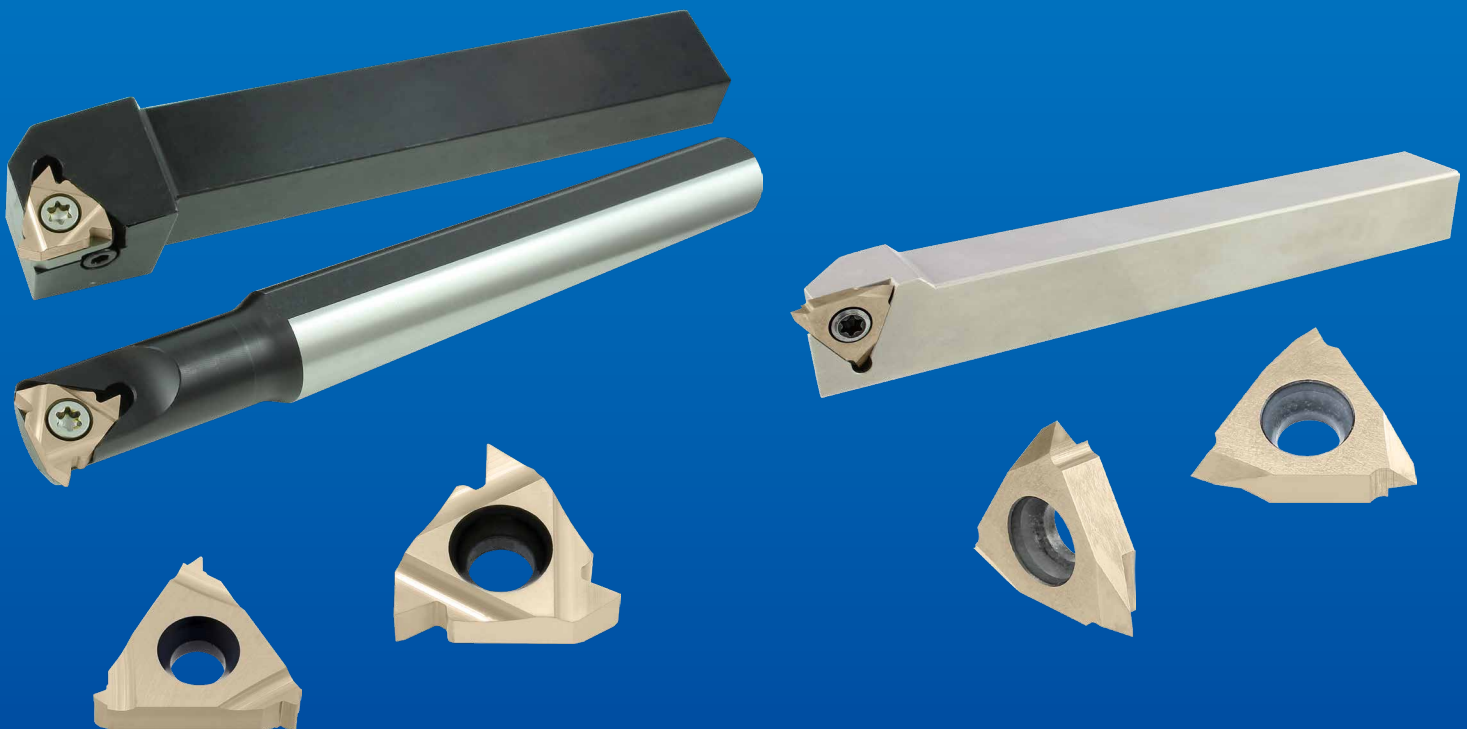


## *Thread Turning Inserts and Holders*

- We offer inserts in two types : laydown and vertical.
- Positive chipbreaker design provides excellent chip control.
- Sharp edge and low cutting forces reduce burr and vibration.
- Welcome to order other thread types.



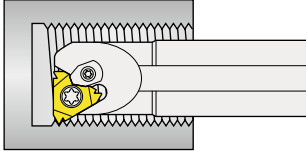
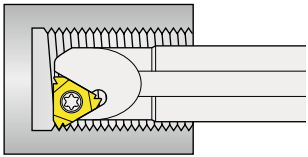
Thread Turning Insert Index

