560	8	3/8"	16	0.41	1.2	1.6	●	●	●		●	●

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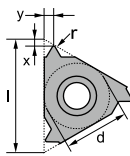
Internal



Tolerance Class : 2A/2B



Right hand



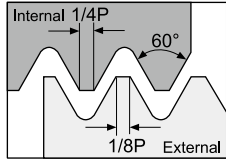
Left hand



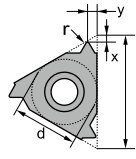
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I16IR40UN1555	16IR40UN-CX1555	40	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16IR40UN1560	16IR40UN-CX1560	40	3/8"	16	0.03	0.6	0.6	●	●	●		●	●
I16IL40UN1555	16IL40UN-CX1555	40	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16IL40UN1560	16IL40UN-CX1560	40	3/8"	16	0.03	0.6	0.6	●	●	●		●	●
I16IR36UN1555	16IR36UN-CX1555	36	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16IR36UN1560	16IR36UN-CX1560	36	3/8"	16	0.03	0.6	0.6	●	●	●		●	●
I16IL36UN1555	16IL36UN-CX1555	36	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16IL36UN1560	16IL36UN-CX1560	36	3/8"	16	0.03	0.6	0.6	●	●	●		●	●
I16IR32UN1555	16IR32UN-CX1555	32	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IR32UN1560	16IR32UN-CX1560	32	3/8"	16	0.04	0.6	0.6	●	●	●		●	●
I16IL32UN1555	16IL32UN-CX1555	32	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IL32UN1560	16IL32UN-CX1560	32	3/8"	16	0.04	0.6	0.6	●	●	●		●	●
I16IR28UN1555	16IR28UN-CX1555	28	3/8"	16	0.04	0.6	0.7	●	●	●		○	○
I16IR28UN1560	16IR28UN-CX1560	28	3/8"	16	0.04	0.6	0.7	●	●	●		●	●
I16IL28UN1555	16IL28UN-CX1555	28	3/8"	16	0.04	0.6	0.7	●	●	●		○	○
I16IL28UN1560	16IL28UN-CX1560	28	3/8"	16	0.04	0.6	0.7	●	●	●		●	●
I16IR26UN1555	16IR26UN-CX1555	26	3/8"	16	0.04	0.7	0.8	●	●	●		○	○
I16IR26UN1560	16IR26UN-CX1560	26	3/8"	16	0.04	0.7	0.8	●	●	●		●	●
I16IL26UN1555	16IL26UN-CX1555	26	3/8"	16	0.04	0.7	0.8	●	●	●		○	○
I16IL26UN1560	16IL26UN-CX1560	26	3/8"	16	0.04	0.7	0.8	●	●	●		●	●
I16IR24UN1555	16IR24UN-CX1555	24	3/8"	16	0.05	0.7	0.8	●	●	●		○	○
I16IR24UN1560	16IR24UN-CX1560	24	3/8"	16	0.05	0.7	0.8	●	●	●		●	●
I16IL24UN1555	16IL24UN-CX1555	24	3/8"	16	0.05	0.7	0.8	●	●	●		○	○
I16IL24UN1560	16IL24UN-CX1560	24	3/8"	16	0.05	0.7	0.8	●	●	●		●	●
I16IR20UN1555	16IR20UN-CX1555	20	3/8"	16	0.06	0.8	0.9	●	●	●		○	○
I16IR20UN1560	16IR20UN-CX1560	20	3/8"	16	0.06	0.8	0.9	●	●	●		●	●
I16IL20UN1555	16IL20UN-CX1555	20	3/8"	16	0.06	0.8	0.9	●	●	●		○	○
I16IL20UN1560	16IL20UN-CX1560	20	3/8"	16	0.06	0.8	0.9	●	●	●		●	●
I16IR18UN1555	16IR18UN-CX1555	18	3/8"	16	0.07	0.8	1.0	●	●	●		○	○
I16IR18UN1560	16IR18UN-CX1560	18	3/8"	16	0.07	0.8	1.0	●	●	●		●	●
I16IL18UN1555	16IL18UN-CX1555	18	3/8"	16	0.07	0.8	1.0	●	●	●		○	○
I16IL18UN1560	16IL18UN-CX1560	18	3/8"	16	0.07	0.8	1.0	●	●	●		●	●
I16IR16UN1555	16IR16UN-CX1555	16	3/8"	16	0.09	0.9	1.1	●	●	●		○	○
I16IR16UN1560	16IR16UN-CX1560	16	3/8"	16	0.09	0.9	1.1	●	●	●		●	●
I16IL16UN1555	16IL16UN-CX1555	16	3/8"	16	0.09	0.9	1.1	●	●	●		○	○
I16IL16UN1560	16IL16UN-CX1560	16	3/8"	16	0.09	0.9	1.1	●	●	●		●	●

