для заказа - kyocera@kyocera-tools.ru

TPGB Type (60° Partial Profile)

(D.O.C. shows the value of radial ap.)

Thread Type		Pitch mm & TPI	Part Number	rε	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
Metric (60°)	Internal Thread	0.75mm	TPGB 1102005	0.05	0.44	5	0.15	0.12	0.10	0.05	0.02												
			TPGB 1103005																				
		0.80mm	TPGB 1102005	0.05	0.47	5	0.15	0.14	0.10	0.06	0.02												
			TPGB 1103005																				
		1.00mm	TPGB 1102005	0.05	0.60	6	0.18	0.14	0.12	0.10	0.04	0.02											
			TPGB 1103005																				
		1.25mm	TPGB 1102005	0.05	0.76	7	0.18	0.16	0.14	0.12	0.10	0.04	0.02										
			TPGB 1103005																				
		1.50mm	TPGB 1102005	0.05	0.92	8	0.20	0.18	0.16	0.14	0.10	0.08	0.04	0.02									
			TPGB 1103005																				
			110201	0.10	0.87	8	0.20	0.18	0.16	0.14	0.08	0.05	0.04	0.02									
			110301																				
		1.75mm	TPGB 1102005	0.05	1.09	9	0.20	0.18	0.16	0.14	0.13	0.12	0.10	0.04	0.02								
			TPGB 1103005																				
			110301	0.10	1.04	9	0.20	0.18	0.16	0.13	0.12	0.10	0.08	0.05	0.02								
		2.00mm	TPGB 1102005	0.05	1.25	11	0.20	0.18	0.16	0.14	0.13	0.12	0.10	0.10	0.06	0.04	0.02						
			TPGB 1103005																				
			110301	0.10	1.20	11	0.20	0.18	0.16	0.13	0.13	0.12	0.10	0.08	0.05	0.03	0.02						
		2.50mm	TPGB 1102005	0.05	1.57	13	0.23	0.20	0.18	0.18	0.14	0.13	0.12	0.10	0.08	0.07	0.07	0.05	0.02				
			TPGB 1103005																				
			110301	0.10	1.52	13	0.23	0.20	0.18	0.18	0.13	0.13	0.12	0.10	0.08	0.07	0.05	0.03	0.02				
		3.00mm	TPGB 1102005	0.05	1.90	15	0.25	0.22	0.20	0.18	0.14	0.14	0.13	0.12	0.12	0.10	0.08	0.08	0.07	0.05	0.02		
			TPGB 1103005																				
			110301	0.10	1.85	15	0.25	0.22	0.20	0.18	0.14	0.14	0.13	0.12	0.10	0.10	0.08	0.07	0.05	0.05	0.02		
			110302	0.20	1.75	14	0.25	0.22	0.20	0.18	0.14	0.14	0.13	0.12	0.10	0.08	0.07	0.05	0.05	0.02			
		3.50mm	TPGB 1102005	0.05	2.22	16	0.25	0.22	0.20	0.18	0.18	0.16	0.16	0.14	0.14	0.12	0.12	0.10	0.10	0.08	0.05	0.02	
			TPGB 1103005																				
			110301	0.10	2.17	16	0.25	0.22	0.20	0.18	0.18	0.16	0.16	0.14	0.14	0.12	0.10	0.10	0.08	0.07	0.05	0.02	
			110302	0.20	2.07	15	0.25	0.22	0.20	0.18	0.18	0.16	0.16	0.14	0.14	0.12	0.10	0.08	0.07	0.05	0.02		

Guide for Internal Threading

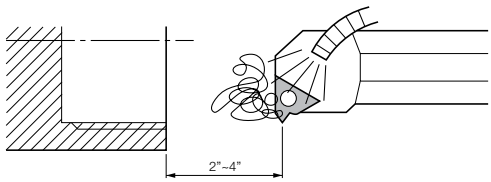
For internal threading, pay extra attention to "Stabilizing diameters of pre-drilled holes"and "chip evacuation".

1. Stabilizing diameters of pre-drilled holes
   Because small pitch internal threads have a small corner radius any variation in the diameter of pre drilled holes will greatly affect the tool life of the insert. Please minimize any variation of pre drilled holes and add an air pass to the first thread pass for safety.

2. Chip evacuation
   If the threading cycle continues with chips tangled on the holder or in the part it may damage the insert. We suggest starting each thread pass at least 2" from the part to allow room for the coolant to remove chips from the tool on each pass.

< 1 When running the first part of a setup>
Run the program in single block to make sure coolant can remove the chips from the tool after each threading pass.

< 2 When running the second part of a setup>
Run through the full threading cycle and again check that chips are removed from the tool before going into production.



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