Thread Turning Insert

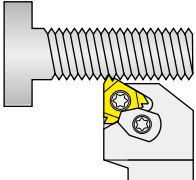
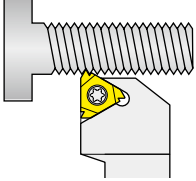
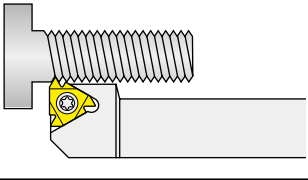
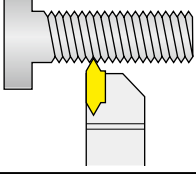
Insert Sharp	Thread Standard	Insert Code	Thread Pitch	Applicable Holder	Page												
	Partial Profile 60°	11E <sup>R</sup> / <sub>L</sub> ...60 11I <sup>R</sup> / <sub>L</sub> ...60 16E <sup>R</sup> / <sub>L</sub> ...60 16I <sup>R</sup> / <sub>L</sub> ...60	<table border="1"> <thead> <tr> <th></th> <th>TP (mm)</th> <th>TPI</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>0.5 ~ 1.5</td> <td>48 ~ 16</td> </tr> <tr> <td>AG</td> <td>0.5 ~ 3.0</td> <td>48 ~ 8</td> </tr> <tr> <td>G</td> <td>1.75 ~ 3.0</td> <td>14 ~ 8</td> </tr> </tbody> </table>		TP (mm)	TPI	A	0.5 ~ 1.5	48 ~ 16	AG	0.5 ~ 3.0	48 ~ 8	G	1.75 ~ 3.0	14 ~ 8	SN <sup>R</sup> / <sub>L</sub> ...CL SN <sup>R</sup> / <sub>L</sub> ... SE <sup>R</sup> / <sub>L</sub> ...CL SE <sup>R</sup> / <sub>L</sub> ... SKE <sup>R</sup> / <sub>L</sub> ...	05
		TP (mm)	TPI														
A	0.5 ~ 1.5	48 ~ 16															
AG	0.5 ~ 3.0	48 ~ 8															
G	1.75 ~ 3.0	14 ~ 8															
	16VE <sup>R</sup> / <sub>L</sub> ...60	<table border="1"> <thead> <tr> <th></th> <th>TP (mm)</th> <th>TPI</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>0.5 ~ 1.5</td> <td>48 ~ 16</td> </tr> <tr> <td>AG</td> <td>0.5 ~ 2.5</td> <td>48 ~ 10</td> </tr> <tr> <td>G</td> <td>1.75 ~ 2.5</td> <td>14 ~ 10</td> </tr> </tbody> </table>		TP (mm)	TPI	A	0.5 ~ 1.5	48 ~ 16	AG	0.5 ~ 2.5	48 ~ 10	G	1.75 ~ 2.5	14 ~ 10	KTTX <sup>R</sup> / <sub>L</sub> ...	06	
	TP (mm)	TPI															
A	0.5 ~ 1.5	48 ~ 16															
AG	0.5 ~ 2.5	48 ~ 10															
G	1.75 ~ 2.5	14 ~ 10															
	Partial Profile 55°	11E <sup>R</sup> / <sub>L</sub> ...55 11I <sup>R</sup> / <sub>L</sub> ...55 16E <sup>R</sup> / <sub>L</sub> ...55 16I <sup>R</sup> / <sub>L</sub> ...55	<table border="1"> <thead> <tr> <th></th> <th>TP (mm)</th> <th>TPI</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>0.5 ~ 1.5</td> <td>48 ~ 16</td> </tr> <tr> <td>AG</td> <td>0.5 ~ 3.0</td> <td>48 ~ 8</td> </tr> <tr> <td>G</td> <td>1.75 ~ 3.0</td> <td>14 ~ 8</td> </tr> </tbody> </table>		TP (mm)	TPI	A	0.5 ~ 1.5	48 ~ 16	AG	0.5 ~ 3.0	48 ~ 8	G	1.75 ~ 3.0	14 ~ 8	SN <sup>R</sup> / <sub>L</sub> ...CL SN <sup>R</sup> / <sub>L</sub> ... SE <sup>R</sup> / <sub>L</sub> ...CL SE <sup>R</sup> / <sub>L</sub> ... SKE <sup>R</sup> / <sub>L</sub> ...	07
		TP (mm)	TPI														
A	0.5 ~ 1.5	48 ~ 16															
AG	0.5 ~ 3.0	48 ~ 8															
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	TP (mm)	TPI															
A	0.5 ~ 1.5	48 ~ 16															
AG	0.5 ~ 2.5	48 ~ 10															
G	1.75 ~ 2.5	14 ~ 10															
	ISO 60°	11I <sup>R</sup> / <sub>L</sub> ...ISO 16E <sup>R</sup> / <sub>L</sub> ...ISO 16I <sup>R</sup> / <sub>L</sub> ...ISO	<table border="1"> <thead> <tr> <th>TP (mm)</th> </tr> </thead> <tbody> <tr> <td>0.35 ~ 3.0</td> </tr> </tbody> </table>	TP (mm)	0.35 ~ 3.0	SN <sup>R</sup> / <sub>L</sub> ...CL SN <sup>R</sup> / <sub>L</sub> ... SE <sup>R</sup> / <sub>L</sub> ...CL SE <sup>R</sup> / <sub>L</sub> ... SKE <sup>R</sup> / <sub>L</sub> ...	09										
TP (mm)																	
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	16VE <sup>R</sup> / <sub>L</sub> ...ISO	<table border="1"> <thead> <tr> <th>TP (mm)</th> </tr> </thead> <tbody> <tr> <td>0.5 ~ 2.5</td> </tr> </tbody> </table>	TP (mm)	0.5 ~ 2.5	KTTX <sup>R</sup> / <sub>L</sub> ...	11											
TP (mm)																	
0.5 ~ 2.5																	
	UN 60°	11ER...UN 11IR...UN 16ER...UN 16IR...UN	<table border="1"> <thead> <tr> <th>TPI</th> </tr> </thead> <tbody> <tr> <td>32 ~ 8</td> </tr> </tbody> </table>	TPI	32 ~ 8	SN <sup>R</sup> / <sub>L</sub> ...CL SN <sup>R</sup> / <sub>L</sub> ... SE <sup>R</sup> / <sub>L</sub> ...CL SE <sup>R</sup> / <sub>L</sub> ... SKE <sup>R</sup> / <sub>L</sub> ...	12										
TPI																	
32 ~ 8																	
	16VE <sup>R</sup> / <sub>L</sub> ...UN	<table border="1"> <thead> <tr> <th>TPI</th> </tr> </thead> <tbody> <tr> <td>32 ~ 10</td> </tr> </tbody> </table>	TPI	32 ~ 10	KTTX <sup>R</sup> / <sub>L</sub> ...	16											
TPI																	
32 ~ 10																	

**Thread Turning Holder Index**

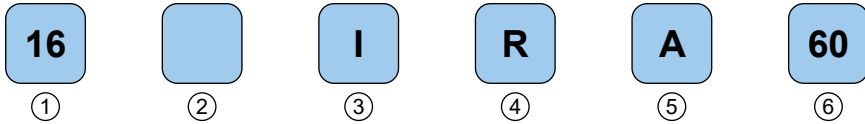
**Internal Thread Turning Holder**

Holder Sharp	Holder Code	Applicable Insert	Min. Bore Dia.	Page
	SN <sup>R</sup> / <sub>L</sub> ...CL	16IR / 16IL	24mm~36mm	17
	SN <sup>R</sup> / <sub>L</sub> ...	16IR / 16IL	13mm~36mm	17

**External Thread Turning Holder**

Holder Sharp	Holder Code	Applicable Insert	Shank Height	Page
	SE <sup>R</sup> / <sub>L</sub> ...CL	16ER / 16EL	10mm~32mm	18
	SE <sup>R</sup> / <sub>L</sub> ...	16ER / 16EL	12mm~32mm	18
	SKE <sup>R</sup> / <sub>L</sub> ...	16ER / 16EL	12mm~25mm	19
	KTTX <sup>R</sup> / <sub>L</sub> ...	16VER / 16VEL	10mm~25mm	20

Designations for Threading Insert



① Insert Size

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

② Insert Style

<b>V</b>	Vertical
----------	----------

③ Application

<b>E</b>	External
<b>I</b>	Internal

④ Hand of Tool

<b>R</b>	Right Hand
<b>L</b>	Left Hand

⑤ Thread Pitch or TPI

**Partial Profile**

	TP (mm)	TPI
<b>A</b>	0.5 ~ 1.5	48 ~ 16
<b>AG</b>	0.5 ~ 3.0	48 ~ 8
<b>G</b>	1.75 ~ 3.0	14 ~ 8

**Full Profile**  
Value by number

TP (mm)	TPI
0.75	34
⋮	⋮
3.00	8

⑥ Thread Standard

**Partial Profile**

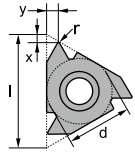
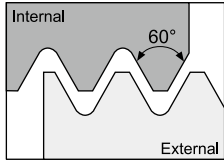
<b>55°</b>	Partial Profile 55°
<b>60°</b>	Partial Profile 60°

**Full Profile**

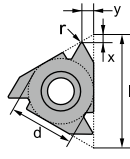
<b>ISO</b>	ISO Metric 60°
<b>UN</b>	American UN 60°
<b>W</b>	Whitworth 55°

Threading Inserts - Partial Profile 60°

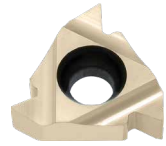
External



Right hand

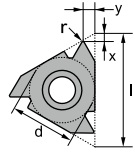
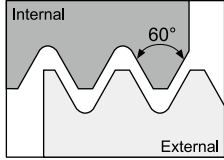


Left hand

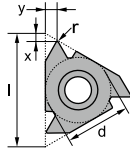


Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I11ERA606025	11ERA60-CP6025	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I11ELA606025	11ELA60-CP6025	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I16ERA606025	16ERA60-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ELA606025	16ELA60-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ERAG606025	16ERAG60-CP6025	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ELAG606025	16ELAG60-CP6025	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ERG606025	16ERG60-CP6025	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16ELG606025	16ELG60-CP6025	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○

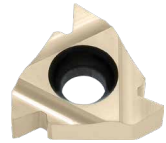
Internal



Right hand



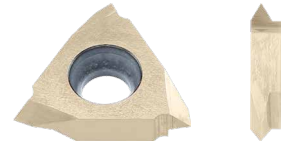
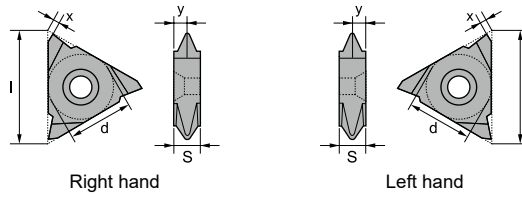
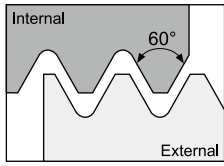
Left hand



Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I11IRA606025	11IRA60-CP6025	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I11ILA606025	11ILA60-CP6025	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I16IRA606025	16IRA60-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ILA606025	16ILA60-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16IRAG606025	16IRAG60-CP6025	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ILAG606025	16ILAG60-CP6025	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16IRG606025	16IRG60-CP6025	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○
I16ILG606025	16ILG60-CP6025	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○

Threading Inserts - Partial Profile 60° Vertical

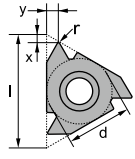
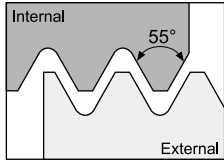
External



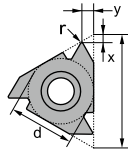
Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	x	y	s	P	M	K	N	S	H
I16VERA606025	16VERA60-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VELA606025	16VELA60-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VERAG606025	16VERAG60-CP6025	0.5 ~ 2.5	48 ~ 10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○
I16VELAG606025	16VELAG60-CP6025	0.5 ~ 2.5	48 ~ 10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○
I16VERG606025	16VERG60-CP6025	1.75 ~ 2.5	14 ~ 10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○
I16VELG606025	16VELG60-CP6025	1.75 ~ 2.5	14 ~ 10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○

Threading Inserts - Partial Profile 55°

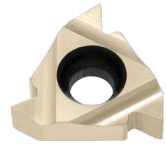
External



Right hand

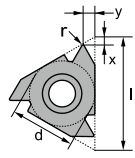
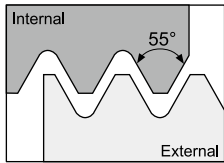


Left hand

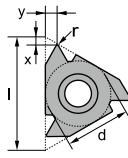


Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I11ERA556025	11ERA55-CP6025	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I11ELA556025	11ELA55-CP6025	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I16ERA556025	16ERA55-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ELA556025	16ELA55-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ERAG556025	16ERAG55-CP6025	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ELAG556025	16ELAG55-CP6025	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ERG556025	16ERG55-CP6025	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16ELG556025	16ELG55-CP6025	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○

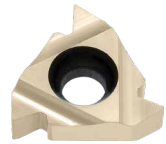
Internal



Right hand



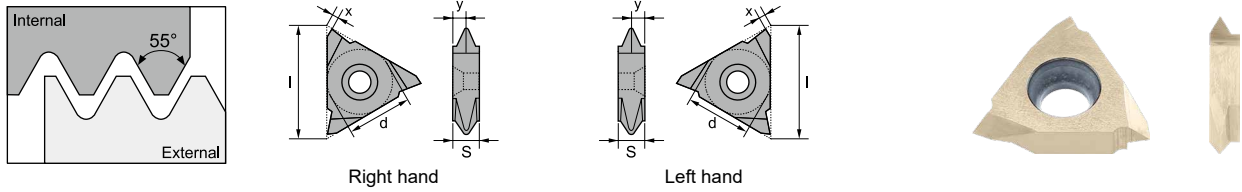
Left hand



Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I11IRA556025	11IRA55-CP6025	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I11ILA556025	11ILA55-CP6025	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I16IRA556025	16IRA55-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ILA556025	16ILA55-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16IRAG556025	16IRAG55-CP6025	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ILAG556025	16ILAG55-CP6025	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16IRG556025	16IRG55-CP6025	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○
I16ILG556025	16ILG55-CP6025	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○

**Threading Inserts - Partial Profile 55° Vertical**

**External**

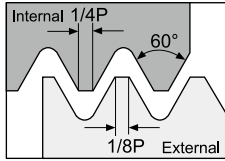


Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	x	y	S	P	M	K	N	S	H
I16VERA556025	16VERA55-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VELA556025	16VELA55-CP6025	0.5 ~ 1.5	48 ~ 16	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VERAG556025	16VERAG55-CP6025	0.5 ~ 2.5	48 ~ 10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○
I16VELAG556025	16VELAG55-CP6025	0.5 ~ 2.5	48 ~ 10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○
I16VERG556025	16VERG55-CP6025	1.75 ~ 2.5	14 ~ 10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○
I16VELG556025	16VELG55-CP6025	1.75 ~ 2.5	14 ~ 10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○

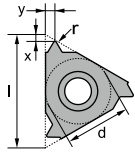


Threading Inserts - ISO Metric 60°

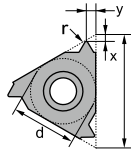
External



Tolerance Class : 6g/6H



Right hand



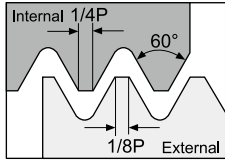
Left hand



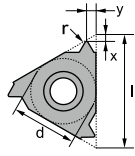
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TP (mm)	d	l	r	x	y	P	M	K	N	S	H
I16ER035ISO6025	16ER0.35ISO-CP6025	0.35	3/8"	16	0.04	0.8	0.4	●	●	●		○	○
I16EL035ISO6025	16EL0.35ISO-CP6025	0.35	3/8"	16	0.04	0.8	0.4	●	●	●		○	○
I16ER040ISO6025	16ER0.40ISO-CP6025	0.40	3/8"	16	0.04	0.7	0.4	●	●	●		○	○
I16ER045ISO6025	16ER0.45ISO-CP6025	0.45	3/8"	16	0.05	0.7	0.4	●	●	●		○	○
I16ER050ISO6025	16ER0.50ISO-CP6025	0.50	3/8"	16	0.05	0.6	0.6	●	●	●		○	○
I16EL050ISO6025	16EL0.50ISO-CP6025	0.50	3/8"	16	0.05	0.6	0.6	●	●	●		○	○
I16ER060ISO6025	16ER0.60ISO-CP6025	0.60	3/8"	16	0.07	0.6	0.6	●	●	●		○	○
I16ER070ISO6025	16ER0.70ISO-CP6025	0.70	3/8"	16	0.07	0.6	0.6	●	●	●		○	○
I16ER075ISO6025	16ER0.75ISO-CP6025	0.75	3/8"	16	0.08	0.6	0.6	●	●	●		○	○
I16EL075ISO6025	16EL0.75ISO-CP6025	0.75	3/8"	16	0.08	0.6	0.6	●	●	●		○	○
I16ER080ISO6025	16ER0.80ISO-CP6025	0.80	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16EL080ISO6025	16EL0.80ISO-CP6025	0.80	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16ER100ISO6025	16ER1.00ISO-CP6025	1.00	3/8"	16	0.12	0.7	0.7	●	●	●		○	○
I16EL100ISO6025	16EL1.00ISO-CP6025	1.00	3/8"	16	0.12	0.7	0.7	●	●	●		○	○
I16ER125ISO6025	16ER1.25ISO-CP6025	1.25	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16EL125ISO6025	16EL1.25ISO-CP6025	1.25	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16ER150ISO6025	16ER1.50ISO-CP6025	1.50	3/8"	16	0.18	0.8	1.0	●	●	●		○	○
I16EL150ISO6025	16EL1.50ISO-CP6025	1.50	3/8"	16	0.18	0.8	1.0	●	●	●		○	○
I16ER175ISO6025	16ER1.75ISO-CP6025	1.75	3/8"	16	0.21	0.9	1.2	●	●	●		○	○
I16EL175ISO6025	16EL1.75ISO-CP6025	1.75	3/8"	16	0.21	0.9	1.2	●	●	●		○	○
I16ER200ISO6025	16ER2.00ISO-CP6025	2.00	3/8"	16	0.25	1.0	1.3	●	●	●		○	○
I16EL200ISO6025	16EL2.00ISO-CP6025	2.00	3/8"	16	0.25	1.0	1.3	●	●	●		○	○
I16ER250ISO6025	16ER2.50ISO-CP6025	2.50	3/8"	16	0.31	1.1	1.5	●	●	●		○	○
I16EL250ISO6025	16EL2.50ISO-CP6025	2.50	3/8"	16	0.31	1.1	1.5	●	●	●		○	○
I16ER300ISO6025	16ER3.00ISO-CP6025	3.00	3/8"	16	0.38	1.2	1.6	●	●	●		○	○
I16EL300ISO6025	16EL3.00ISO-CP6025	3.00	3/8"	16	0.38	1.2	1.6	●	●	●		○	○