Threading Inserts - American UN 60°

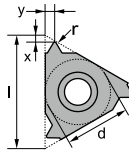
Internal



Tolerance Class : 2A/2B



Right hand

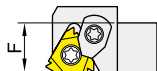
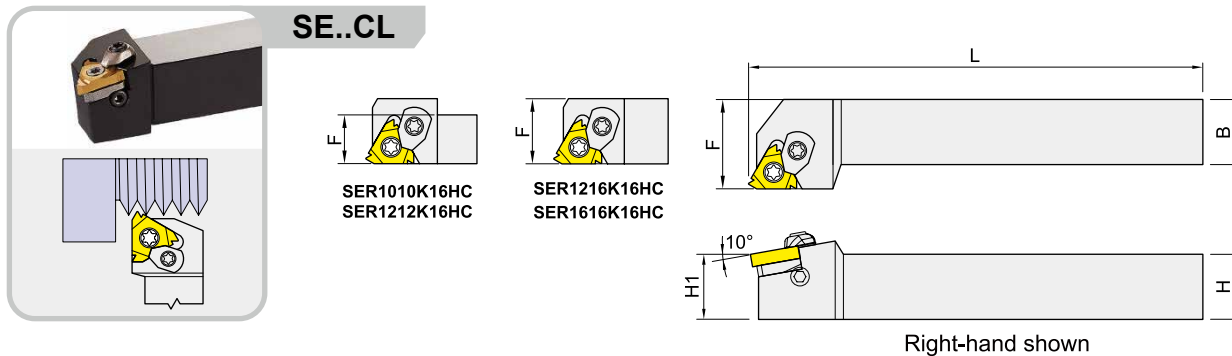


Left hand



Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I16R14UN1555	16R14UN-CX1555	14	3/8"	16	0.10	0.9	1.2	●	●	●		○	○
I16R14UN1560	16R14UN-CX1560	14	3/8"	16	0.10	0.9	1.2	●	●	●		●	●
I16L14UN1555	16L14UN-CX1555	14	3/8"	16	0.10	0.9	1.2	●	●	●		○	○
I16L14UN1560	16L14UN-CX1560	14	3/8"	16	0.10	0.9	1.2	●	●	●		●	●
I16R13UN1555	16R13UN-CX1555	13	3/8"	16	0.11	1.0	1.3	●	●	●		○	○
I16R13UN1560	16R13UN-CX1560	13	3/8"	16	0.11	1.0	1.3	●	●	●		●	●
I16L13UN1555	16L13UN-CX1555	13	3/8"	16	0.11	1.0	1.3	●	●	●		○	○
I16L13UN1560	16L13UN-CX1560	13	3/8"	16	0.11	1.0	1.3	●	●	●		●	●
I16R12UN1555	16R12UN-CX1555	12	3/8"	16	0.12	1.1	1.4	●	●	●		○	○
I16R12UN1560	16R12UN-CX1560	12	3/8"	16	0.12	1.1	1.4	●	●	●		●	●
I16L12UN1555	16L12UN-CX1555	12	3/8"	16	0.12	1.1	1.4	●	●	●		○	○
I16L12UN1560	16L12UN-CX1560	12	3/8"	16	0.12	1.1	1.4	●	●	●		●	●
I16R11.5UN1555	16R11.5UN-CX1555	11.5	3/8"	16	0.13	1.1	1.5	●	●	●		○	○
I16R11.5UN1560	16R11.5UN-CX1560	11.5	3/8"	16	0.13	1.1	1.5	●	●	●		●	●
I16L11.5UN1555	16L11.5UN-CX1555	11.5	3/8"	16	0.13	1.1	1.5	●	●	●		○	○
I16L11.5UN1560	16L11.5UN-CX1560	11.5	3/8"	16	0.13	1.1	1.5	●	●	●		●	●
I16R11UN1555	16R11UN-CX1555	11	3/8"	16	0.14	1.1	1.5	●	●	●		○	○
I16R11UN1560	16R11UN-CX1560	11	3/8"	16	0.14	1.1	1.5	●	●	●		●	●
I16L11UN1555	16L11UN-CX1555	11	3/8"	16	0.14	1.1	1.5	●	●	●		○	○
I16L11UN1560	16L11UN-CX1560	11	3/8"	16	0.14	1.1	1.5	●	●	●		●	●
I16R10UN1555	16R10UN-CX1555	10	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16R10UN1560	16R10UN-CX1560	10	3/8"	16	0.15	1.1	1.5	●	●	●		●	●
I16L10UN1555	16L10UN-CX1555	10	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16L10UN1560	16L10UN-CX1560	10	3/8"	16	0.15	1.1	1.5	●	●	●		●	●
I16R9UN1555	16R9UN-CX1555	9	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16R9UN1560	16R9UN-CX1560	9	3/8"	16	0.17	1.2	1.7	●	●	●		●	●
I16L9UN1555	16L9UN-CX1555	9	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16L9UN1560	16L9UN-CX1560	9	3/8"	16	0.17	1.2	1.7	●	●	●		●	●
I16R8UN1555	16R8UN-CX1555	8	3/8"	16	0.19	1.1	1.5	●	●	●		○	○
I16R8UN1560	16R8UN-CX1560	8	3/8"	16	0.19	1.1	1.5	●	●	●		●	●
I16L8UN1555	16L8UN-CX1555	8	3/8"	16	0.19	1.1	1.5	●	●	●		○	○
I16L8UN1560	16L8UN-CX1560	8	3/8"	16	0.19	1.1	1.5	●	●	●		●	●

