

## Internal Threading Inserts

### Tapered Pipe [Rc (PT) (BSPT)]

Full Profile 55° (mm)					Classification of usage ● : 1st Choice ○ : 2nd Choice	P	Carbon Steel / Alloy Steel		●	○			Ref. Page for Depth of Cut & Number of Passes						
Description	Previous Description	A	T	ød		M	Stainless Steel		●	○									
					K	Cast Iron					●								
					N	Non-ferrous Metals					●								
Insert	Description	Previous Description	Applicable Thread		Dimension (mm)		Angle (°)	Cermet			PVD Coated Carbide			Carbide					
			RC (PT) (BSPT)	Pitch	rc	S	θ	TC60		PR1115		PR930		GW15		KW10			
			TPI					R	L	R	L	R	L	R	L	R	L		
Full Profile		111°/L 28BSPT-TF 19BSPT-TF 14BSPT-TF	-	28	0.10	0.6	55°											J31	
				19	0.16	0.78													
				14	0.22	0.97													
		161°/L 14BSPT-TF 11BSPT-TF	-	14	0.22	0.97													
				11	0.29	1.5													
Full Profile		111°/L 28BSPT 19BSPT 14BSPT	TNN221°/L 28PT	28	0.10	0.6	55°											J35	
				19	0.16	0.78													
				14	0.22	0.97													
		161°/L 14BSPT 11BSPT	TNN321°/L 14PT	14	0.22	0.97													
				11	0.29	1.5													
1-Thread, With Chipbreaker		111°/L 19BSPT-TS 14BSPT-TS	TNN221°/L 19PT-TS	19	0.16	0.78	55°												
				14	0.22	0.97													
				11	0.29	1.5													
1-Thread, With Chipbreaker		161°/L 14BSPT-TS 11BSPT-TS	TNN321°/L 14PT-TS	14	0.22	0.97													
				11	0.29	1.5													

#### Applicable Toolholder

Description	Applicable Toolholder	Ref. Page for Toolholder
11IR ..	SINR...11E SINR...11	J17
11IL ..	SINL...11E SINL...11	
16IR ..	SINR...16 CINR...16	

For recommended cutting conditions, see page J29

## Internal Threading Inserts

### American National Tapered Pipe (NPT60°)

Full Profile 60° (mm)					Classification of usage ● : 1st Choice ○ : 2nd Choice	P	Carbon Steel / Alloy Steel		●	○			Ref. Page for Depth of Cut & Number of Passes					
Description	Previous Description	A	T	ød		M	Stainless Steel		●	○								
					K	Cast Iron					●							
					N	Non-ferrous Metals					●							
Insert	Description	Previous Description	Applicable Thread		Dimension (mm)		Angle (°)	Cermet			PVD Coated Carbide			Carbide				
			NPT	Pitch	rc	S	θ	TC60		PR1115		PR930		GW15		KW10		
			TPI					R	L	R	L	R	L	R	L	R	L	
Full Profile		161°/L 18NPT 14NPT 11.5NPT	TNN321°/L 18NPT	18	0.04	0.9	60°											J31
				14	0.05	1.5												
				11.5	0.06	1.5												

#### Applicable Toolholder

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

For recommended cutting conditions, see page J29

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

● : Std. Item □ : Check Availability

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

Inserts are sold  
in 10 piece boxes.

