

# Threading Methods

## External Threading (R-hand Thread / L-hand Thread)

External Threading					
R-hand Thread			L-hand Thread		
Toolholder	R-hand		Toolholder	L-hand	
Insert	R-hand		Insert	L-hand	
The direction of spindle revolution	M03		The direction of spindle revolution	M04	
Toolholder	L-hand		Toolholder	R-hand	
Insert	L-hand		Insert	R-hand	
The direction of spindle revolution	M03		The direction of spindle revolution	M04	
Toolholder	R-hand		Toolholder	L-hand	
Insert	R-hand		Insert	L-hand	
The direction of spindle revolution	M04		The direction of spindle revolution	M03	
Toolholder	L-hand		Toolholder	R-hand	
Insert	L-hand		Insert	R-hand	
The direction of spindle revolution	M04		The direction of spindle revolution	M03	

\* These tables are based on KTN / KTNS / KTT / KTTX type Toolholder.

## Internal Threading (R-hand Thread / L-hand Thread)

Internal Threading					
R-hand Thread			L-hand Thread		
	Toolholder	R-hand		Toolholder	L-hand
	Insert	R-hand		Insert	L-hand
	The direction of spindle revolution	M03		The direction of spindle revolution	M04
	Toolholder	L-hand		Toolholder	R-hand
	Insert	L-hand		Insert	R-hand
	The direction of spindle revolution	M04		The direction of spindle revolution	M03

\* These tables are based on SIN / CIN type Toolholder.

For KITG type (for large internal threading), L-hand Insert for R-hand Toolholder, R-hand Insert for L-hand Toolholder.