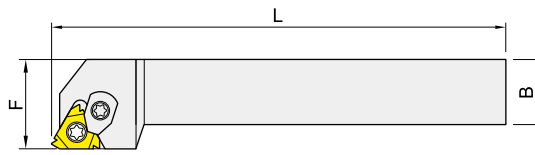
External Threading Tool Holders



SER1010K16HC
SER1212K16HC



SER1216K16HC
SER1616K16HC

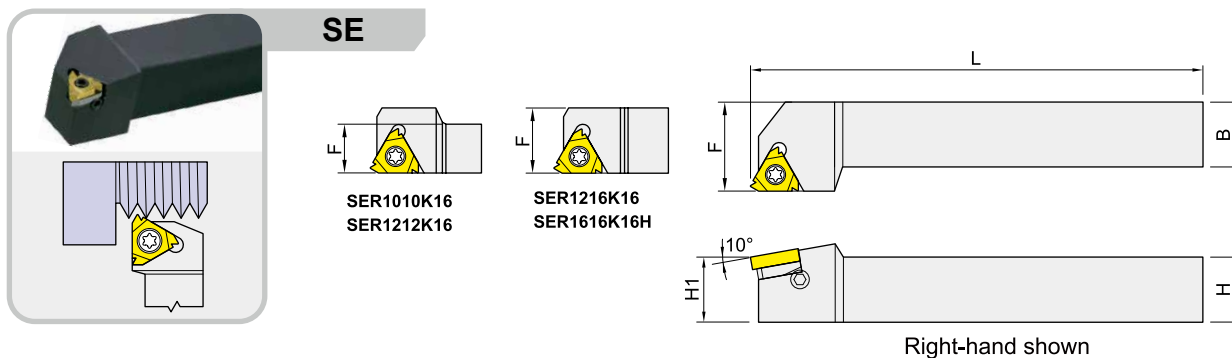


Right-hand shown

Order No.	Dimensions (mm)				Insert	Spare parts
	H(H1)	B	L	F		
ISE ^{R/L} 1010K16HC	10	10	125	10	16IR or 16IL	①
ISE ^{R/L} 1212K16HC	12	12	125	12		
ISE ^{R/L} 1216K16HC	12	16	125	16		
ISE ^{R/L} 1616K16HC	16	16	125	16		
ISE ^{R/L} 1616K16CL	16	16	125	20		②
ISE ^{R/L} 2020K16CL	20	20	125	25		
ISE ^{R/L} 2525M16CL	25	25	150	32		
ISE ^{R/L} 3232P16CL	32	32	170	40		

Spare parts	Screw	Shim	Screw	Wrench	Clamp	Wrench
①	IMS3509A	-	-	-	-	ITK15
②	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	IMC353V	ITK15

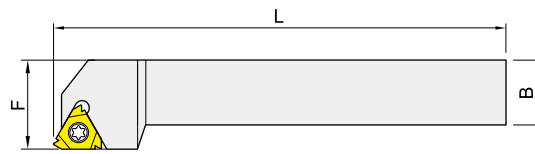
※ SER right hand tools shim is IGXE16, SEL left hand tools shim is IGXN16.



