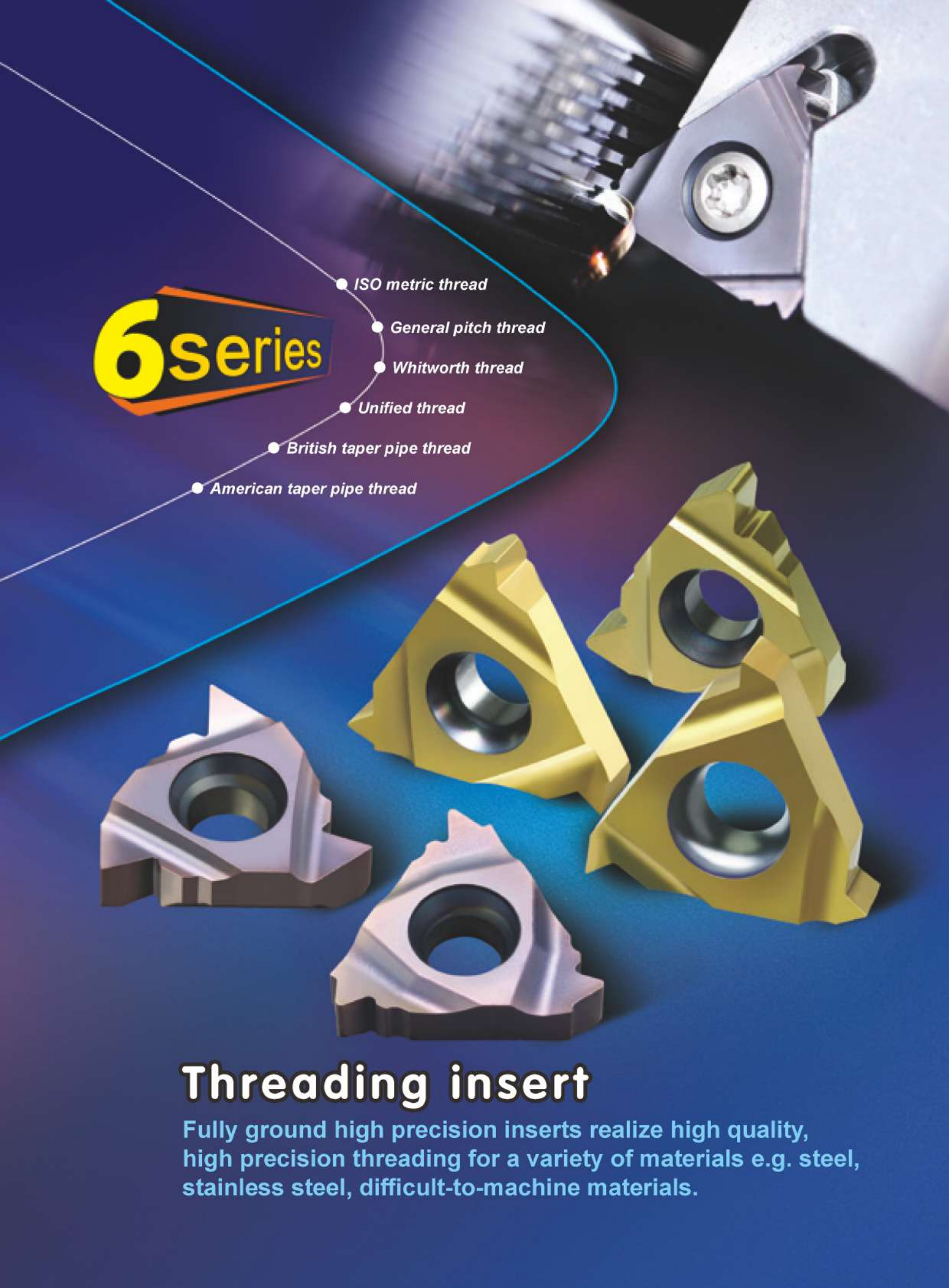
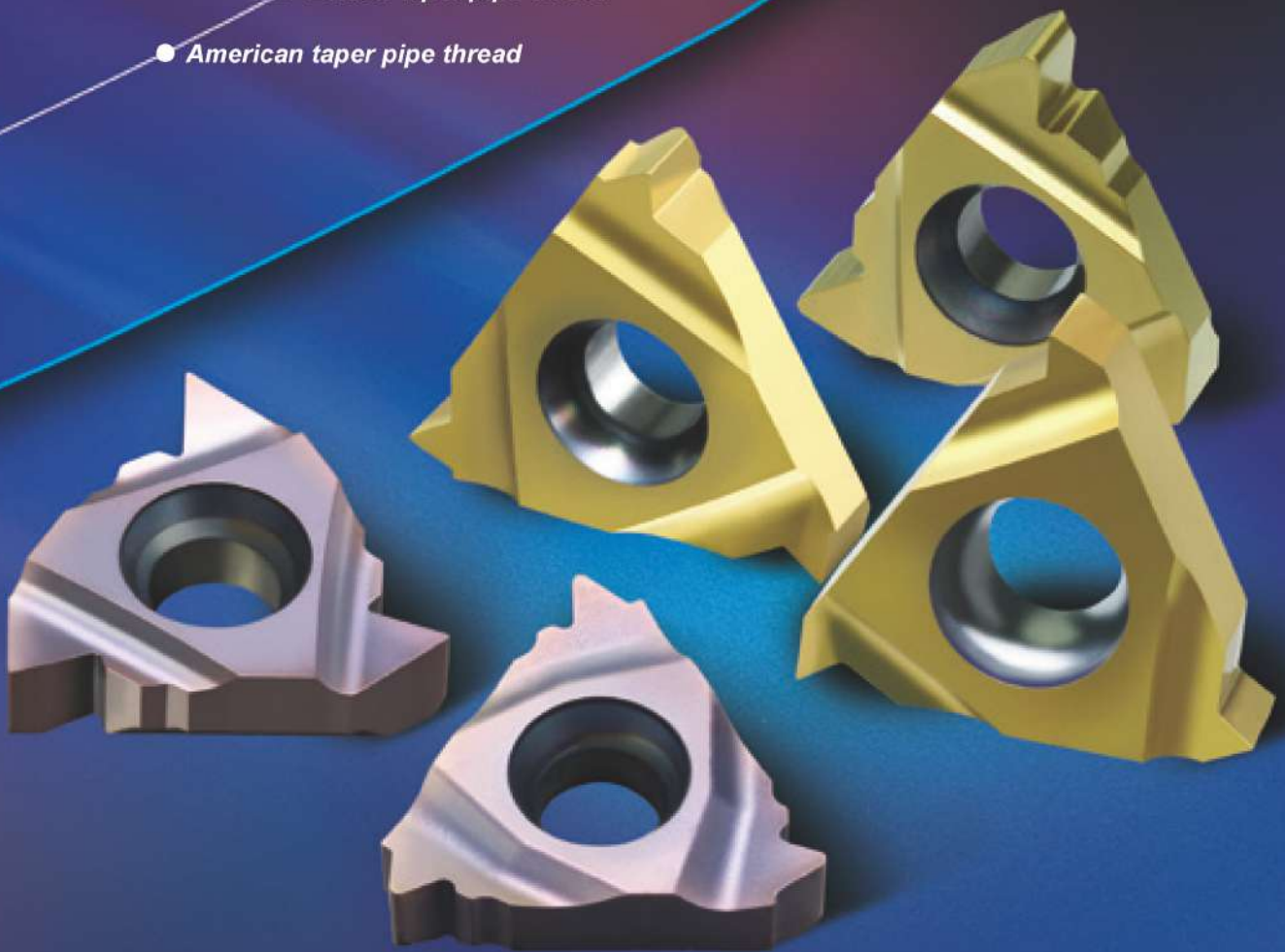




6series

- ISO metric thread
- General pitch thread
- Whitworth thread
- Unified thread
- British taper pipe thread
- American taper pipe thread



Threading insert

Fully ground high precision inserts realize high quality, high precision threading for a variety of materials e.g. steel, stainless steel, difficult-to-machine materials.



How to select threading tools

Structure of threading tools selected table

- Categorized as external threading and internal threading according to machining type.
- Separately listed out according to series.

