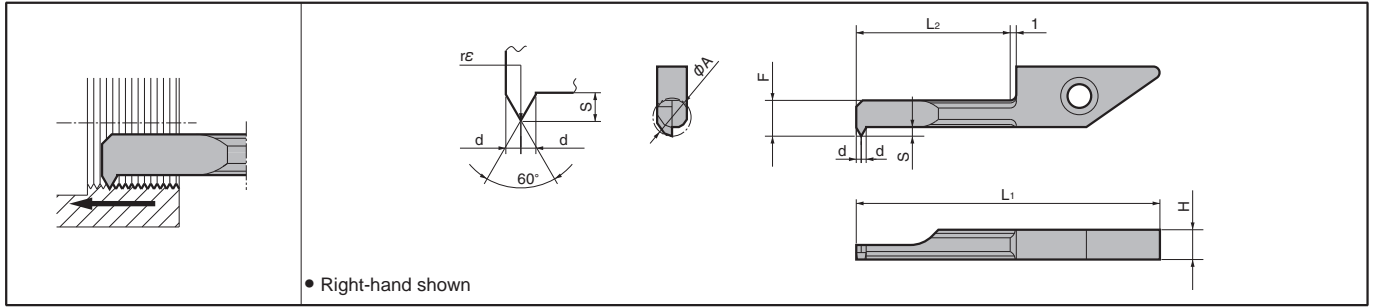


# System Tip-Bar for Micro Threading

## VNT (System Tip-Bar)



• Right-hand shown

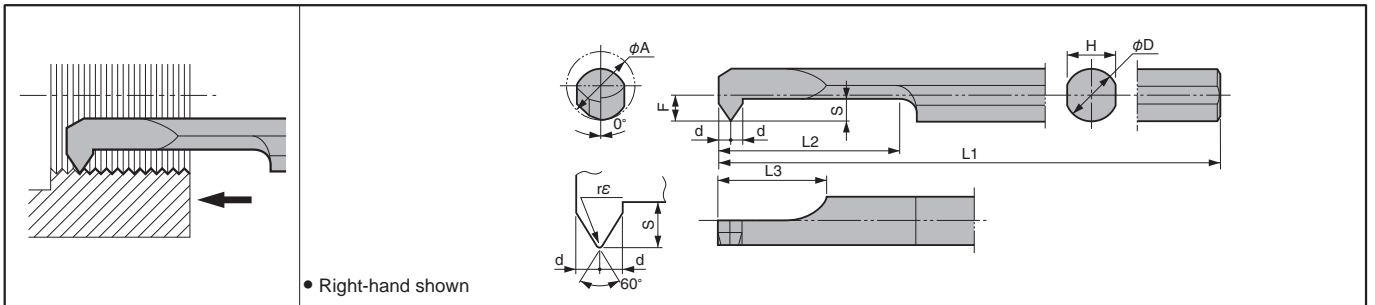
### Insert Dimensions

Description	Min. Bore Dia.	Dimension (mm)								Insert Grade			Applicable Thread			
										Cermet	PVD Coated Carbide	Carbide	Metric		Unified	
													Nominal Thread	Pitch (mm)	Nominal Thread	Pitch (TPI)
<b>VNTR 045-11</b>	4.5									TC60	PR930	KW10	M6 and over	P0.75 ~P1.25	1/4-20UNC, 1/4-28UNF and over	28~20
<b>060-11</b>	6.0	3.9	30.8	11	3.6	1.3	0.6		0.05				M8 and over	P0.75 ~P1.50	5/16-18UNC, 5/16-24UNF and over	24~18

• For applicable Toolholder, see page **F16~F18**.

## PST-S (Tip-Bar)

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



• Right-hand shown

### Insert Dimensions

Description	Min. Bore Dia.	Dimension (mm)										Insert Grade			Applicable Thread			
												Cermet	PVD Coated Carbide	Carbide	Metric		Unified	
															Nominal Thread	Pitch (mm)	Nominal Thread	Pitch (TPI)
<b>PSTR 0604-60S</b>	4.5	3.8	3.6	60	15							TC60	PR930	KW10	M6 and over	P0.75 ~P1.25	1/4-20UNC, 1/4-28UNF and over	28~20
<b>0805-70S</b>	6.0	4.8	4.4	70	20	8	1.7	1.6	0.8		0.05				M8 and over	P0.75 ~P1.50	5/16-18UNC, 5/16-24UNF and over	24~18

• For applicable Toolholder, see page **F80**.

### Depth of Cut & Number of Passes (Metric)

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 Vc=30~50m/min. The table feed may not follow the expected conditions when machining small diameter workpieces at high speeds.  
2) Coolant is recommended.

● : Std. Item    □ : Check Availability

Tip-Bars are sold in 1 piece boxes.

System Tip-Bars are sold in 5 piece boxes.

