

Outlines of Threading Inserts

KTKF  J18

“Threading” is added to Small Tools special tool series.

Threading

For Threading

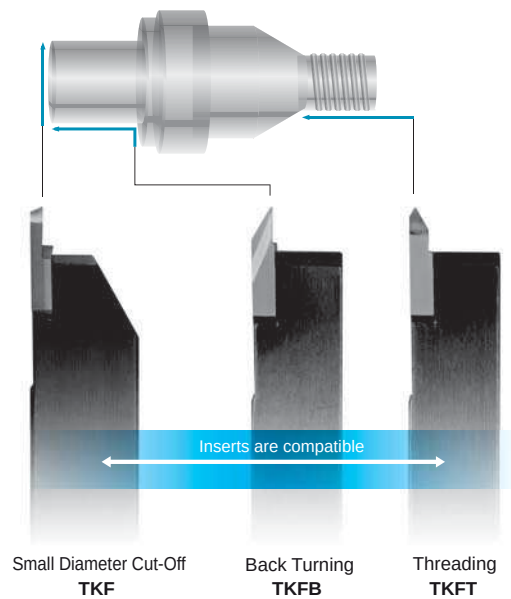
TKFT


- Applicable for various type of threading

Metric (M)

Parallel Pipe [G (PF)]

Unified (UN)

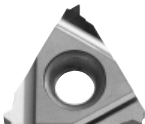
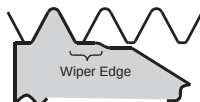
 Tapered Pipe
[R (PT) (BSPT)]

 Small Diameter Cut-Off
TKF

 Back Turning
TKFB

 Threading
TKFT

Threading Insert Features

- Full Profile and Partial Profile

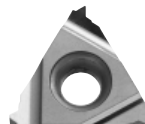
	Shape	Function	Features
Full Profile		 Wiper Edge	① Burr-free thread surface; high quality (Smooth feeling) ② Additional stock must be left on the part diameter for full topping ③ Every pitch size requires a specific insert
Partial Profile			① Thread's corner tends to be sharp edged ② Thread's O.D. or I.D. needs to be finished to the size before threading ③ One insert can machine various pitch sizes

- Thread Precision

Type of Thread		Thread Precision		
		Strict	Loose	
M	External	4h (1st Class)	6g (2nd Class)	8g (3rd Class)
	Internal	5H (1st Class)	6H (2nd Class)	7H (3rd Class)
Unified	External	3A	2A	1A
	Internal	3B	2B	1B
* Applicable precision with Full Profile Insert		×	○	○

* Not recommended if strict thread precision is required.

- With and Without Chipbreaker

	Shape	Condition	Cutting Force	Chip Length
Without Chipbreaker		• When less cutting force is needed for small or thin part machining	Small	
1-Thread, With Chipbreaker	-TS 	• When Better Chip Control is needed	Smaller	
2-Thread, With Chipbreaker	-M02 	① Fewer passes and less machining time ② For rigid workpiece ③ Wider dead space	Large (2 Edges engage in threading)	

J


Threading