SER1010K16
SER1212K16



SER1216K16
SER1616K16H



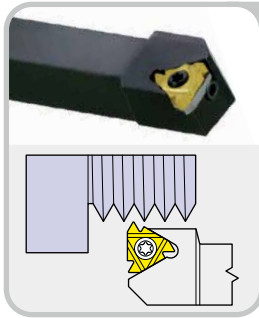
Right-hand shown

Order No.	Dimensions (mm)				Insert	Spare parts
	H(H1)	B	L	F		
ISE ^{R/L} 1216K16	12	16	125	16	16IR or 16IL	①
ISE ^{R/L} 1010K16H	10	10	125	10		
ISE ^{R/L} 1212K16H	12	12	125	12		
ISE ^{R/L} 1616K16H	16	16	125	16		
ISE ^{R/L} 1616K16	16	16	125	20		②
ISE ^{R/L} 2020K16	20	20	125	25		
ISE ^{R/L} 2525M16	25	25	150	32		
ISE ^{R/L} 3232P16	32	32	170	40		

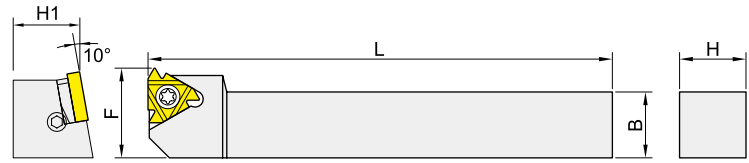
Spare parts	Screw	Shim	Screw	Wrench	Wrench
①	IMS3509A	-	-	-	ITK15
②	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	ITK15

※ SER right hand tools shim is IGXE16, SEL left hand tools shim is IGXN16.

External Threading Tool Holders



SKE



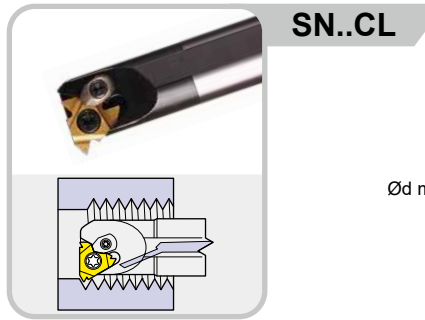
Right-hand shown

Order No.	Dimensions (mm)				Insert	Spare parts
	H(H1)	B	L	F		
ISKE ^{R/L} 1212K16	12	12	125	18	16IR or 16IL	①
ISKE ^{R/L} 1616K16	16	16	125	22		②
ISKE ^{R/L} 2020K16	20	20	125	27		
ISKE ^{R/L} 2525M16	25	25	150	34		

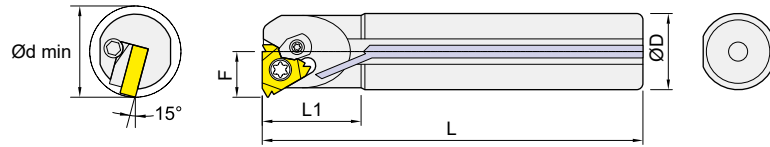
Spare parts	Screw 	Shim 	Screw 	Wrench 	Wrench
①	IMS3509A	-	-	-	ITK15
②	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	ITK15

※ SKER right hand tools shim is IGXE16, SKEL left hand tools shim is IGXN16.