Dimensions of product

Indicating external threading or internal threading

External threading tools

Threading insert type
Including type, standard, tolerance class

Diagram of thread pitch

ISO metric thread (with end)

ISO 965-1980 DIN 13
GB/T 197-2003 Tolerance class: 6g/6H

Product specification
Including type (right hand and left hand), basic dimensions, stock

Dimension diagram of insert

Stock available Make-to-order

External thread

Type	Stock	Basic dimensions(mm)					Applicable inserts	Inserts screw	Shim	Shim screw	Wrench					
		H	HF	B	LF	WF										
1616H16	▲	16	16	16	100	20	Z16ER0000	ISO M5.5X12TT	MT16-QDMN	SMX8C	WT10P					
2020K16	▲	20	20	20	125	25										
2525M16	▲	25	25	25	150	32										
3225P16	▲	32	32	25	170	32										
3232P16	▲	32	32	32	170	40										
3225P22	▲	32	32	25	170	32	Z22ER0000	ISO M4X15X	MT22-QDMN	SMX8.5	WT15P					
3232P22	▲	32	32	32	170	40										
4040S22	△	40	40	40	250	50										
1616H16	▲	16	16	16	100	20						Z16EL0000	ISO M5.5X12TT	MT16-QDMN	SMX8C	WT10P
2020K16	▲	20	20	20	125	25										
2525M16	▲	25	25	25	150	32										
3225P16	▲	32	32	25	170	32										
3232P16	▲	32	32	32	170	40										
3225P22	▲	32	32	25	170	32	Z22EL0000	ISO M4X15X	MT22-QDMN	SMX8.5	WT15P					
3232P22	▲	32	32	32	170	40										
4040S22	△	40	40	40	250	50										

Type	Basic dimensions(mm)					Recommended coating grade	
	The right hand tools	The left hand tools	Pitch	S	IC	D1	YBG203
Z16ER0.5ISO	Z16EL0.5ISO	0.50	3.52	9.525	4.0	★	○
Z16ER0.75ISO	Z16EL0.75ISO	0.75	3.52	9.525	4.0	★	○
Z16ER1.0ISO	Z16EL1.0ISO	1.00	3.52	9.525	4.0	★	○
Z16ER1.25ISO	Z16EL1.25ISO	1.25	3.52	9.525	4.0	★	○
Z16ER1.5ISO	Z16EL1.5ISO	1.50	3.52	9.525	4.0	★	○
Z16ER1.75ISO	Z16EL1.75ISO	1.75	3.52	9.525	4.0	★	○
Z16ER2.0ISO	Z16EL2.0ISO	2.00	3.52	9.525	4.0	★	○
Z16ER2.5ISO	Z16EL2.5ISO	2.50	3.52	9.525	4.0	★	○
Z16ER3.0ISO	Z16EL3.0ISO	3.00	3.52	9.525	4.0	★	○
Z22ER3.5ISO	Z22EL3.5ISO	3.50	4.65	12.7	5.0	★	○
Z22ER4.0ISO	Z22EL4.0ISO	4.00	4.65	12.7	5.0	★	○
Z22ER4.5ISO	Z22EL4.5ISO	4.50	4.65	12.7	5.0	★	○
Z22ER5.0ISO	Z22EL5.0ISO	5.00	4.65	12.7	5.0	★	○
Z22ER5.5ISO	Z22EL5.5ISO	5.50	4.65	12.7	5.0	★	○
Z22ER6.0ISO	Z22EL6.0ISO	6.00	4.65	12.7	5.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

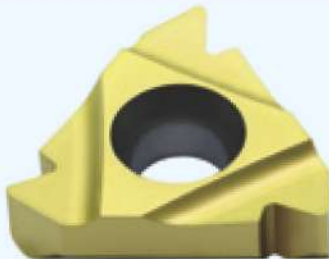


TURNING

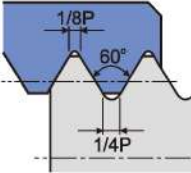
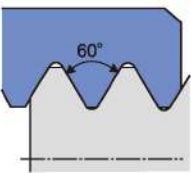
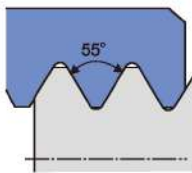


Threading tools

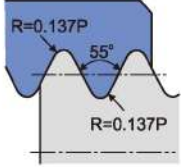
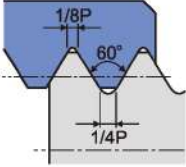
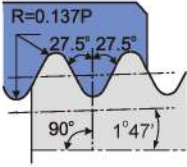
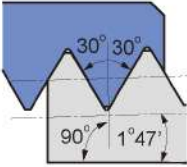
Threading tools overview	A288-A291
Introduction on threading insert grade and chipbreaker	A292
Threading inserts	A293-A306
Threading inserts code key	A293
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General pitch thread	A296
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British taper pipe thread	A299
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ISO metric thread(PP chipbreaker)	A301
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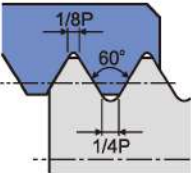
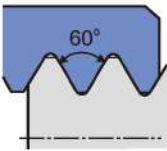
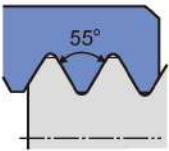


Applications			For general use					
Legend of thread profile								
Thread name			ISO metric thread With end		General pitch thread Without end		General pitch thread Without end	
Thread profile			ISO		60		55	
Picture of insert (length: 11, 16, 22mm)			R style shown		R style shown		R style shown	
			 A294 A301		 A296 A302		 A396 A302	
Tool holder	Pitch	Dimensions (mm) (H×W×L) (Dia×L×Min. dia)	Pitch/mm		Pitch/mm (pitch/Inch)		Pitch/mm (pitch/Inch)	
External thread	 R-type shown A308	16×16×100 20×20×125 25×25×150 32×25×170 32×32×170 40×40×250	0.5~6.0	1.0~3.0	0.5~5.0 (5~48)	0.5~5.0 (5~48)	0.5~5.0 (5~48)	0.5~5.0 (5~48)
Internal thread	 R-type shown A309	16×125×12 16×150×16 16×150×20 20×150×25 20×180×25 25×150×32 32×200×40 32×250×40 40×300×50 50×350×63	0.5~6.0	1.0~3.0	0.5~5.0 (5~48)	0.5~5.0 (5~48)	0.5~5.0 (5~48)	0.5~5.0 (5~48)



For general use		For aerospace industry		Heater, gas and water pipe thread		For gas and water faucet and pipe connection	
							
Whitworth thread		Unified thread (American standard threads)		British taper pipe thread		American taper pipe thread	
W		UN		BSPT		NPT	
R style shown		R style shown		R style shown		R style shown	
							
A297 A303		A298 A304		A299 A305		A300 A306	
Pitch/mm (pitch/Inch)		Pitch/mm (pitch/Inch)		Pitch/mm (pitch/Inch)		Pitch/mm (pitch/Inch)	
8~19	11~19	8~24	12~16	11~28	11~19	8~27	11.5~18
8~19	11~19	8~24	12~16	11~28	11~19	8~27	11.5~18



Applications			For general use		
Legend of thread profile					
Thread name			ISO metric thread With end	General pitch thread Without end	General pitch thread Without end
Thread profile			GM	60	55
Picture of insert (length: 11, 16, 22mm)			R style shown  A311	R style shown  A313	R style shown  A313
Tool holder	Pitch	Dimensions (mm) (H×W×L) (Dia×L×Min. dia)	Pitch/mm	Pitch/mm (pitch/Inch)	Pitch/mm (pitch/Inch)
External thread	 R-type shown A319	16×16×100 20×20×125 25×25×150 32×25×170 32×32×170 40×40×250	0.5~6.0	0.5~5.0 (5~48)	0.5~5.0 (5~48)
Internal thread	 R-type shown A320	16×125×12 16×150×16 16×150×20 20×150×25 20×180×25 25×150×32 32×200×40 32×250×40 40×300×50 50×350×63	0.5~6.0	0.5~5.0 (5~48)	0.5~5.0 (5~48)