Threading Inserts - ISO Metric 60°

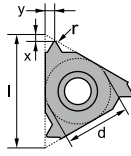
Internal



Tolerance Class : 6g/6H



Right hand



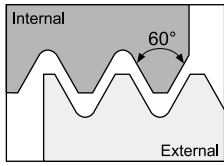
Left hand



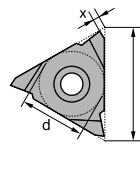
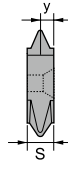
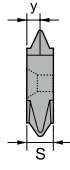
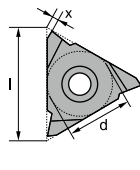
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TP (mm)	d	l	r	x	y	P	M	K	N	S	H
I11R035ISO6025	11R0.35ISO-CP6025	0.35	1/4"	11	0.02	0.8	0.3	●	●	●		○	○
I11L035ISO6025	11L0.35ISO-CP6025	0.35	1/4"	11	0.02	0.8	0.3	●	●	●		○	○
I11R040ISO6025	11R0.40ISO-CP6025	0.40	1/4"	11	0.02	0.8	0.4	●	●	●		○	○
I11R050ISO6025	11R0.50ISO-CP6025	0.50	1/4"	11	0.03	0.6	0.6	●	●	●		○	○
I11L050ISO6025	11L0.50ISO-CP6025	0.50	1/4"	11	0.03	0.6	0.6	●	●	●		○	○
I11R070ISO6025	11R0.70ISO-CP6025	0.70	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11R075ISO6025	11R0.75ISO-CP6025	0.75	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11L075ISO6025	11L0.75ISO-CP6025	0.75	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11R080ISO6025	11R0.80ISO-CP6025	0.80	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11R100ISO6025	11R1.00ISO-CP6025	1.00	1/4"	11	0.05	0.6	0.7	●	●	●		○	○
I11L100ISO6025	11L1.00ISO-CP6025	1.00	1/4"	11	0.05	0.6	0.7	●	●	●		○	○
I11R125ISO6025	11R1.25ISO-CP6025	1.25	1/4"	11	0.07	0.8	0.8	●	●	●		○	○
I11L125ISO6025	11L1.25ISO-CP6025	1.25	1/4"	11	0.07	0.8	0.8	●	●	●		○	○
I11R150ISO6025	11R1.50ISO-CP6025	1.50	1/4"	11	0.08	0.8	1.0	●	●	●		○	○
I11L150ISO6025	11L1.50ISO-CP6025	1.50	1/4"	11	0.08	0.8	1.0	●	●	●		○	○
I16R075ISO6025	16R0.75ISO-CP6025	0.75	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16L075ISO6025	16L0.75ISO-CP6025	0.75	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16R080ISO6025	16R0.80ISO-CP6025	0.80	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16L080ISO6025	16L0.80ISO-CP6025	0.80	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16R100ISO6025	16R1.00ISO-CP6025	1.00	3/8"	16	0.05	0.6	0.7	●	●	●		○	○
I16L100ISO6025	16L1.00ISO-CP6025	1.00	3/8"	16	0.05	0.6	0.7	●	●	●		○	○
I16R125ISO6025	16R1.25ISO-CP6025	1.25	3/8"	16	0.07	0.8	0.9	●	●	●		○	○
I16L125ISO6025	16L1.25ISO-CP6025	1.25	3/8"	16	0.07	0.8	0.9	●	●	●		○	○
I16R150ISO6025	16R1.50ISO-CP6025	1.50	3/8"	16	0.10	0.8	1.0	●	●	●		○	○
I16L150ISO6025	16L1.50ISO-CP6025	1.50	3/8"	16	0.10	0.8	1.0	●	●	●		○	○
I16R175ISO6025	16R1.75ISO-CP6025	1.75	3/8"	16	0.12	0.9	1.2	●	●	●		○	○
I16L175ISO6025	16L1.75ISO-CP6025	1.75	3/8"	16	0.12	0.9	1.2	●	●	●		○	○
I16R200ISO6025	16R2.00ISO-CP6025	2.00	3/8"	16	0.13	1.0	1.3	●	●	●		○	○
I16L200ISO6025	16L2.00ISO-CP6025	2.00	3/8"	16	0.13	1.0	1.3	●	●	●		○	○
I16R250ISO6025	16R2.50ISO-CP6025	2.50	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16L250ISO6025	16L2.50ISO-CP6025	2.50	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16R300ISO6025	16R3.00ISO-CP6025	3.00	3/8"	16	0.18	1.1	1.5	●	●	●		○	○
I16L300ISO6025	16L3.00ISO-CP6025	3.00	3/8"	16	0.18	1.1	1.5	●	●	●		○	○

Threading Inserts - ISO Metric 60° Vertical

External



Tolerance Class : 6g/6H



Right hand

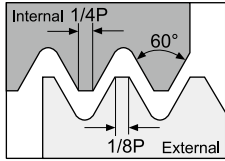
Left hand



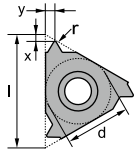
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TP (mm)	d	l	x	y	s	P	M	K	N	S	H
I16VER050ISO6025	16VER0.50ISO-CP6025	0.50	3/8"	16	1.0	0.6	3.18	●	●	●		○	○
I16VEL050ISO6025	16VEL0.50ISO-CP6025	0.50	3/8"	16	1.0	0.6	3.18	●	●	●		○	○
I16VER075ISO6025	16VER0.75ISO-CP6025	0.75	3/8"	16	1.0	0.6	3.18	●	●	●		○	○
I16VEL075ISO6025	16VEL0.75ISO-CP6025	0.75	3/8"	16	1.0	0.6	3.18	●	●	●		○	○
I16VER080ISO6025	16VER0.80ISO-CP6025	0.80	3/8"	16	1.0	0.6	3.18	●	●	●		○	○
I16VEL080ISO6025	16VEL0.80ISO-CP6025	0.80	3/8"	16	1.0	0.6	3.18	●	●	●		○	○
I16VER100ISO6025	16VER1.00ISO-CP6025	1.00	3/8"	16	1.0	0.7	3.18	●	●	●		○	○
I16VEL100ISO6025	16VEL1.00ISO-CP6025	1.00	3/8"	16	1.0	0.7	3.18	●	●	●		○	○
I16VER125ISO6025	16VER1.25ISO-CP6025	1.25	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VEL125ISO6025	16VEL1.25ISO-CP6025	1.25	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VER150ISO6025	16VER1.50ISO-CP6025	1.50	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VEL150ISO6025	16VEL1.50ISO-CP6025	1.50	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VER175ISO6025	16VER1.75ISO-CP6025	1.75	3/8"	16	1.0	1.2	3.18	●	●	●		○	○
I16VEL175ISO6025	16VEL1.75ISO-CP6025	1.75	3/8"	16	1.0	1.2	3.18	●	●	●		○	○
I16VER200ISO6025	16VER2.00ISO-CP6025	2.00	3/8"	16	1.0	1.3	3.18	●	●	●		○	○
I16VEL200ISO6025	16VEL2.00ISO-CP6025	2.00	3/8"	16	1.0	1.3	3.18	●	●	●		○	○
I16VER250ISO6025	16VER2.50ISO-CP6025	2.50	3/8"	16	1.0	1.5	3.18	●	●	●		○	○
I16VEL250ISO6025	16VEL2.50ISO-CP6025	2.50	3/8"	16	1.0	1.5	3.18	●	●	●		○	○