Internal Threading Tool Holders



SN..CL

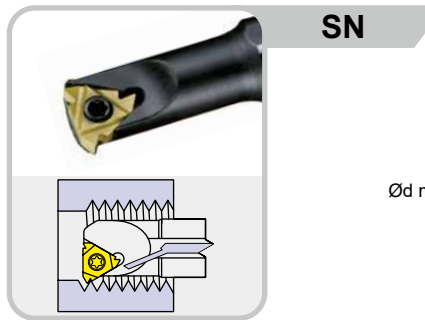


Right-hand shown

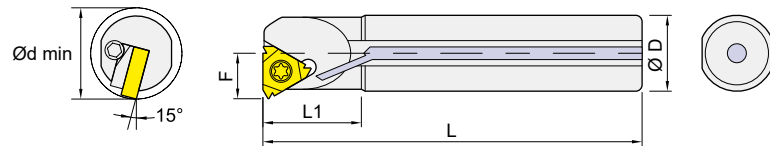
Order No.	Dimensions (mm)					Coolant	Insert	Spare parts
	D	L	L1	F	d min			
ISN ^{R/L} _0020R16CL	20	200	40	12	24		16IR or 16IL	①
ISN ^{R/L} _0025R16CL	25	200	45	14.5	29			
ISN ^{R/L} _0032S16CL	32	250	45	18.5	36			
ISN ^{R/L} _A0020R16CL	20	200	40	12	24	●		
ISN ^{R/L} _A0025R16CL	25	200	45	14.5	29	●		
ISN ^{R/L} _A0032S16CL	32	250	45	18.5	36	●		

Spare parts	Screw	Shim	Screw	Wrench	Clamp	Wrench
①	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	IMC353V	ITK15

※ SNR right hand tools shim is IGXN16, SNL left hand tools shim is IGXE16.



SN



Right-hand shown

Order No.	Dimensions (mm)					Coolant	Insert	Spare parts
	D	L	L1	F	d min			
ISN ^{R/L} _0016Q16	16	180	36	10	19		16IR or 16IL	①
ISN ^{R/L} _0020R16	20	200	40	12	24			②
ISN ^{R/L} _0025R16	25	200	45	14.5	29			①
ISN ^{R/L} _0032S16	32	250	45	18.5	36			②
ISN ^{R/L} _A0016Q16	16	180	36	10	19	●		
ISN ^{R/L} _A0020R16	20	200	40	12	24	●		
ISN ^{R/L} _A0025R16	25	200	45	14.5	29	●		
ISN ^{R/L} _A0032S16	32	250	45	18.5	36	●		

Spare parts	Screw	Wrench	Shim	Screw	Wrench
①	IMS3509A	ITK15	-	-	-
②	IMS3512A	ITK15	IGXN16 or IGXE16	IHTM309	IPL25

※ SNR right hand tools shim is IGXN16, SNL left hand tools shim is IGXE16.

Recommended Cutting Conditions

Working Material	Vc (m/min)
Carbon Steel (HB85-225)	60 -100 -140
Stainless 300 Series	40 - 80 - 120
Cast Iron (HB140-220)	60 - 90 -120
High Temperature Alloy	25 - 45 - 65
Hardened Steel	20 - 40 -60

Depth of Cut And Number of Passes

ISO Metric 60° External

No. of Passes	Pitch (mm)															
	0.5	0.75	0.8	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0
	Radial infeed per pass (mm)															
1	0.102	0.178	0.178	0.178	0.178	0.229	0.229	0.254	0.279	0.279	0.330	0.330	0.381	0.406	0.432	0.457
2	0.102	0.152	0.152	0.178	0.178	0.203	0.203	0.229	0.254	0.254	0.305	0.330	0.330	0.381	0.406	0.432
3	0.076	0.102	0.127	0.127	0.152	0.178	0.152	0.178	0.203	0.203	0.254	0.254	0.279	0.330	0.330	0.356
4	0.076	0.076	0.076	0.102	0.127	0.152	0.152	0.152	0.178	0.178	0.203	0.229	0.229	0.279	0.279	0.305
5	0.356	0.508	0.533	0.076	0.102	0.127	0.127	0.152	0.152	0.152	0.178	0.178	0.229	0.229	0.229	0.279
6				0.660	0.076	0.076	0.102	0.127	0.127	0.152	0.178	0.178	0.203	0.229	0.229	0.229
7					0.813	0.965	0.102	0.102	0.127	0.127	0.152	0.152	0.178	0.203	0.203	0.229
8							0.076	0.076	0.102	0.127	0.152	0.152	0.178	0.178	0.178	0.203
9							1.143	1.270	0.102	0.127	0.152	0.152	0.152	0.178	0.178	0.203
10									0.076	0.102	0.127	0.127	0.152	0.178	0.178	0.178
11									1.600	0.102	0.102	0.127	0.152	0.152	0.152	0.178
12										0.076	0.076	0.127	0.127	0.152	0.152	0.152
13										1.880	2.210	0.102	0.127	0.127	0.127	0.152
14												0.076	0.102	0.102	0.127	0.152
15												2.515	2.819	3.124	0.127	0.127
16															0.102	0.102
															3.429	3.734

Last pass equals total depth of thread.