For general use	For aerospace industry	Heater, gas and water pipe thread	For gas and water faucet and pipe connection
Whitworth thread	Unified thread (American standard threads)	British taper pipe thread	American taper pipe thread
W	UN	BSPT	NPT
R style shown	R style shown	R style shown	R style shown
A314	A315	A316	A317
Pitch/mm (pitch/Inch)	Pitch/mm (pitch/Inch)	Pitch/mm (pitch/Inch)	Pitch/mm (pitch/Inch)
8~16	8~20	11~28	8~27
8~16	8~20	11~28	8~27

General turning

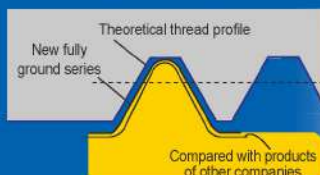
Parting and grooving

Threading

Threading tools overview

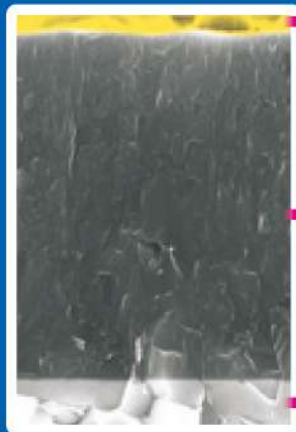
suitable for threading in a variety of materials New nano coating grade YBG203

- Specially treated edge for superior surface quality
- Sharp nose with small cutting resistance and superior performance
- Full ground inserts with high dimensional precision for high quality threading



Thread type	Grade of tolerance
ISO metric thread	6g/6H
Whitworth thread W	Medium Class A
British taper pipe thread	Standard BSPT
Unified thread	2A/2B
American taper pipe thread	Standard NPT

- New nano coating grade specially designed for threading with longer insert life



Advanced surface treatment techniques effectively reduce friction and allows for better wear observation.

Advanced TiAlN substrate nano coating, in combination with proper coating ingredients, improves the mechanical and thermal properties of coating.

Further optimizing coating structure, improving coating stress, enhancing bond strength of coating and substrate.



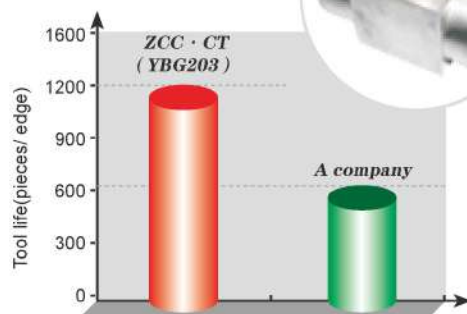
Case:

Workpiece material: 42CrMo(HB260)

Insert: Z16ER2.0ISO/YBG203

Thread pitch: $p=2.0\text{mm}$

Cutting data: $V_c=120\text{ m/min}$



84% tool life improvement of ZCC-CT product than that of company A under the same cutting condition.

Threading inserts code key

Insert size

Code	Diameter of IC(mm)
Z11	Ø6.35
Z16	Ø9.525
Z22	Ø12.7

Cutting style

- E -External threading inserts
- I -Internal threading inserts

Cutting direction

- R-Righ
- L-Left

Z16 E R 2.0 ISO (PP)

Thread pitch

Full profile (Range of Thread pitch is indicated by numbers).

mm	TPI
0.5-6.0	48-5

V profile (Range of Thread pitch is indicated by letters).

	mm	TPI
A	0.5-1.5	48-16
AG	0.5-3.0	48-8
G	1.75-3.0	14-8
N	3.5-5.0	7-5

Thread specification	Range of thread pitch
ISO metric thread	0.5-6.0
General pitch thread	0.5-5.0
Whitworth thread W	8-19
British taper pipe thread	11-28
Unified thread	8-24
American taper pipe thread	8-27

Thread profile

- ISO—ISO metric 60° thread
- 60—60° general pitch thread
- 55—55° general pitch thread
- W—Whitworth thread
- UN—Unified thread(American standard threads)
- BSPT—British taper pipe thread
- NPT—American taper pipe thread

Chip breaker

- ☐ -fully ground edge insert
- PP -3-Dimensional chip-breaking insert

General turning

Parting and grooving

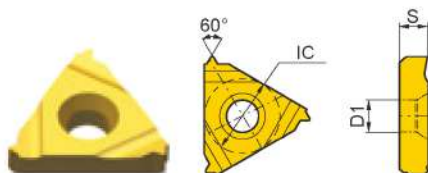
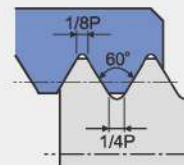
Threading

Threading inserts

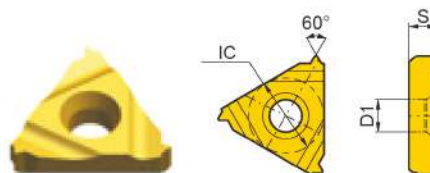


ISO metric thread (with end)

ISO 965-1980 DIN 13
GB/T 197-2003 Tolerance class: 6g/6H



R type



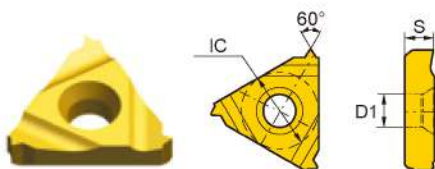
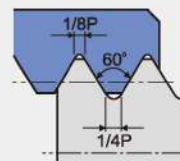
L type

	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch	S	IC	D1	YBG203	YBG205
External thread	Z16ER0.5ISO	Z16EL0.5ISO	0.50	3.52	9.525	4.0	★	○
	Z16ER0.75ISO	Z16EL0.75ISO	0.75	3.52	9.525	4.0	★	○
	Z16ER1.0ISO	Z16EL1.0ISO	1.00	3.52	9.525	4.0	★	○
	Z16ER1.25ISO	Z16EL1.25ISO	1.25	3.52	9.525	4.0	★	○
	Z16ER1.5ISO	Z16EL1.5ISO	1.50	3.52	9.525	4.0	★	○
	Z16ER1.75ISO	Z16EL1.75ISO	1.75	3.52	9.525	4.0	★	○
	Z16ER2.0ISO	Z16EL2.0ISO	2.00	3.52	9.525	4.0	★	○
	Z16ER2.5ISO	Z16EL2.5ISO	2.50	3.52	9.525	4.0	★	○
	Z16ER3.0ISO	Z16EL3.0ISO	3.00	3.52	9.525	4.0	★	○
	Z22ER3.5ISO	Z22EL3.5ISO	3.50	4.65	12.7	5.0	★	○
	Z22ER4.0ISO	Z22EL4.0ISO	4.00	4.65	12.7	5.0	★	○
	Z22ER4.5ISO	Z22EL4.5ISO	4.50	4.65	12.7	5.0	★	○
	Z22ER5.0ISO	Z22EL5.0ISO	5.00	4.65	12.7	5.0	★	○
	Z22ER5.5ISO	Z22EL5.5ISO	5.50	4.65	12.7	5.0	★	○
	Z22ER6.0ISO	Z22EL6.0ISO	6.00	4.65	12.7	5.0	★	○

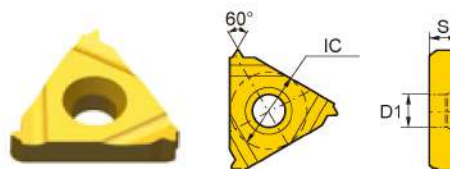
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

ISO metric thread (with end)

