для заказа - kyocera@kyocera-tools.ru

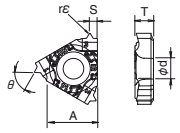
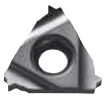
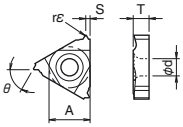
Internal Threading Inserts

Unified (UN)

Full Profile 60° (mm)

Description	Previous Description	A	T	ød
16IR/L	TNN32IR/L	9.525	3.68	4.0
22IR/L	TNN43IR/L	12.70	4.9	4.85

Classification of usage								
● : 1st Choice ○ : 2nd Choice	P	Carbon Steel / Alloy Steel			○	●		
	M	Stainless Steel			○	●		
	K	Cast Iron						
	N	Non-ferrous Metals						

	Insert (Handed Insert shows Right-hand)		Description	Previous Description	Applicable Thread UN, UNF Pitch TPI	Dimension (mm) rε	S	Angle (°) θ	Cermet TC60 R	TC60 L	PVD Coated Carbide PR630 R	PR630 L	PR930 R	PR930 L	PR1115 R	PR1115 L	Carbide GW15 R	GW15 L	KW10 R	KW10 L	Ref. Page for Depth of Cut & Number of Passes
Full Profile			16IR/L 24UN-TF	-	24	0.06	0.8	60°							●						J30
			20UN-TF		20	0.08	1.0								●						
			18UN-TF		18	0.09	1.0								●						
			16UN-TF		16	0.10	1.1								●						
			14UN-TF		14	0.12	1.5								●						
			13UN-TF		13	0.13	1.5								●						
			12UN-TF		12	0.14	1.5								●						
			10UN-TF		10	0.17	1.5								●						
			08UN-TF		8	0.21	1.8								●						
			16IR/L 24UN	TNN32IR/L 24UN	24	0.05	0.8	60°	●				●								
			20UN	20UN	20	0.07	1.0		●				●								
			18UN	18UN	18	0.09	1.0		●				●								
			16UN	16UN	16	0.10	1.1		●				●								
			14UN	14UN	14	0.12	1.5		●				●								
			12UN	12UN	12	0.14	1.5		●				●								
			22IR/L 08UN	TNN43IR/L 08UN	8	0.20	1.8	60°	●				●		●						

For recommended cutting conditions, see page ➡J29

Applicable Toolholder

Description	Applicable Toolholder	Ref. Page for Toolholder
16IR ···	SINR··-16 CINR··-16	J17
22IR ···	SINR··-22 CINR··-22	

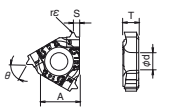
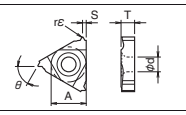
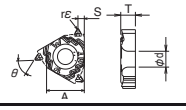
Internal Threading Inserts

Parallel Pipe [G (PF)] Whitworth (W)

Full Profile 55° (mm)

Description	Previous Description	A	T	ød
16IR/L	TNN32IR/L	9.525	3.68	4.0

Classification of usage								
● : 1st Choice ○ : 2nd Choice	P	Carbon Steel / Alloy Steel			○	●		
	M	Stainless Steel			○	●		
	K	Cast Iron						
	N	Non-ferrous Metals						

	Insert (Handed Insert shows Right-hand)		Description	Previous Description	Applicable Thread G (PF) Pitch TPI	W Pitch TPI	Dimension (mm) rε	S	Angle (°) θ	Cermet TC60 R	TC60 L	PVD Coated Carbide PR630 R	PR630 L	PR930 R	PR930 L	PR1115 R	PR1115 L	Carbide GW15 R	GW15 L	KW10 R	KW10 L	Ref. Page for Depth of Cut & Number of Passes
Full Profile			16IR/L 19W-TF	-	19	-	0.16	1.0	55°							●						J31
			16W-TF		-	16	0.19	1.1								●						
			14W-TF		14	14	0.23	1.5								●						
			11W-TF		11	11	0.30	1.5								●						
			16IR/L 14W	TNN32IR/L 14W	14	14	0.23	1.5	55°	●				●								
			11W	11W	11	11	0.30	1.5		●				●								
	1-Thread, With Chipbreaker		16IR/L 14W-TS	TNN32IR/L 14W-TS	14	14	0.23	1.5						●								
			11W-TS	11W-TS	11	11	0.30	1.5						●								J35

For recommended cutting conditions, see page ➡J29

- No wiper effect is expected when threading the internal whitworth screw using 16IR ○○ W- ○○ insert.

Applicable Thread	M: Metric	R, Rc (PT), (BSPT): Tapered Pipe
	UN: Unified	W: Whitworth
	UNF: Unified Fine Thread	NPT: American National Pipe
	G (PF): Parallel Pipe	Tr: 30°Trapezoidal

Applicable Toolholder

Description	Applicable Toolholder	Ref. Page for Toolholder
16IR ···	SINR··-16 CINR··-16	J17
16IL ···	SINL··-16 CINL··-16	

● : Std. Item ○ : Check Availability
R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)

PR930 / PR1115 / GW15 (Threading Insert) is sold in 5 piece boxes.

Inserts are sold in 10 piece boxes.

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