ISO Metric 60° Internal

No. of Passes	Pitch (mm)															
	0.5	0.75	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0	
	Radial infeed per pass (mm)															
1	0.102	0.178	0.178	0.203	0.254	0.229	0.254	0.279	0.279	0.305	0.330	0.356	0.381	0.381	0.406	
2	0.102	0.127	0.152	0.178	0.203	0.203	0.229	0.229	0.279	0.279	0.305	0.330	0.356	0.356	0.406	
3	0.076	0.102	0.102	0.127	0.152	0.152	0.178	0.178	0.203	0.229	0.229	0.279	0.305	0.305	0.356	
4	0.076	0.076	0.102	0.102	0.102	0.127	0.152	0.152	0.152	0.203	0.203	0.229	0.254	0.254	0.279	
5	0.356	0.483	0.076	0.102	0.102	0.102	0.127	0.152	0.152	0.178	0.178	0.203	0.229	0.229	0.229	
6			0.610	0.076	0.076	0.102	0.102	0.127	0.152	0.152	0.152	0.178	0.203	0.203	0.229	
7				0.787	0.889	0.102	0.102	0.102	0.127	0.152	0.152	0.152	0.178	0.178	0.203	
8						0.076	0.076	0.102	0.102	0.152	0.152	0.152	0.152	0.178	0.178	
9						1.092	1.219	0.102	0.102	0.127	0.127	0.152	0.152	0.152	0.178	
10								0.076	0.102	0.102	0.127	0.152	0.152	0.152	0.152	
11									1.499	0.102	0.102	0.102	0.127	0.152	0.152	
12										0.076	0.076	0.102	0.127	0.152	0.152	
13										1.778	2.057	0.102	0.102	0.127	0.152	
14												0.076	0.102	0.102	0.127	
15												2.337	2.642	2.896	0.127	
16															0.102	
															3.200	3.454

Last pass equals total depth of thread.

Depth of Cut And Number of Passes

Unified(UN) 60° External

No. of Passes	TPI												
	32	28	24	20	18	16	14	13	12	11	10	9	8
	Radial infeed per pass (mm)												
1	0.178	0.178	0.178	0.203	0.229	0.229	0.229	0.254	0.279	0.279	0.279	0.279	0.305
2	0.152	0.152	0.178	0.178	0.203	0.203	0.229	0.229	0.229	0.254	0.229	0.229	0.254
3	0.127	0.127	0.152	0.152	0.152	0.152	0.178	0.178	0.203	0.203	0.203	0.203	0.229
4	0.076	0.102	0.127	0.127	0.152	0.152	0.152	0.152	0.152	0.178	0.178	0.178	0.178
5	0.533	0.076	0.076	0.102	0.127	0.127	0.127	0.152	0.152	0.152	0.152	0.152	0.178
6		0.635	0.711	0.076	0.076	0.102	0.102	0.127	0.152	0.152	0.152	0.152	0.152
7				0.838	0.940	0.076	0.102	0.102	0.127	0.127	0.152	0.152	0.152
8						1.041	0.076	0.076	0.076	0.102	0.127	0.127	0.152
9							1.194	1.270	1.372	0.076	0.102	0.127	0.127
10										1.499	0.076	0.102	0.127
11											1.651	0.076	0.102
12												1.778	0.076
13													2.032

Last pass equals total depth of thread.