ISO 965-1980 DIN 13
GB/T 197-2003 Tolerance class: 6g/6H



R type



L type

	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch	S	IC	D1	YBG203	YBG205
Internal thread	Z11IR0.5ISO	Z11IL0.5ISO	0.50	3.05	6.35	3.2	★	○
	Z11IR0.75ISO	Z11IL0.75ISO	0.75	3.05	6.35	3.2	★	○
	Z11IR1.0ISO	Z11IL1.0ISO	1.00	3.05	6.35	3.2	★	○
	Z11IR1.25ISO	Z11IL1.25ISO	1.25	3.05	6.35	3.2	★	○
	Z11IR1.5ISO	Z11IL1.5ISO	1.50	3.05	6.35	3.2	★	○
	Z11IR1.75ISO	Z11IL1.75ISO	1.75	3.05	6.35	3.2	★	○
	Z11IR2.0ISO	Z11IL2.0ISO	2.00	3.05	6.35	3.2	★	○
	Z16IR0.5ISO	Z16IL0.5ISO	0.50	3.52	9.525	4.0	★	○
	Z16IR0.75ISO	Z16IL0.75ISO	0.75	3.52	9.525	4.0	★	○
	Z16IR1.0ISO	Z16IL1.0ISO	1.00	3.52	9.525	4.0	★	○
	Z16IR1.25ISO	Z16IL1.25ISO	1.25	3.52	9.525	4.0	★	○
	Z16IR1.5ISO	Z16IL1.5ISO	1.50	3.52	9.525	4.0	★	○
	Z16IR1.75ISO	Z16IL1.75ISO	1.75	3.52	9.525	4.0	★	○
	Z16IR2.0ISO	Z16IL2.0ISO	2.00	3.52	9.525	4.0	★	○
	Z16IR2.5ISO	Z16IL2.5ISO	2.50	3.52	9.525	4.0	★	○
	Z16IR3.0ISO	Z16IL3.0ISO	3.00	3.52	9.525	4.0	★	○
	Z22IR3.5ISO	Z22IL3.5ISO	3.50	4.65	12.7	5.0	★	○
	Z22IR4.0ISO	Z22IL4.0ISO	4.00	4.65	12.7	5.0	★	○
	Z22IR4.5ISO	Z22IL4.5ISO	4.50	4.65	12.7	5.0	★	○
	Z22IR5.0ISO	Z22IL5.0ISO	5.00	4.65	12.7	5.0	★	○
	Z22IR5.5ISO	Z22IL5.5ISO	5.50	4.65	12.7	5.0	★	○
	Z22IR6.0ISO	Z22IL6.0ISO	6.00	4.65	12.7	5.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General turning

Parting and grooving

Threading

Threading inserts



General pitch thread (without end)



		Type		Basic dimensions(mm)				Recommended coating grade		
		The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	PAL/R	YBG203	YBG205
External thread	55°	Z16ERA55	Z16ELA55	0.5-1.5(48-16)	3.52	9.525	4.0	55°	★	○
		Z16ERG55	Z16ELG55	1.75-3.0(14-8)	3.52	9.525	4.0	55°	★	○
		Z16ERAG55	Z16ELAG55	0.5-3.0(48-8)	3.52	9.525	4.0	55°	★	○
		Z22ERN55	Z22ELN55	3.5-5.0(7-5)	4.65	12.7	5.0	55°	★	○
	60°	Z16ERA60	Z16ELA60	0.5-1.5(48-16)	3.52	9.525	4.0	60°	★	○
		Z16ERG60	Z16ELG60	1.75-3.0(14-8)	3.52	9.525	4.0	60°	★	○
		Z16ERAG60	Z16ELAG60	0.5-3.0(48-8)	3.52	9.525	4.0	60°	★	○
		Z22ERN60	Z22ELN60	3.5-5.0(7-5)	4.65	12.7	5.0	60°	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

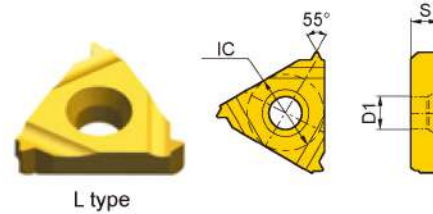
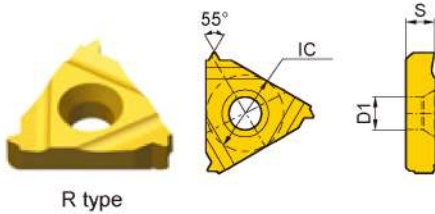
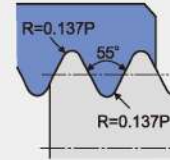


		Type		Basic dimensions(mm)					Recommended coating grade	
		The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	PAL/R	YBG203	YBG205
Internal thread	55°	Z11IRA55	Z11ILA55	0.5-1.5(48-16)	3.05	6.35	3.2	55°	★	○
		Z16IRA55	Z16ILA55	0.5-1.5(48-16)	3.52	9.525	4.0	55°	★	○
		Z16IRG55	Z16ILG55	1.75-3.0(14-8)	3.52	9.525	4.0	55°	★	○
		Z16IRAG55	Z16ILAG55	0.5-3.0(48-8)	3.52	9.525	4.0	55°	★	○
		Z22IRN55	Z22ILN55	3.5-5.0(7-5)	4.65	12.7	5.0	55°	★	○
	60°	Z11IRA60	Z11ILA60	0.5-1.5(48-16)	3.05	6.35	3.2	60°	★	○
		Z16IRA60	Z16ILA60	0.5-1.5(48-16)	3.52	9.525	4.0	60°	★	○
		Z16IRG60	Z16ILG60	1.75-3.0(14-8)	3.52	9.525	4.0	60°	★	○
		Z16IRAG60	Z16ILAG60	0.5-3.0(48-8)	3.52	9.525	4.0	60°	★	○
		Z22IRN60	Z22ILN60	3.5-5.0(7-5)	4.65	12.7	5.0	60°	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

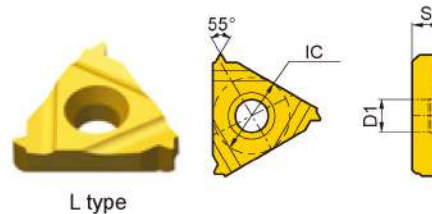
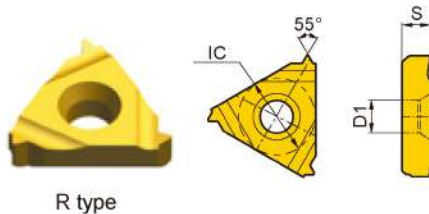
Whitworth thread (with end)

ISO 228/1:1982,
DIN 259, B.S.84:1956
Tolerance class: Medium class A



	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YBG203	YBG205
External thread	Z16ER8W	Z16EL8W	8	3.52	9.525	4.0	★	○
	Z16ER9W	Z16EL9W	9	3.52	9.525	4.0	★	○
	Z16ER10W	Z16EL10W	10	3.52	9.525	4.0	★	○
	Z16ER11W	Z16EL11W	11	3.52	9.525	4.0	★	○
	Z16ER12W	Z16EL12W	12	3.52	9.525	4.0	★	○
	Z16ER14W	Z16EL14W	14	3.52	9.525	4.0	★	○
	Z16ER16W	Z16EL16W	16	3.52	9.525	4.0	★	○
	Z16ER18W	Z16EL18W	18	3.52	9.525	4.0	★	○
	Z16ER19W	Z16EL19W	19	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YBG203	YBG205
Internal thread	Z16IR8W	Z16IL8W	8	3.52	9.525	4.0	★	○
	Z16IR9W	Z16IL9W	9	3.52	9.525	4.0	★	○
	Z16IR10W	Z16IL10W	10	3.52	9.525	4.0	★	○
	Z16IR11W	Z16IL11W	11	3.52	9.525	4.0	★	○
	Z16IR12W	Z16IL12W	12	3.52	9.525	4.0	★	○
	Z16IR14W	Z16IL14W	14	3.52	9.525	4.0	★	○
	Z16IR16W	Z16IL16W	16	3.52	9.525	4.0	★	○
	Z16IR18W	Z16IL18W	18	3.52	9.525	4.0	★	○
	Z16IR19W	Z16IL19W	19	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General turning

Parting and grooving

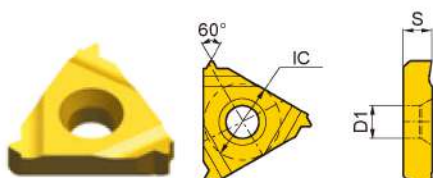
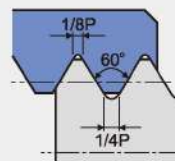
Threading

Threading inserts

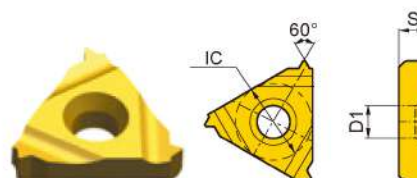


Unified thread (with end)