Threading Inserts - American UN 60°

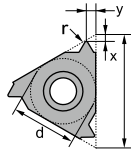
External



Tolerance Class : 2A/2B



Right hand



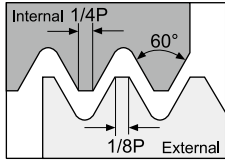
Left hand



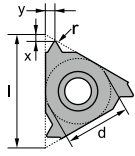
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I11ER32UN6025	11ER32UN-CP6025	32	1/4"	11	0.09	0.6	0.6	●	●	●		○	○
I11ER28UN6025	11ER28UN-CP6025	28	1/4"	11	0.10	0.6	0.7	●	●	●		○	○
I11EL28UN6025	11EL28UN-CP6025	28	1/4"	11	0.10	0.6	0.7	●	●	●		○	○
I11ER18UN6025	11ER18UN-CP6025	18	1/4"	11	0.17	0.8	1.0	●	●	●		○	○
I11ER16UN6025	11ER16UN-CP6025	16	1/4"	11	0.18	0.9	1.1	●	●	●		○	○
I16ER40UN6025	16ER40UN-CP6025	40	3/8"	16	0.06	0.6	0.6	●	●	●		○	○
I16EL40UN6025	16EL40UN-CP6025	40	3/8"	16	0.06	0.6	0.6	●	●	●		○	○
I16ER36UN6025	16ER36UN-CP6025	36	3/8"	16	0.07	0.6	0.6	●	●	●		○	○
I16EL36UN6025	16EL36UN-CP6025	36	3/8"	16	0.07	0.6	0.6	●	●	●		○	○
I16ER32UN6025	16ER32UN-CP6025	32	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16EL32UN6025	16EL32UN-CP6025	32	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16ER28UN6025	16ER28UN-CP6025	28	3/8"	16	0.10	0.6	0.7	●	●	●		○	○
I16EL28UN6025	16EL28UN-CP6025	28	3/8"	16	0.10	0.6	0.7	●	●	●		○	○
I16ER26UN6025	16ER26UN-CP6025	26	3/8"	16	0.11	0.7	0.8	●	●	●		○	○
I16EL26UN6025	16EL26UN-CP6025	26	3/8"	16	0.11	0.7	0.8	●	●	●		○	○
I16ER24UN6025	16ER24UN-CP6025	24	3/8"	16	0.12	0.7	0.8	●	●	●		○	○
I16EL24UN6025	16EL24UN-CP6025	24	3/8"	16	0.12	0.7	0.8	●	●	●		○	○
I16ER20UN6025	16ER20UN-CP6025	20	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16EL20UN6025	16EL20UN-CP6025	20	3/8"	16	0.15	0.8	0.9	●	●	●		○	○

Threading Inserts - American UN 60°

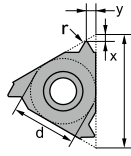
External



Tolerance Class : 2A/2B



Right hand



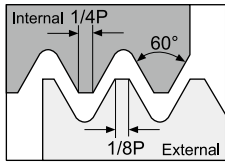
Left hand



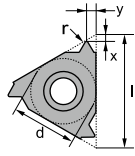
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I16ER18UN6025	16ER18UN-CP6025	18	3/8"	16	0.17	0.8	1.0	●	●	●		○	○
I16EL18UN6025	16EL18UN-CP6025	18	3/8"	16	0.17	0.8	1.0	●	●	●		○	○
I16ER16UN6025	16ER16UN-CP6025	16	3/8"	16	0.18	0.9	1.1	●	●	●		○	○
I16EL16UN6025	16EL16UN-CP6025	16	3/8"	16	0.18	0.9	1.1	●	●	●		○	○
I16ER14UN6025	16ER14UN-CP6025	14	3/8"	16	0.22	1.0	1.2	●	●	●		○	○
I16EL14UN6025	16EL14UN-CP6025	14	3/8"	16	0.22	1.0	1.2	●	●	●		○	○
I16ER13UN6025	16ER13UN-CP6025	13	3/8"	16	0.24	1.0	1.3	●	●	●		○	○
I16EL13UN6025	16EL13UN-CP6025	13	3/8"	16	0.24	1.0	1.3	●	●	●		○	○
I16ER12UN6025	16ER12UN-CP6025	12	3/8"	16	0.26	1.1	1.4	●	●	●		○	○
I16EL12UN6025	16EL12UN-CP6025	12	3/8"	16	0.26	1.1	1.4	●	●	●		○	○
I16ER11.5UN6025	16ER11.5UN-CP6025	11.5	3/8"	16	0.27	1.1	1.5	●	●	●		○	○
I16EL11.5UN6025	16EL11.5UN-CP6025	11.5	3/8"	16	0.27	1.1	1.5	●	●	●		○	○
I16ER11UN6025	16ER11UN-CP6025	11	3/8"	16	0.28	1.1	1.5	●	●	●		○	○
I16EL11UN6025	16EL11UN-CP6025	11	3/8"	16	0.28	1.1	1.5	●	●	●		○	○
I16ER10UN6025	16ER10UN-CP6025	10	3/8"	16	0.32	1.1	1.5	●	●	●		○	○
I16EL10UN6025	16EL10UN-CP6025	10	3/8"	16	0.32	1.1	1.5	●	●	●		○	○
I16ER9UN6025	16ER9UN-CP6025	9	3/8"	16	0.36	1.2	1.7	●	●	●		○	○
I16EL9UN6025	16EL9UN-CP6025	9	3/8"	16	0.36	1.2	1.7	●	●	●		○	○
I16ER8UN6025	16ER8UN-CP6025	8	3/8"	16	0.41	1.2	1.6	●	●	●		○	○
I16EL8UN6025	16EL8UN-CP6025	8	3/8"	16	0.41	1.2	1.6	●	●	●		○	○

