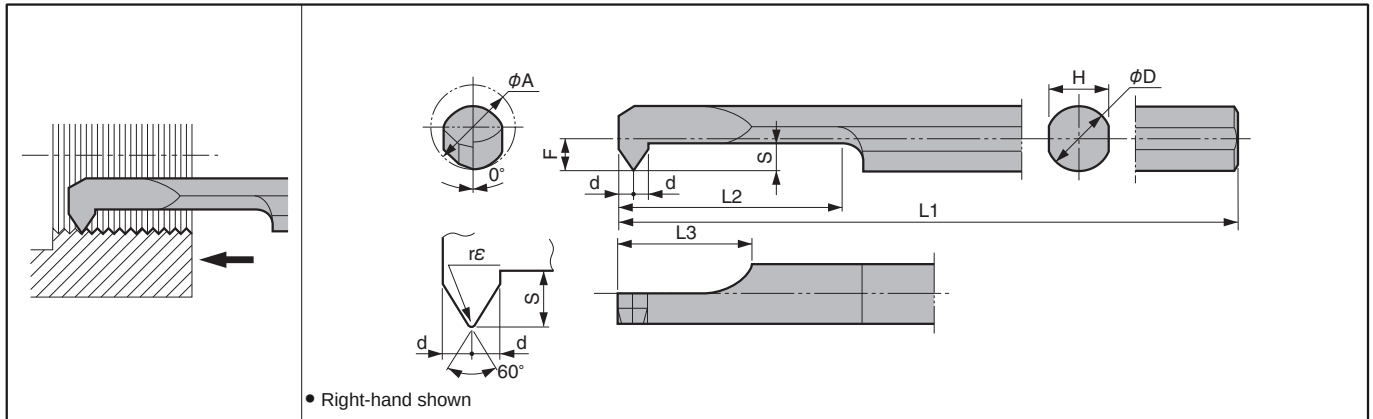


Tip-Bar for Micro Internal Threading

PST-S (Tip-Bar)

This insert will be switched to **HPT** (2-Edge See Page [J24](#)).



Insert Dimensions

Description	Min. Bore Dia.	Dimension (mm)										Insert Grade				Applicable Thread			
												Cermet	PVD Coated Carbide	Carbide		Metric		Unified	
		ϕA	ϕD	H	L1	L2	L3	F	S	d	r					Nominal Thread	Pitch (mm)	Nominal Thread	Pitch (TPI)
PSTR	0604-60S	4.5	3.8	3.6	60	15	8	1.7	1.6	0.8	0.05				●	M6 and over	P0.75 ~P1.25	1/4-20UNC, 1/4-28UNF and over	28~20
	0805-70S	6.0	4.8	4.4	70	20		2.2	2.1	1.0					●	M8 and over	P0.75 ~P1.50	5/16-18UNC, 5/16-24UNF and over	24~18

Applicable Sleeves

This sleeve is for 1-Edge Tip-Bar. For 2-Edges Tip-Bar, See Page [J25](#).

Shape	Description	(Previous Description)	Std.	Dimension (mm)								Spare Parts		Applicable Tip-Bar
				$\phi D1$	$\phi D2$	$\phi d1$	$\phi d2$	H	L1	L2		Screw	Wrench	
	PH 0412-60	PH -0412	●	12	19	3.8	6	11	60	20		HS4X4	LW-2	PSTR0604-60S
	0512-60	-0512	●			4.8								PSTR0805-70S
	PH 0416-80	PH -0416	●	16	22	3.8	Rp 1/4 (PS 1/4)	15	80	20		HS4X4	LW-2	PSTR0604-60S
	0516-80	-0516	●			4.8								PSTR0805-70S

Depth of Cut & Number of Passes

Pitch (mm)	Total ap (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

<Note> 1) The standard cutting speed is $V_c=30\sim50\text{m/min}$. The table feed may not follow the expected conditions when machining small diameter workpieces at high speeds.
2) Coolant is recommended.