ASME B1.1-1989
Tolerance class: 2A/2B



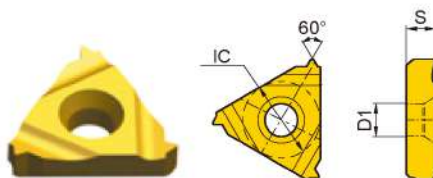
R type



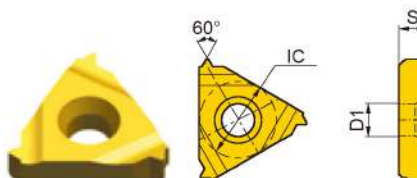
L type

	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YBG203	YBG205
External thread	Z16ER8UN	Z16EL8UN	8	3.52	9.525	4.0	★	○
	Z16ER10UN	Z16EL10UN	10	3.52	9.525	4.0	★	○
	Z16ER12UN	Z16EL12UN	12	3.52	9.525	4.0	★	○
	Z16ER14UN	Z16EL14UN	14	3.52	9.525	4.0	★	○
	Z16ER16UN	Z16EL16UN	16	3.52	9.525	4.0	★	○
	Z16ER18UN	Z16EL18UN	18	3.52	9.525	4.0	★	○
	Z16ER20UN	Z16EL20UN	20	3.52	9.525	4.0	★	○
	Z16ER24UN	Z16EL24UN	24	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



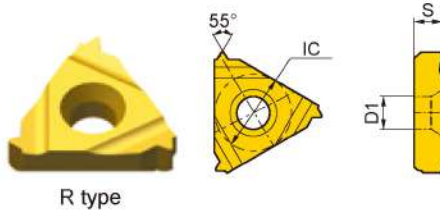
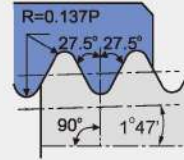
L type

	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YBG203	YBG205
Internal thread	Z16IR8UN	Z16IL8UN	8	3.52	9.525	4.0	★	○
	Z16IR10UN	Z16IL10UN	10	3.52	9.525	4.0	★	○
	Z16IR12UN	Z16IL12UN	12	3.52	9.525	4.0	★	○
	Z16IR14UN	Z16IL14UN	14	3.52	9.525	4.0	★	○
	Z16IR16UN	Z16IL16UN	16	3.52	9.525	4.0	★	○
	Z16IR18UN	Z16IL18UN	18	3.52	9.525	4.0	★	○
	Z16IR20UN	Z16IL20UN	20	3.52	9.525	4.0	★	○
	Z16IR24UN	Z16IL24UN	24	3.52	9.525	4.0	★	○

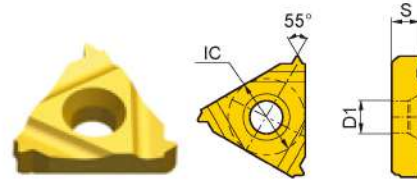
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

British taper pipe thread (with end)

ISO 7/1:1994
B.S.21:1985
Standard BSPT



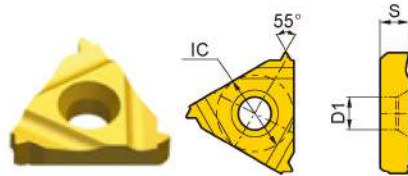
R type



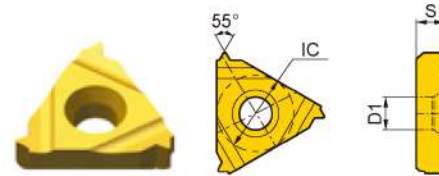
L type

	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YBG203	YBG205
External thread	Z16ER11BSPT	Z16EL11BSPT	11	3.52	9.525	4.0	★	○
	Z16ER14BSPT	Z16EL14BSPT	14	3.52	9.525	4.0	★	○
	Z16ER19BSPT	Z16EL19BSPT	19	3.52	9.525	4.0	★	○
	Z16ER28BSPT	Z16EL28BSPT	28	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



L type

	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YBG203	YBG205
Internal thread	Z16IR11BSPT	Z16IL11BSPT	11	3.52	9.525	4.0	★	○
	Z16IR14BSPT	Z16IL14BSPT	14	3.52	9.525	4.0	★	○
	Z16IR19BSPT	Z16IL19BSPT	19	3.52	9.525	4.0	★	○
	Z16IR28BSPT	Z16IL28BSPT	28	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General turning

Parting and grooving

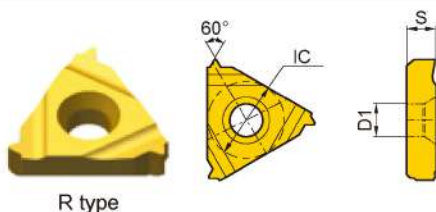
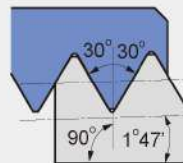
Threading

Threading inserts

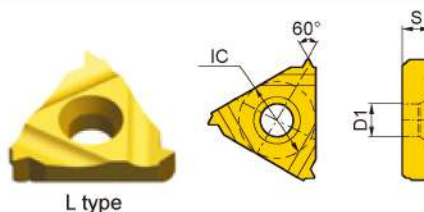


American taper pipe thread (with end)

ASME B1.20.1-1983
Standard NPT



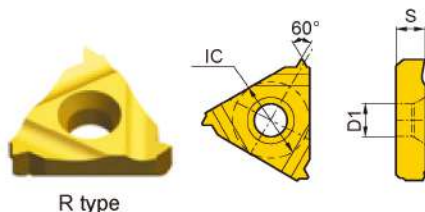
R type



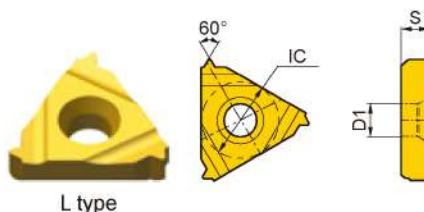
L type

	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YBG203	YBG205
External thread	Z16ER8NPT	Z16EL8NPT	8	3.52	9.525	4.0	★	○
	Z16ER11.5NPT	Z16EL11.5NPT	11.5	3.52	9.525	4.0	★	○
	Z16ER14NPT	Z16EL14NPT	14	3.52	9.525	4.0	★	○
	Z16ER18NPT	Z16EL18NPT	18	3.52	9.525	4.0	★	○
	Z16ER27NPT	Z16EL27NPT	27	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



L type

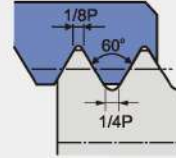
	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YBG203	YBG205
Internal thread	Z16IR8NPT	Z16IL8NPT	8	3.52	9.525	4.0	★	○
	Z16IR11.5NPT	Z16IL11.5NPT	11.5	3.52	9.525	4.0	★	○
	Z16IR14NPT	Z16IL14NPT	14	3.52	9.525	4.0	★	○
	Z16IR18NPT	Z16IL18NPT	18	3.52	9.525	4.0	★	○
	Z16IR27NPT	Z16IL27NPT	27	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

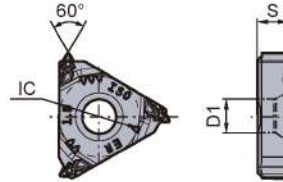
ISO metric thread (with end) PP chipbreaker

ISO 965-1980, DIN 13, GB/T 197-2003

Tolerance class: 6g/6H



R type

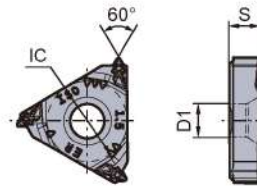


	Type	Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	Pitch	S	IC	D1	YB9120	YBG205
External thread	Z16ER1.0ISOPP	1.00	3.52	9.525	4.0	★	○
	Z16ER1.25ISOPP	1.25	3.52	9.525	4.0	★	○
	Z16ER1.5ISOPP	1.50	3.52	9.525	4.0	★	○
	Z16ER1.75ISOPP	1.75	3.52	9.525	4.0	★	○
	Z16ER2.0ISOPP	2.00	3.52	9.525	4.0	★	○
	Z16ER2.5ISOPP	2.50	3.52	9.525	4.0	★	○
	Z16ER3.0ISOPP	3.00	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