Threading Inserts - American UN 60°

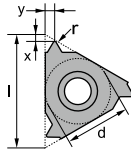
Internal



Tolerance Class : 2A/2B



Right hand



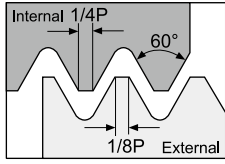
Left hand



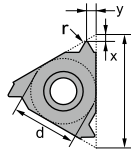
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I11R32UN6025	11R32UN-CP6025	32	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11L32UN6025	11L32UN-CP6025	32	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11R28UN6025	11R28UN-CP6025	28	1/4"	11	0.04	0.6	0.7	●	●	●		○	○
I11L28UN6025	11L28UN-CP6025	28	1/4"	11	0.04	0.6	0.7	●	●	●		○	○
I11R24UN6025	11R24UN-CP6025	24	1/4"	11	0.05	0.7	0.8	●	●	●		○	○
I11L24UN6025	11L24UN-CP6025	24	1/4"	11	0.05	0.7	0.8	●	●	●		○	○
I11R20UN6025	11R20UN-CP6025	20	1/4"	11	0.06	0.8	0.9	●	●	●		○	○
I11L20UN6025	11L20UN-CP6025	20	1/4"	11	0.06	0.8	0.9	●	●	●		○	○
I11R18UN6025	11R18UN-CP6025	18	1/4"	11	0.07	0.8	1.0	●	●	●		○	○
I11L18UN6025	11L18UN-CP6025	18	1/4"	11	0.07	0.8	1.0	●	●	●		○	○
I11R16UN6025	11R16UN-CP6025	16	1/4"	11	0.09	0.9	1.1	●	●	●		○	○
I11L16UN6025	11L16UN-CP6025	16	1/4"	11	0.09	0.9	1.1	●	●	●		○	○
I16R40UN6025	16R40UN-CP6025	40	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16L40UN6025	16L40UN-CP6025	40	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16R36UN6025	16R36UN-CP6025	36	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16L36UN6025	16L36UN-CP6025	36	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16R32UN6025	16R32UN-CP6025	32	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16L32UN6025	16L32UN-CP6025	32	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16R28UN6025	16R28UN-CP6025	28	3/8"	16	0.04	0.6	0.7	●	●	●		○	○
I16L28UN6025	16L28UN-CP6025	28	3/8"	16	0.04	0.6	0.7	●	●	●		○	○
I16R26UN6025	16R26UN-CP6025	26	3/8"	16	0.04	0.7	0.8	●	●	●		○	○
I16L26UN6025	16L26UN-CP6025	26	3/8"	16	0.04	0.7	0.8	●	●	●		○	○
I16R24UN6025	16R24UN-CP6025	24	3/8"	16	0.05	0.7	0.8	●	●	●		○	○
I16L24UN6025	16L24UN-CP6025	24	3/8"	16	0.05	0.7	0.8	●	●	●		○	○
I16R20UN6025	16R20UN-CP6025	20	3/8"	16	0.06	0.8	0.9	●	●	●		○	○
I16L20UN6025	16L20UN-CP6025	20	3/8"	16	0.06	0.8	0.9	●	●	●		○	○

Threading Inserts - American UN 60°

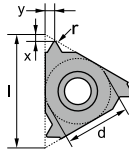
Internal



Tolerance Class : 2A/2B



Right hand



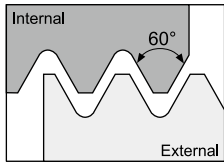
Left hand



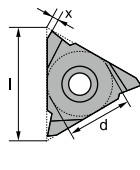
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I16IR18UN6025	16IR18UN-CP6025	18	3/8"	16	0.07	0.8	1.0	●	●	●		○	○
I16IL18UN6025	16IL18UN-CP6025	18	3/8"	16	0.07	0.8	1.0	●	●	●		○	○
I16IR16UN6025	16IR16UN-CP6025	16	3/8"	16	0.09	0.9	1.1	●	●	●		○	○
I16IL16UN6025	16IL16UN-CP6025	16	3/8"	16	0.09	0.9	1.1	●	●	●		○	○
I16IR14UN6025	16IR14UN-CP6025	14	3/8"	16	0.10	0.9	1.2	●	●	●		○	○
I16IL14UN6025	16IL14UN-CP6025	14	3/8"	16	0.10	0.9	1.2	●	●	●		○	○
I16IR13UN6025	16IR13UN-CP6025	13	3/8"	16	0.11	1.0	1.3	●	●	●		○	○
I16IL13UN6025	16IL13UN-CP6025	13	3/8"	16	0.11	1.0	1.3	●	●	●		○	○
I16IR12UN6025	16IR12UN-CP6025	12	3/8"	16	0.12	1.1	1.4	●	●	●		○	○
I16IL12UN6025	16IL12UN-CP6025	12	3/8"	16	0.12	1.1	1.4	●	●	●		○	○
I16IR11.5UN6025	16IR11.5UN-CP6025	11.5	3/8"	16	0.13	1.1	1.5	●	●	●		○	○
I16IL11.5UN6025	16IL11.5UN-CP6025	11.5	3/8"	16	0.13	1.1	1.5	●	●	●		○	○
I16IR11UN6025	16IR11UN-CP6025	11	3/8"	16	0.14	1.1	1.5	●	●	●		○	○
I16IL11UN6025	16IL11UN-CP6025	11	3/8"	16	0.14	1.1	1.5	●	●	●		○	○
I16IR10UN6025	16IR10UN-CP6025	10	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16IL10UN6025	16IL10UN-CP6025	10	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16IR9UN6025	16IR9UN-CP6025	9	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16IL9UN6025	16IL9UN-CP6025	9	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16IR8UN6025	16IR8UN-CP6025	8	3/8"	16	0.19	1.1	1.5	●	●	●		○	○
I16IL8UN6025	16IL8UN-CP6025	8	3/8"	16	0.19	1.1	1.5	●	●	●		○	○

Threading Inserts - American UN 60° Vertical

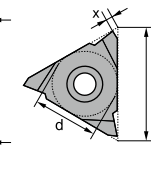
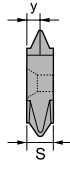
External



Tolerance Class : 6g/6H



Right hand



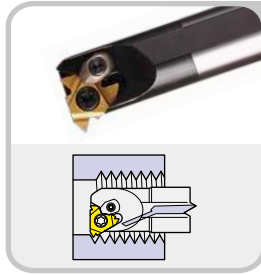
Left hand



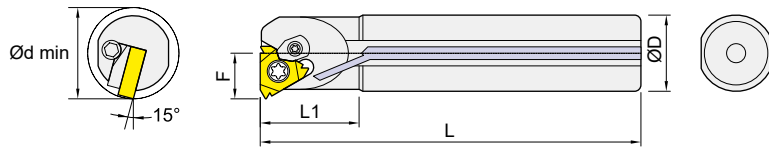
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	x	y	s	P	M	K	N	S	H
I16VER32UN6025	16VER32UN-CP6025	32	3/8"	16	1.0	0.6	3.18	●	●	●		○	○
I16VEL32UN6025	16VEL32UN-CP6025	32	3/8"	16	1.0	0.6	3.18	●	●	●		○	○
I16VER28UN6025	16VER28UN-CP6025	28	3/8"	16	1.0	0.7	3.18	●	●	●		○	○
I16VEL28UN6025	16VEL28UN-CP6025	28	3/8"	16	1.0	0.7	3.18	●	●	●		○	○
I16VER24UN6025	16VER24UN-CP6025	24	3/8"	16	1.0	0.8	3.18	●	●	●		○	○
I16VEL24UN6025	16VEL24UN-CP6025	24	3/8"	16	1.0	0.8	3.18	●	●	●		○	○
I16VER20UN6025	16VER20UN-CP6025	20	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VEL20UN6025	16VEL20UN-CP6025	20	3/8"	16	1.0	0.9	3.18	●	●	●		○	○
I16VER18UN6025	16VER18UN-CP6025	18	3/8"	16	1.0	1.0	3.18	●	●	●		○	○
I16VEL18UN6025	16VEL18UN-CP6025	18	3/8"	16	1.0	1.0	3.18	●	●	●		○	○
I16VER16UN6025	16VER16UN-CP6025	16	3/8"	16	1.0	1.1	3.18	●	●	●		○	○
I16VEL16UN6025	16VEL16UN-CP6025	16	3/8"	16	1.0	1.1	3.18	●	●	●		○	○
I16VER14UN6025	16VER14UN-CP6025	14	3/8"	16	1.0	1.2	3.18	●	●	●		○	○
I16VEL14UN6025	16VEL14UN-CP6025	14	3/8"	16	1.0	1.2	3.18	●	●	●		○	○
I16VER12UN6025	16VER12UN-CP6025	12	3/8"	16	1.0	1.4	3.18	●	●	●		○	○
I16VEL12UN6025	16VEL12UN-CP6025	12	3/8"	16	1.0	1.4	3.18	●	●	●		○	○
I16VER10UN6025	16VER10UN-CP6025	10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○
I16VEL10UN6025	16VEL10UN-CP6025	10	3/8"	16	1.0	1.5	3.18	●	●	●		○	○