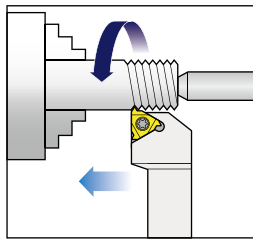
Unified(UN) 60° Internal

No. of Passes	TPI												
	32	28	24	20	18	16	14	13	12	11	10	9	8
	Radial infeed per pass (mm)												
1	0.178	0.178	0.178	0.203	0.229	0.229	0.229	0.254	0.279	0.279	0.279	0.279	0.305
2	0.152	0.152	0.152	0.178	0.178	0.178	0.203	0.229	0.229	0.229	0.229	0.229	0.279
3	0.102	0.102	0.152	0.127	0.152	0.152	0.152	0.152	0.178	0.178	0.152	0.178	0.203
4	0.076	0.102	0.102	0.102	0.127	0.127	0.152	0.152	0.152	0.152	0.152	0.152	0.178
5	0.508	0.076	0.076	0.102	0.102	0.102	0.102	0.127	0.127	0.152	0.152	0.152	0.152
6		0.610	0.660	0.076	0.076	0.102	0.102	0.102	0.102	0.127	0.127	0.152	0.152
7				0.787	0.864	0.076	0.102	0.102	0.102	0.102	0.102	0.127	0.127
8						0.940	0.076	0.076	0.076	0.102	0.102	0.102	0.102
9							1.118	1.194	1.245	0.076	0.102	0.102	0.102
10										1.397	0.076	0.102	0.102
11											1.499	0.076	0.102
12												1.651	0.076
13													1.880

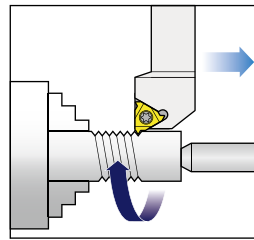
Last pass equals total depth of thread.

Thread Methods

External Right Hand Thread

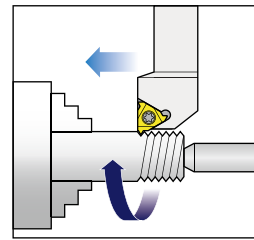


Spindle : Clockwise
Tool : right hand

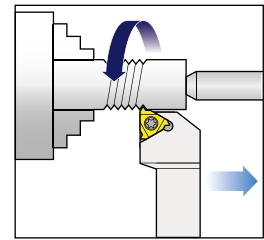


Spindle : Counterclockwise
Tool : left hand

External Left Hand Thread

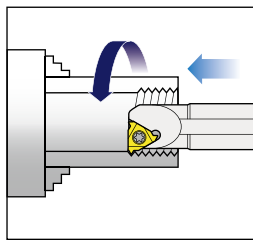


Spindle : Counterclockwise
Tool : left hand

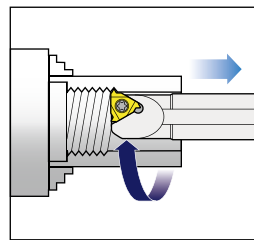


Spindle : Clockwise
Tool : right hand

Internal Right Hand Thread

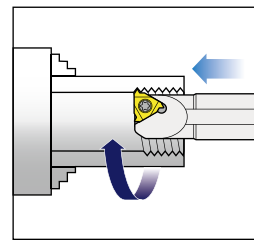


Spindle : Clockwise
Tool : right hand

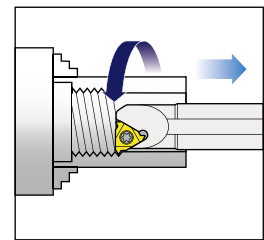


Spindle : Counterclockwise
Tool : left hand

Internal Left Hand Thread



Spindle : Counterclockwise
Tool : left hand



Spindle : Clockwise
Tool : right hand

Infeed Methods

Infeed Methods	Features
<p>Radial Infeed</p>	<ul style="list-style-type: none"> • For pitches of less than 1.5mm or 16 T.P.I. • Most commonly used method on manual lathes. • Equal wear on leading and trailing edge. • Good surface finish on trailing edge. • Use on work hardening materials. • Use on short chipping materials.
<p>Modified Flank Infeed</p>	<ul style="list-style-type: none"> • For threads greater than 1.5mm or 16 T.P.I. • Reduced cutting pressure on larger pitches. • Reduced chatter. • Directs chip away from the cutting edge. • Displaced in-feed angle improves surface finish. • First choice for internal threading.
<p>Alternating Flank Infeed</p>	<ul style="list-style-type: none"> • Recommended for large pitches. • Recommended for long chipping materials. • Method divides the work between both flanks. • Results in equal wear. • Less cutting pressure. • Not available on all lathes.