	Type	Basic dimensions(mm)				Recommended coating grade		
	The right hand tools	Pitch	S	IC	D1	YBG205H	YB9120	YBG205
Internal thread	Z11IR1.0ISOPP	1.00	3.05	6.35	3.2	○	★	○
	Z11IR1.25ISOPP	1.25	3.05	6.35	3.2	○	★	○
	Z11IR1.5ISOPP	1.50	3.05	6.35	3.2	○	★	○
	Z16IR1.0ISOPP	1.00	3.52	9.525	4.0		★	○
	Z16IR1.25ISOPP	1.25	3.52	9.525	4.0		★	○
	Z16IR1.5ISOPP	1.50	3.52	9.525	4.0		★	○
	Z16IR1.75ISOPP	1.75	3.52	9.525	4.0		★	○
	Z16IR2.0ISOPP	2.00	3.52	9.525	4.0		★	○
	Z16IR2.5ISOPP	2.50	3.52	9.525	4.0		★	○
	Z16IR3.0ISOPP	3.00	3.52	9.525	4.0		★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General turning

Parting and grooving

Threading

Threading inserts



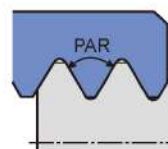
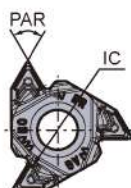
TURNING Threading Tools

Threading inserts

General pitch thread (without end) PP chipbreaker



R type

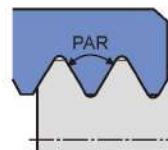


	Type		Basic dimensions(mm)				Recommended coating grade		
		The right hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	PAR	YB9120	YBG205
External thread	55°	Z16ERA55PP	0.5-1.5(48-16)	3.52	9.525	4.0	55°	★	○
		Z16ERG55PP	1.75-3.0(14-8)	3.52	9.525	4.0	55°	★	○
		Z16ERAG55PP	0.5-0.3(48-8)	3.52	9.525	4.0	55°	★	○
		Z22ERN55PP	3.5-5.0(7-5)	4.65	12.7	5.0	55°	★	○
	60°	Z16ERA60PP	0.5-1.5(48-16)	3.52	9.525	4.0	60°	★	○
		Z16ERG60PP	1.75-3.0(14-8)	3.52	9.525	4.0	60°	★	○
		Z16ERAG60PP	0.5-0.3(48-8)	3.52	9.525	4.0	60°	★	○
		Z22ERN60PP	3.5-5.0(7-5)	4.65	12.7	5.0	60°	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



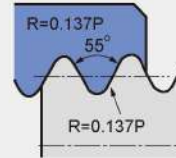
	Type		Basic dimensions(mm)					Recommended coating grade		
		The right hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	PAR	YBG205H	YB9120	YBG205
Internal thread	55°	Z11IRA55PP	0.5-1.5(48-16)	3.05	6.35	3.2	55°	○	★	○
		Z16IRA55PP	0.5-1.5(48-16)	3.52	9.525	4.0	55°		★	○
		Z16IRG55PP	1.75-3.0(14-8)	3.52	9.525	4.0	55°		★	○
		Z16IRAG55PP	0.5-3.0(48-8)	3.52	9.525	4.0	55°		★	○
		Z22IRN55PP	3.5-5.0(7-5)	4.65	12.7	5.0	55°		★	○
	60°	Z11IRA60PP	0.5-1.5(48-16)	3.05	6.35	3.2	60°	○	★	○
		Z16IRA60PP	0.5-1.5(48-16)	3.52	9.525	4.0	60°		★	○
		Z16IRG60PP	1.75-3.0(14-8)	3.52	9.525	4.0	60°		★	○
		Z16IRAG60PP	0.5-3.0(48-8)	3.52	9.525	4.0	60°		★	○
		Z22IRN60PP	3.5-5.0(7-5)	4.65	12.7	5.0	60°		★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

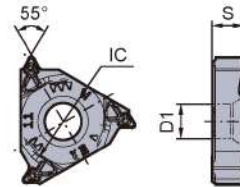
Whitworth thread (with end) PP chipbreaker

ISO 228/1:1982, DIN 259, B.S.84:1956

Tolerance class: Medium class A



R type

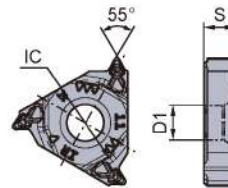


	Type	Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YB9120	YBG205
External thread	Z16ER11WPP	11	3.52	9.525	4.0	★	○
	Z16ER14WPP	14	3.52	9.525	4.0	★	○
	Z16ER19WPP	19	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



	Type	Basic dimensions(mm)				Recommended coating grade		
	The right hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YBG205H	YB9120	YBG205
Internal thread	Z11IR14WPP	14	3.05	6.35	3.2	○	★	
	Z16IR11WPP	11	3.52	9.525	4.0		★	○
	Z16IR14WPP	14	3.52	9.525	4.0		★	○
	Z16IR19WPP	19	3.52	9.525	4.0		★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General
turningParting and
grooving

Threading

Threading inserts



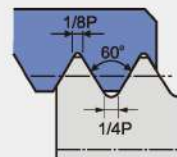
TURNING Threading Tools

Threading inserts

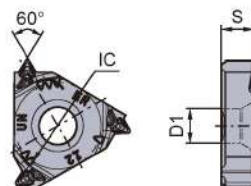
Unified thread (with end) PP chipbreaker

ASME B1.1-1989

Tolerance class: 2A/2B



R type

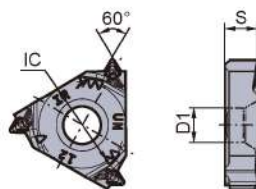


	Type	Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YB9120	YBG205
External thread	Z16ER12UNPP	12	3.52	9.525	4.0	★	○
	Z16ER14UNPP	14	3.52	9.525	4.0	★	○
	Z16ER16UNPP	16	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



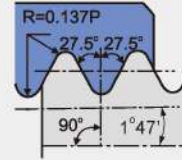
	Type	Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YB9120	YBG205
Internal thread	Z16IR12UNPP	12	3.52	9.525	4.0	★	○
	Z16IR14UNPP	14	3.52	9.525	4.0	★	○
	Z16IR16UNPP	16	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

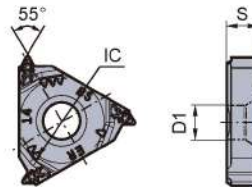
British taper pipe thread (with end)

PP chipbreaker

ISO 7/1: 1994, B.S.21:1985
Standard BSPT



R type

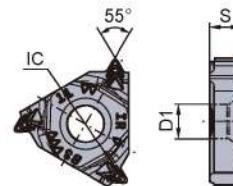


	Type	Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YB9120	YBG205
External thread	Z16ER11BSPTPP	11	3.52	9.525	4.0	★	○
	Z16ER14BSPTPP	14	3.52	9.525	4.0	★	○
	Z16ER19BSPTPP	19	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



	Type	Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YB9120	YBG205
Internal thread	Z16IR11BSPTPP	11	3.52	9.525	4.0	★	○
	Z16IR14BSPTPP	14	3.52	9.525	4.0	★	○
	Z16IR19BSPTPP	19	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General
turningParting and
grooving

Threading

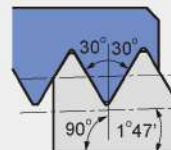
Threading inserts



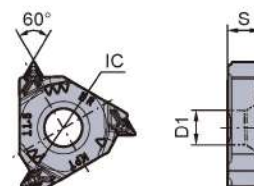
American taper pipe thread (with end)

PP chipbreaker

ASME B1.20.1-1983
Standard NPT



R type

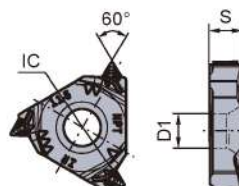


	Type	Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YB9120	YBG205
External thread	Z16ER11.5NPTPP	11.5	3.52	9.525	4.0	★	○
	Z16ER14NPTPP	14	3.52	9.525	4.0	★	○
	Z16ER18NPTPP	18	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



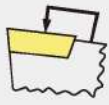
	Type	Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	Pitch/mm (pitch/Inch)	S(mm)	IC(mm)	D1(mm)	YB9120	YBG205
Internal thread	Z16IR11.5NPTPP	11.5	3.52	9.525	4.0	★	○
	Z16IR14NPTPP	14	3.52	9.525	4.0	★	○
	Z16IR18NPTPP	18	3.52	9.525	4.0	★	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

Threading tools code key

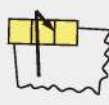
Clamping system

Top clamping



ZC

Screw clamping



ZS

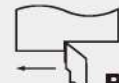
Thread type

I > Internal thread

E > External thread

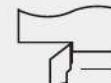
Cutting direction

Right hand



R

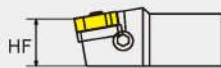
Left hand



L

ZS E R 20 20 K 16 (C)

Nose height (mm)



Note: 00 for round tool holder.
Only to integer, for example: h=8mm is labeled as 08.