Internal Threading Tool Holders

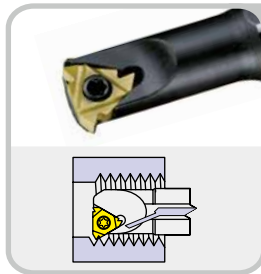


SN..CL

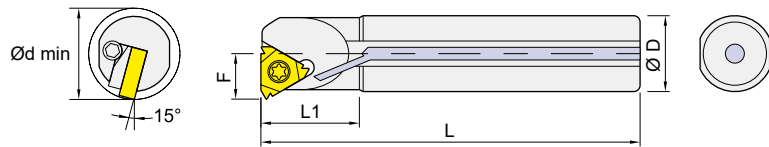


Right-hand shown

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



SN



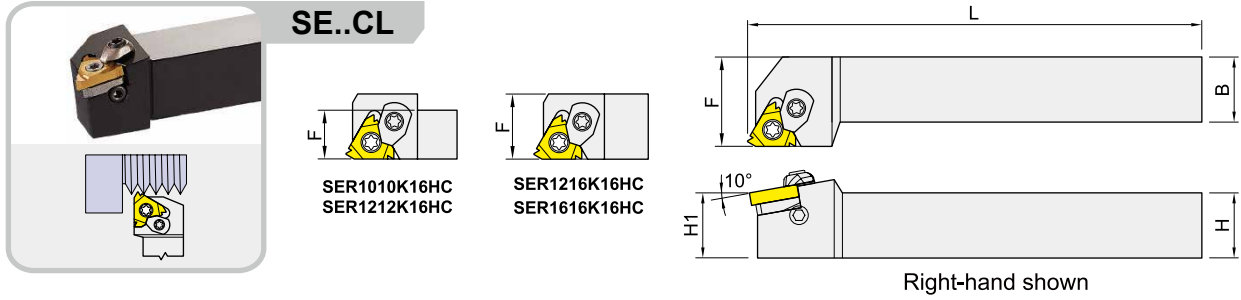
Right-hand shown

Order No.	Dimensions (mm)					Coolant	Insert	Spare parts
	D	L	L1	F	d min			
ISN <sup>R/L</sup> _0010K11S10	10	125	22	6.5	13		11IR 11IL	②
ISN <sup>R/L</sup> _0012M11S12	12	150	26	8	16			
ISN <sup>R/L</sup> _A0010K11S10	10	125	22	6.5	13	●		
ISN <sup>R/L</sup> _A0012M11S12	12	150	26	8	16	●		
ISN <sup>R/L</sup> _0016Q16	16	180	36	10	19		16IR 16IL	③
ISN <sup>R/L</sup> _0020R16	20	200	40	12	24			④
ISN <sup>R/L</sup> _0025R16	25	200	45	14.5	29			④
ISN <sup>R/L</sup> _0032S16	32	250	45	18.5	36			③
ISN <sup>R/L</sup> _A0016Q16	16	180	36	10	19	●		③
ISN <sup>R/L</sup> _A0020R16	20	200	40	12	24	●		④
ISN <sup>R/L</sup> _A0025R16	25	200	45	14.5	29	●		④
ISN <sup>R/L</sup> _A0032S16	32	250	45	18.5	36	●		④

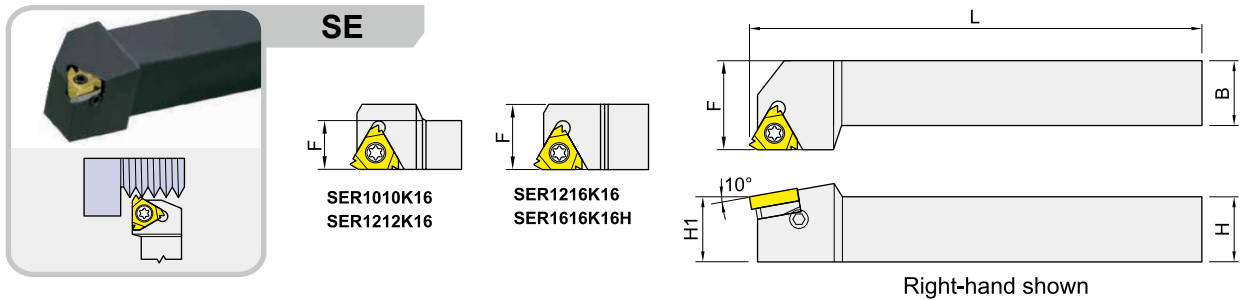
Spare parts	Screw	Shim	Screw	Wrench	Clamp	Wrench
①	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	IMC353V	ITK15
②	IMS2507G	-	-	-	-	ITK08
③	IMS3509A	-	-	-	-	ITK15
④	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	-	ITK15

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

External Threading Tool Holders



Order No.	Dimensions (mm)				Insert	Spare parts
	H(H1)	B	L	F		
ISE <sup>R/L</sup> 1010K16HC	10	10	125	10	16ER 16EL	①
ISE <sup>R/L</sup> 1212K16HC	12	12	125	12		
ISE <sup>R/L</sup> 1216K16HC	12	16	125	16		
ISE <sup>R/L</sup> 1616K16HC	16	16	125	16		
ISE <sup>R/L</sup> 1616K16CL	16	16	125	20		②
ISE <sup>R/L</sup> 2020K16CL	20	20	125	25		
ISE <sup>R/L</sup> 2525M16CL	25	25	150	32		
ISE <sup>R/L</sup> 3232P16CL	32	32	170	40		

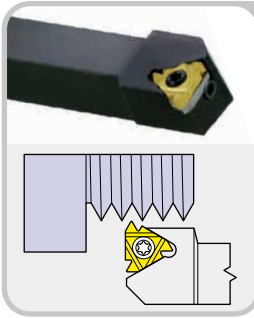


Order No.	Dimensions (mm)				Insert	Spare parts
	H(H1)	B	L	F		
ISE <sup>R/L</sup> 1216K16	12	16	125	16	16ER 16EL	③
ISE <sup>R/L</sup> 1010K16H	10	10	125	10		
ISE <sup>R/L</sup> 1212K16H	12	12	125	12		
ISE <sup>R/L</sup> 1616K16H	16	16	125	16		
ISE <sup>R/L</sup> 1616K16	16	16	125	20		④
ISE <sup>R/L</sup> 2020K16	20	20	125	25		
ISE <sup>R/L</sup> 2525M16	25	25	150	32		
ISE <sup>R/L</sup> 3232P16	32	32	170	40		

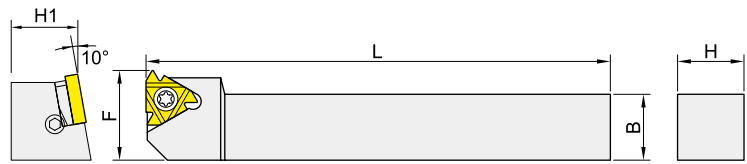
Spare parts	Screw	Shim	Screw	Wrench	Clamp	Wrench
①	IMS3509A	-	-	-	-	ITK15
②	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	IMC353V	ITK15
③	IMS3509A	-	-	-	-	ITK15
④	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	-	ITK15

