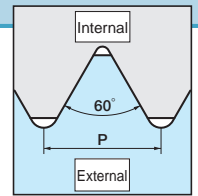


Threading Inserts



External Threading Inserts

60°Type [Partial Profile / M, UN]

Partial Profile60° (mm)

Description	Previous Description	A	T	ød	Classification of usage ● : 1st Choice ○ : 2nd Choice	P		M		K		N		Ref. Page for Depth of Cut & Number of Passes
						Carbon Steel / Alloy Steel	Stainless Steel	Cast Iron	Non-ferrous Metals					
16E ^{R/L}	TNN32E ^{R/L}	9.525	3.68	4.0			●	○			●	○		
22E ^{R/L}	TNN43E ^{R/L}	12.70	4.9	4.85									●	○

Insert	Description	Previous Description	Applicable Thread		Dimension (mm)		Angle (°)	Cermet		PVD Coated Carbide		Carbide		Ref. Page for Depth of Cut & Number of Passes
			M	UN UNF	rε	S		TC60	PR1115	PR930	GW15	KW10		
			Pitch		R	L	R	L	R	L	R	L		
Handed Insert shows Right-hand			mm	TPI										
Partial Profile	16E ^{R/L} A60-TF G60-TF AG60-TF	-	0.5~1.5	48~16	0.06	1.00	60°							J31 J32
			1.75~3	14~8	0.22	1.60								
			0.5~3	48~8	0.06	1.60								
	16E ^{R/L} A60 G60 AG60 22E ^{R/L} N60	-	0.5~1.5	48~16	0.06	1.00	60°							J31 J32
			1.75~3	14~8	0.22	1.60								
			0.5~3	48~8	0.06	1.60								
			3.5~5	7~5	0.48	2.50								
	16E ^{R/L} 6001 6002	TNN32E ^{R/L} 6001 6002	1.0~2.5	24~11	0.10	1.50	60°							J35
			1.5~2.5	16~11	0.20	1.50								
1-Thread, With Chipbreaker 16E ^{R/L} 6001-TS 6002-TS	TNN32E ^{R/L} 6001-TS 6002-TS	1.0~2.5	24~11	0.09	1.50	60°							J35	
		1.5~2.5	16~11	0.19	1.50									

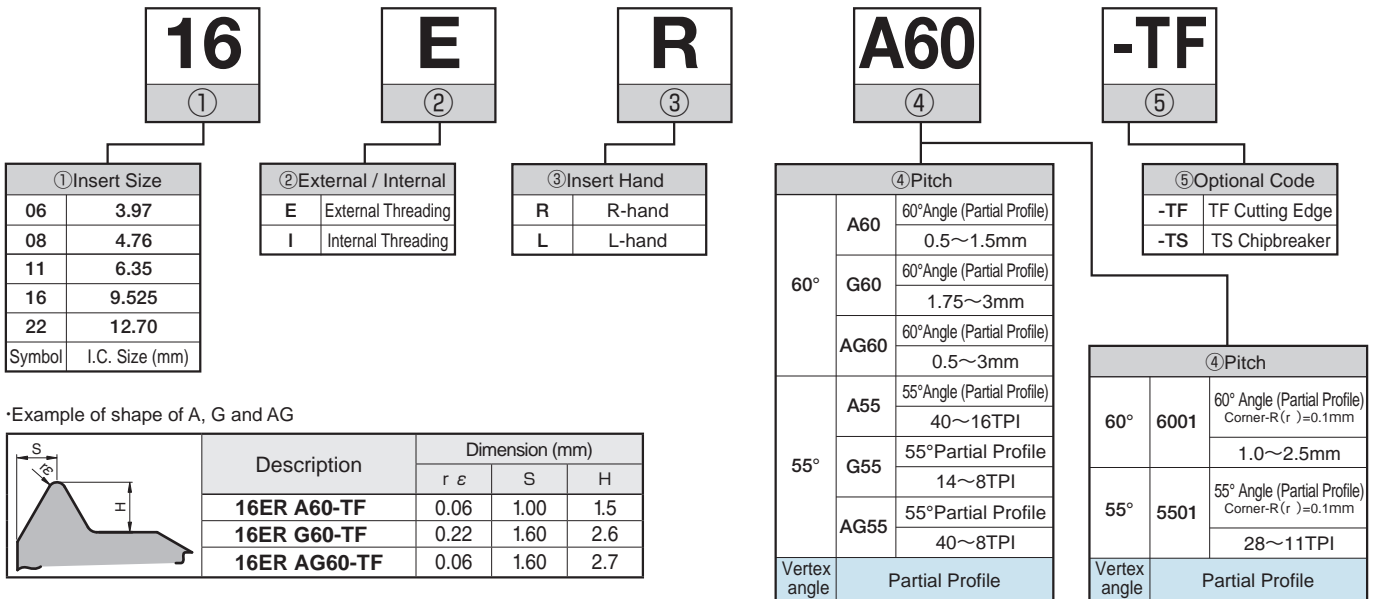
Applicable Toolholder

Description	Applicable Toolholder	Ref. Page for Toolholder
16ER ...	KTNR...-16 KTNSR...-16	J16
22ER ...	KTNR...-22	

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

Threading Inserts Identification System (Partial Profile) J12~J15



Example of shape of A, G and AG

Description	Dimension (mm)		
	rε	S	H
16ER A60-TF	0.06	1.00	1.5
16ER G60-TF	0.22	1.60	2.6
16ER AG60-TF	0.06	1.60	2.7

Corner-R(rε) Selection for Partial Profiling Insert

	External Threading	Internal Threading
Metric Unified	$r\epsilon \leq 0.1443P$	$r\epsilon \leq 0.0720P$
Parallel Pipe (Whitworth) Tapered Pipe	(For Both External and Internal Thread) $r\epsilon \leq 0.1373P$	

rε: Corner-R P: Pitch (= $\frac{25.4}{n}$) n: TPI

- Metric, Unified Thread**
Corner-R(rε) at Internal Threading is almost half of that of External.
- Parallel Pipe, Tapered Pipe, Whitworth Tread**
Same Corner-R(rε) for both External and Internal Threading

Note) Pitch and threads per inch of an insert without wiper depend on the size of insert.

● : Std. Item □ : Check Availability

PR930 / PR1115 / GW15

(Threading Insert) is sold in 5 piece boxes.

Inserts are sold

in 10 piece boxes.