Shank width (mm)



Note: Diameter for round tool holder
for example: b=8mm is labeled as 08.

Tool length (mm)

Code	H	K	M	P	Q	R	S	T	U
Length	100	125	150	170	180	200	250	300	350

Insert size (mm)

Code	11	16	22
Triangle side length	11	16	22
Inscribed circle	6.35	9.525	12.70

C—Inner-cooling

General turning

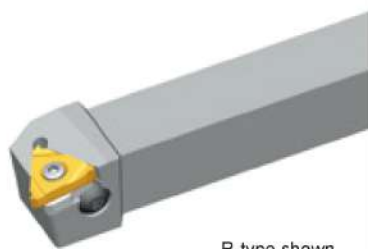
Parting and grooving

Threading

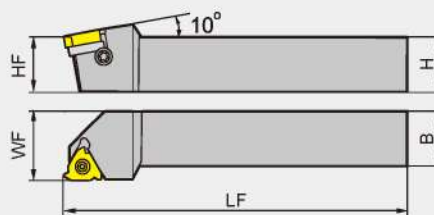
Threading tools



External threading tools



R-type shown

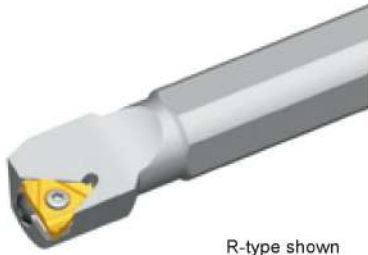


Type		Stock	Basic dimensions(mm)					Applicable inserts	Inserts screw	Shim	Shim screw	Wrench
			H	HF	B	LF	WF					
ZSER	1616H16	▲	16	16	16	100	20	Z16ER□□□□	I60 M3.5×12TT	MT16-□□MN	SM4×8C	WT10IP
	2020K16	▲	20	20	20	125	25					
	2525M16	▲	25	25	25	150	32					
	3225P16	▲	32	32	25	170	32					
	3232P16	▲	32	32	32	170	40					
	2525M22	▲	25	25	25	150	32	Z22ER□□□□	I60 M4×15X	MT22-□□MN	SM5×8.5	WT15IP
	3225P22	▲	32	32	25	170	32					
	3232P22	▲	32	32	32	170	40					
	4040S22	△	40	40	40	250	50					
ZSEL	1616H16	▲	16	16	16	100	20	Z16EL□□□□	I60 M3.5×12TT	MT16-□□MN	SM4×8C	WT10IP
	2020K16	▲	20	20	20	125	25					
	2525M16	▲	25	25	25	150	32					
	3225P16	▲	32	32	25	170	32					
	3232P16	▲	32	32	32	170	40					
	2525M22	▲	25	25	25	150	32	Z22EL□□□□	I60 M4×15X	MT22-□□MN	SM5×8.5	WT15IP
	3225P22	▲	32	32	25	170	32					
	3232P22	▲	32	32	32	170	40					
	4040S22	△	40	40	40	250	50					

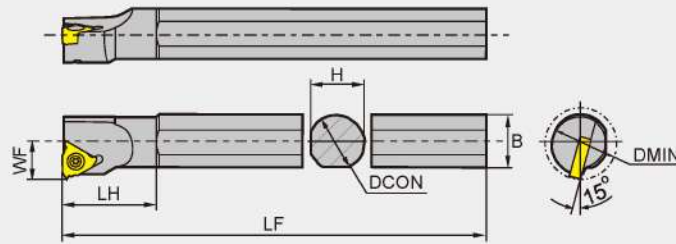
▲Stock available

△Make-to-order

Internal threading tools



R-type shown



Type	Stock	Basic dimensions(mm)								Applicable inserts	Inserts screw	Shim	Shim screw	Wrench
		DCON	LF	B	DMIN	WF	H	LH						
ZSIR	0016K11	▲	16	125	15.5	12	10	15	20.9	Z11IR□□□□	I60 M2.5×6.5T	---	---	WT08IP
	0016M11	▲	16	150	16	16	10.5	15	25.9					
	0016M16	▲	16	150	15.5	20	12	15	27		I60 M3.5×08TT	---	---	
	0020M16	▲	20	150	19	25	14	18	28.7					
	0020Q16	▲	20	180	19	25	14	18	34					
	0025M16	▲	25	150	24	32	17	23	28.8	Z16IR□□□□				
	0032R16	▲	32	200	31	40	22	30	30.9		I60 M3.5×12TT	MT16-□□MN	SM4×8C	WT10IP
	0032S16	▲	32	250	31	40	22	30	30.9					
	0040T16	▲	40	300	38.5	50	27	37	31.5					
	0050U16	▲	50	350	48.5	63	35	49	40.2					
	0020Q22	▲	20	180	19	25	15	18	35		I60 M5×13.2	---	---	
	0025R22	▲	25	200	24	32	19	23	39					
	0032S22	▲	32	250	31	40	22	30	36.4	Z22IR□□□□				
	0040T22	▲	40	300	38.5	50	27	37	37.2		I60 M4×15X	MT22-□□MN	SM5×8.5	WT15IP
	0050U22	▲	50	350	48.5	63	35	47	42.6					
ZSIL	0016K11	▲	16	125	15.5	12	10	15	20.9	Z11IL□□□□	I60 M2.5×6.5T	---	---	WT08IP
	0016M11	▲	16	150	16	16	10.5	15	25.9					
	0016M16	▲	16	150	16	20	12	15	27		I60 M3.5×08TT	---	---	
	0020M16	▲	20	150	19	25	14	18	28.7					
	0020Q16	▲	20	180	19	25	14	18	34					
	0025M16	▲	25	150	24	32	17	23	28.8	Z16IL□□□□				
	0032R16	▲	32	200	31	40	22	30	30.9		I60 M3.5×12	MT16-□□MN	SM4×8C	WT10IP
	0032S16	▲	32	250	31	40	22	30	30.9					
	0040T16	▲	40	300	38.5	50	27	37	31.5					
	0050U16	▲	50	350	48.5	63	35	49	40.2					
	0020Q22	▲	20	180	19	25	15	18	35		I60 M5×13.2	---	---	
	0025R22	▲	25	200	24	32	19	23	39					
	0032S22	▲	32	250	31	40	22	30	36.4	Z22IL□□□□				
	0040T22	▲	40	300	38.5	50	27	37	37.2		I60 M4×15X	MT22-□□MN	SM5×8.5	WT15IP
	0050U22	▲	50	350	48.5	63	35	47	42.6					

▲Stock available

△Make-to-order

General turning

Parting and grooving

Threading

Threading tools



TURNING Threading Tools

Thick threading inserts

Thick threading inserts code key

General turning

Parting and grooving

Threading

Thick threading inserts

Cutting direction

R ➤ Right L ➤ Left

Insert



T

Others

Z

Insert size

- 22 ➤ Diameter of IC ø12.7
- 16 ➤ Diameter of IC ø9.525
- 11 ➤ Diameter of IC ø6.35

Number of cutting edge pitch

- 01 ➤ Number of pitch per cutting edge

Cutting style

- W ➤ External threading insert
- N ➤ Internal threading insert

R T 22. 01 W- 4.50 GM

Thread pitch

full profile(range of Thread pitch is indicated by numbers)

mm	TPI
0.35-0.9	72-2

V profile (range of Thread pitch is indicated by numbers)