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

External Threading Tool Holders



SKE



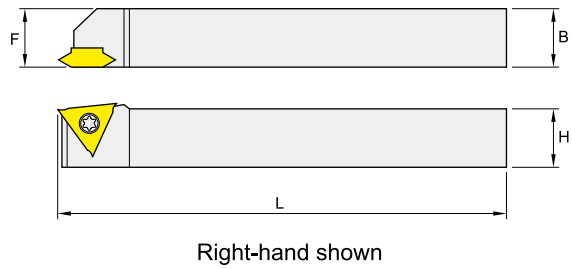
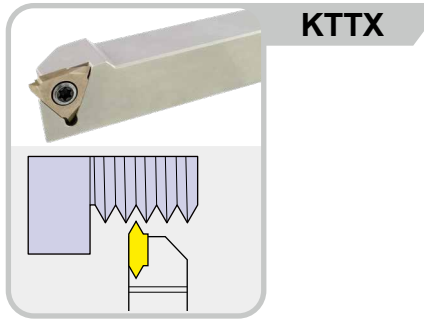
Right-hand shown



Order No.	Dimensions (mm)				Insert	Spare parts
	H(H1)	B	L	F		
ISKE <sup>R</sup> / <sub>L</sub> 1212K16	12	12	125	18	16ER 16EL	①
ISKE <sup>R</sup> / <sub>L</sub> 1616K16	16	16	125	22		②
ISKE <sup>R</sup> / <sub>L</sub> 2020K16	20	20	125	27		
ISKE <sup>R</sup> / <sub>L</sub> 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.

External Threading Tool Holders



Order No.	Dimensions (mm)				Insert	Screw 	Wrench 
	H	B	L	F			
IKTTX <sup>R</sup> / <sub>L</sub> 1010K16F	10	10	125	10	16VER 16VEL	IBFTX0407	ITK15
IKTTX <sup>R</sup> / <sub>L</sub> 1212K16F	12	12	125	12			
IKTTX <sup>R</sup> / <sub>L</sub> 1616K16F	16	16	125	16			
IKTTX <sup>R</sup> / <sub>L</sub> 2020K16F	20	20	125	20			
IKTTX <sup>R</sup> / <sub>L</sub> 2525K16F	25	25	150	25			

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

**Threading Tools**

**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	<b>0.356</b>	<b>0.508</b>	<b>0.533</b>	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				<b>0.660</b>	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					<b>0.813</b>	<b>0.965</b>	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									<b>1.143</b>	<b>1.270</b>	0.102	0.127	0.152	0.152	0.178	0.178	0.203			
10											0.076	0.102	0.127	0.152	0.178	0.178	0.178			
11										<b>1.600</b>	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													<b>1.880</b>	<b>2.210</b>	0.102	0.127	0.127	0.152		
14															0.076	0.102	0.102	0.127	0.152	
15																<b>2.515</b>	<b>2.819</b>	<b>3.124</b>	0.127	0.127
16																			0.102	0.102
																			<b>3.429</b>	<b>3.734</b>

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	0.229	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	<b>0.356</b>	<b>0.483</b>	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			<b>0.610</b>	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				<b>0.787</b>	<b>0.889</b>	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	0.203					
9								<b>1.092</b>	<b>1.219</b>	0.102	0.102	0.127	0.127	0.152	0.152	0.178					
10										0.076	0.102	0.102	0.127	0.152	0.152	0.152					
11											<b>1.499</b>	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														<b>1.778</b>	<b>2.057</b>	0.102	0.102	0.127	0.152		
14																0.076	0.102	0.102	0.127	0.152	
15																	<b>2.337</b>	<b>2.642</b>	<b>2.896</b>	0.127	0.127
16																				0.102	0.102
																				<b>3.200</b>	<b>3.454</b>

Last pass equals total depth of thread.

**Threading Tools**

**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	<b>0.533</b>	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		<b>0.635</b>	<b>0.711</b>	0.076	0.076	0.102	0.102	0.127	0.152	0.152	0.152	0.152	0.152
7				<b>0.838</b>	<b>0.940</b>	0.076	0.102	0.102	0.127	0.127	0.152	0.152	0.152
8						<b>1.041</b>	0.076	0.076	0.076	0.102	0.127	0.127	0.152
9							<b>1.194</b>	<b>1.270</b>	<b>1.372</b>	0.076	0.102	0.127	0.127
10										<b>1.499</b>	0.076	0.102	0.127
11											<b>1.651</b>	0.076	0.102
12												<b>1.778</b>	0.076
13													<b>2.032</b>

Last pass equals total depth of thread.

Unified(UN) 60° Internal

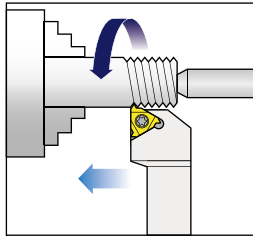
No. of Passes	TPI												
	32	28	24	20	18	16	14	13	12	11	10	9	8
	Radial infeed per pass (mm)												
1	0.178	0.178	0.178	0.203	0.229	0.229	0.229	0.254	0.279	0.279	0.279	0.279	0.305
2	0.152	0.152	0.152	0.178	0.178	0.178	0.203	0.229	0.229	0.229	0.229	0.229	0.279
3	0.102	0.102	0.152	0.127	0.152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

Last pass equals total depth of thread.

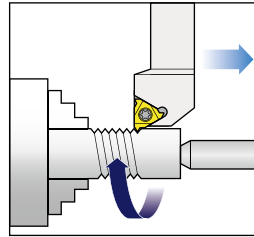
**Threading Tools**

**Thread Methods**

External Right Hand Thread

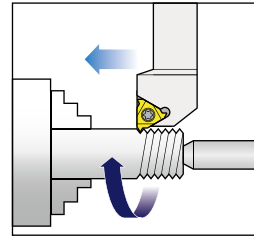


Spindle : Clockwise  
Tool : right hand

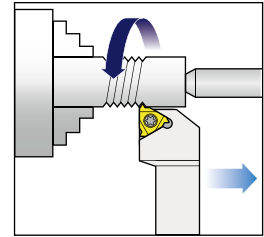


Spindle : Counterclockwise  
Tool : left hand

External Left Hand Thread

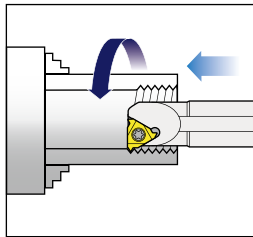


Spindle : Counterclockwise  
Tool : left hand

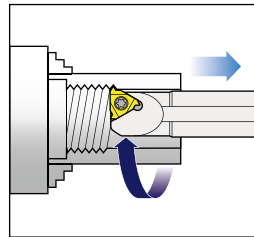


Spindle : Clockwise  
Tool : right hand

Internal Right Hand Thread

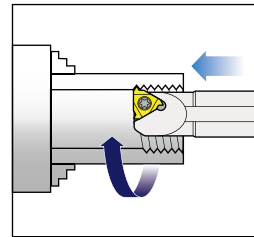


Spindle : Clockwise  
Tool : right hand

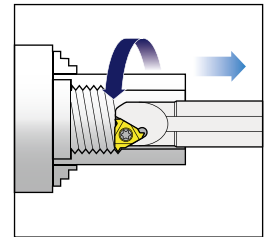


Spindle : Counterclockwise  
Tool : left hand

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