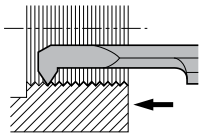
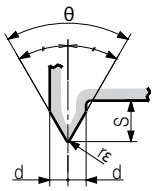
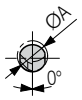
для заказа - kyocera@kyocera-tools.ru

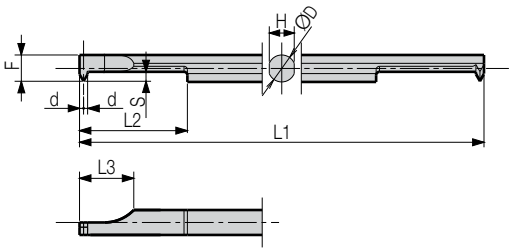
HPT Micro Internal Threading





Details of Edge





• Right-hand shown

Tip-Bars Dimensions

Part Number		Min. Bore Dia.	Dimensions (mm)										Insert Grade		Applicable Thread			
													PVD Coated Carbide	Carbide	Metric		Unified	
		ØA	ØD	H	L1	L2	L3	F	S	d	rε	θ	**PR930**	**KW10**	Applicable Thread	Pitch (mm)	Applicable Thread	Pitch TPI
HPTR	**04504-60-005**	4.5	4	3.7	60	16	8	3.9	1.3	0.6	+0 -0.02 0.05	60°	○	○	M6 or more	P0.75~ P1.25	1/4-20UNC 1/4-28UNF or more	28~20
	06005-60-005	6.0	5	4.6	70	21	8	4.9	1.6	0.8		60°	○	○	M8 or more	P0.75~ P1.50	5/16-18UNC 5/16-24UNF or more	24~18
	07507-60-005	7.5	7	6.4	80	26	10	6.9	2.0	1.0		60°	○	○	M10 or more	P0.75~ P1.50	3/8-16UNC 3/8-24UNF or more	24~16
															Whitworth		Parallel Pipe Tapered Pipe	
HPTR	**06005-55-010**	6.0	5	4.6	70	21	8	4.9	1.6	0.8	+0 -0.02 0.10	55°	○	○	W10 24 W10 TPI 24 or more	24~20	G1/16 R1/16	28
	08007-55-010	8.0	7	6.4	80	26	10	6.9	2.0	1.0		55°	○	○	W11 20 W11 TPI 24 or more	20~18	G1/8 R1/8	28,19

• For American National Pipe (NPT), use HPTR...-60-005. See Page ➡ **J33**

Description Table for Tip-Bars and Applicable Sleeves

Part Number		Applicable Sleeve Part Number ➡ **J29**	
HPTR	**04504-60-005**	EZH	04...-...
	06005-60-005		05...-...
	07507-60-005		07...-...
HPTR	**06005-55-010**	EZH	05...-...
	08007-55-010		07...-...

Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Vc sfm)	
	PVD Coated Carbide	Carbide
	PR930	**KW10**
Carbon Steel/Alloy Steel	★ 100-330	-
Stainless Steel	★ 100-260	-
Non-ferrous Metals	-	★ -980

★ : 1st Recommendation ☆ : 2nd Recommendation

Note:
1) The standard cutting speed is Vc (sfm) = 100-160. The table feed may not follow the expected conditions when machining small diameter workpieces at high speeds.
2) Coolant is recommended.

D.O.C. & Number of Passes (Metric)

Pitch (mm)	Total D.O.C. (mm)	No. of Passes	1 Pass	2 Pass	3 Pass	4 Pass	5 Pass	6 Pass	7 Pass	8 Pass	9 Pass	10 Pass	11 Pass	12 Pass	13 Pass	14 Pass	15 Pass	16 Pass	17 Pass
0.75	0.44	10	0.06	0.06	0.05	0.05	0.05	0.04	0.04	0.03	0.03	0.03							
1.00	0.60	12	0.07	0.07	0.06	0.06	0.06	0.05	0.05	0.04	0.04	0.04	0.03	0.03					
1.25	0.76	14	0.07	0.07	0.07	0.07	0.06	0.06	0.06	0.05	0.05	0.05	0.04	0.04	0.04	0.03			
1.50	0.92	17	0.07	0.07	0.07	0.07	0.06	0.06	0.06	0.06	0.05	0.05	0.05	0.05	0.04	0.04	0.04	0.04	0.03

D.O.C. & Number of Passes (Whitworth)

TPI	Total D.O.C.	No. of Passes	1 Pass	2 Pass	3 Pass	4 Pass	5 Pass	6 Pass	7 Pass	8 Pass	9 Pass	10 Pass	11 Pass	12 Pass	13 Pass	14 Pass	15 Pass	16 Pass	17 Pass
24	0.0256	13	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001				
20	0.0319	15	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001		
18	0.0358	17	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001

D.O.C. & Number of Passes (Unified)

TPI	Total D.O.C.	No. of Passes	1 Pass	2 Pass	3 Pass	4 Pass	5 Pass	6 Pass	7 Pass	8 Pass	9 Pass	10 Pass	11 Pass	12 Pass	13 Pass	14 Pass	15 Pass	16 Pass	17 Pass	18 Pass
28	0.0213	12	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001						
24	0.0252	12	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001						
20	0.0303	14	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001				
18	0.0343	17	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001	
16	0.0386	18	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.001

Tip-Bar is sold in 1 piece boxes.

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