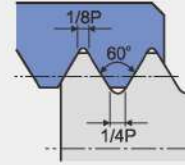
letter	mm	TPI
A	0.5-1.5	48-16
AG	0.5-3.0	48-8
G	1.75-3.0	14-8
N	3.5-5.0	7-5
Q	5.5-6.0	4 1/2-4

Thread profile

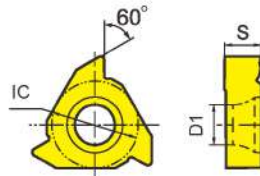
- GM**—ISO metric 60°thread
- 60**—60° general pitch thread
- 55**—55° general pitch thread
- W**—Whitworth thread
- UN**—Unified thread
- BSPT**—British taper pipe thread
- NPT**—American taper pipe thread

ISO metric thread (with end)

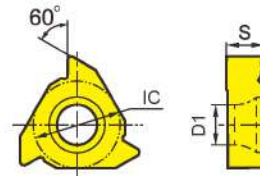
ISO 965-1980 DIN 13
GB/T 197-2003 Tolerance class: 6g/6H



R type



L type



	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch	S	IC	D1	YBG201	
							R	L
External thread	RT16.01W-0.50GM	LT16.01W-0.50GM	0.50	3.97	9.525	4.4	○	○
	RT16.01W-0.75GM	LT16.01W-0.75GM	0.75	3.97	9.525	4.4	○	○
	RT16.01W-1.00GM	LT16.01W-1.00GM	1.00	3.97	9.525	4.4	○	○
	RT16.01W-1.25GM	LT16.01W-1.25GM	1.25	3.97	9.525	4.4	★	○
	RT16.01W-1.50GM	LT16.01W-1.50GM	1.50	3.97	9.525	4.4	★	★
	RT16.01W-1.75GM	LT16.01W-1.75GM	1.75	3.97	9.525	4.4	★	○
	RT16.01W-2.00GM	LT16.01W-2.00GM	2.00	3.97	9.525	4.4	★	★
	RT16.01W-2.50GM	LT16.01W-2.50GM	2.50	3.97	9.525	4.4	★	○
	RT16.01W-3.00GM	LT16.01W-3.00GM	3.00	3.97	9.525	4.4	★	○
	RT22.01W-3.50GM	LT22.01W-3.50GM	3.50	5.56	12.7	5.5	★	○
	RT22.01W-4.00GM	LT22.01W-4.00GM	4.00	5.56	12.7	5.5	★	○
	RT22.01W-4.50GM	LT22.01W-4.50GM	4.50	5.56	12.7	5.5	★	○
	RT22.01W-5.00GM	LT22.01W-5.00GM	5.00	5.56	12.7	5.5	★	○
	RT22.01W-5.50GM	LT22.01W-5.50GM	5.50	5.56	12.7	5.5	○	○
	RT22.01W-6.00GM	LT22.01W-6.00GM	6.00	5.56	12.7	5.5	★	○

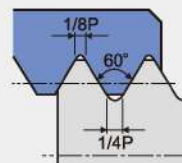
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



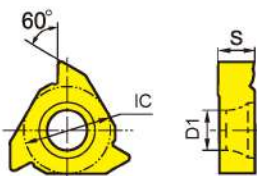


ISO metric thread (with end)

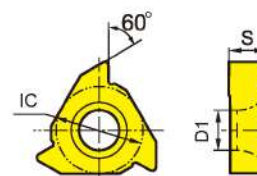
ISO 965-1980 DIN 13
GB/T 197-2003 Tolerance class: 6g/6H



R type



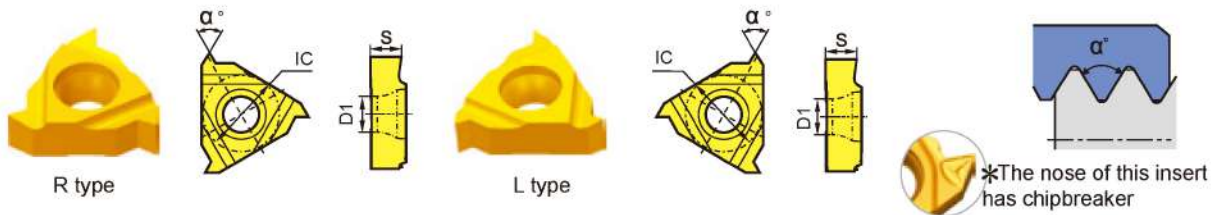
L type



	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch	S	IC	D1	YBG201	
							R	L
Internal thread	RT11.01N-0.50GM	LT11.01N-0.50GM	0.50	3.18	6.35	2.8	○	○
	RT11.01N-0.75GM	LT11.01N-0.75GM	0.75	3.18	6.35	2.8	○	○
	RT11.01N-1.00GM	LT11.01N-1.00GM	1.00	3.18	6.35	2.8	○	○
	RT11.01N-1.25GM	LT11.01N-1.25GM	1.25	3.18	6.35	2.8	○	○
	RT11.01N-1.50GM	LT11.01N-1.50GM	1.50	3.18	6.35	2.8	★	○
	RT11.01N-1.75GM	LT11.01N-1.75GM	1.75	3.18	6.35	2.8	○	○
	RT11.01N-2.00GM	LT11.01N-2.00GM	2.00	3.18	6.35	2.8	★	○
	RT16.01N-0.50GM	LT16.01N-0.50GM	0.50	3.97	9.525	4.4	○	○
	RT16.01N-0.75GM	LT16.01N-0.75GM	0.75	3.97	9.525	4.4	○	○
	RT16.01N-1.00GM	LT16.01N-1.00GM	1.00	3.97	9.525	4.4	★	○
	RT16.01N-1.25GM	LT16.01N-1.25GM	1.25	3.97	9.525	4.4	○	○
	RT16.01N-1.50GM	LT16.01N-1.50GM	1.50	3.97	9.525	4.4	★	★
	RT16.01N-1.75GM	LT16.01N-1.75GM	1.75	3.97	9.525	4.4	○	○
	RT16.01N-2.00GM	LT16.01N-2.00GM	2.00	3.97	9.525	4.4	★	★
	RT16.01N-2.50GM	LT16.01N-2.50GM	2.50	3.97	9.525	4.4	★	★
	RT16.01N-3.00GM	LT16.01N-3.00GM	3.00	3.97	9.525	4.4	★	★
	RT22.01N-3.50GM	LT22.01N-3.50GM	3.50	5.56	12.7	5.5	○	○
	RT22.01N-4.00GM	LT22.01N-4.00GM	4.00	5.56	12.7	5.5	★	○
	RT22.01N-4.50GM	LT22.01N-4.50GM	4.50	5.56	12.7	5.5	○	○
	RT22.01N-5.00GM	LT22.01N-5.00GM	5.00	5.56	12.7	5.5	★	○
	RT22.01N-5.50GM	LT22.01N-5.50GM	5.50	5.56	12.7	5.5	○	○
	RT22.01N-6.00GM	LT22.01N-6.00GM	6.00	5.56	12.7	5.5	★	○

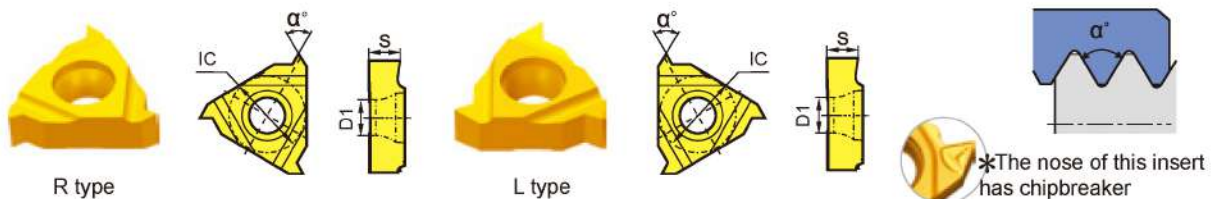
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General pitch thread (without end)



		Type		Basic dimensions(mm)					Recommended coating grade	
		The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	α°	YBG201	
									R	L
External thread	60°	RT16.01W-A60	LT16.01W-A60	0.5-1.5(48-16)	3.97	9.525	4.4	60°	★	○
		RT16.01W-G60	LT16.01W-G60	1.75-3.0(14-8)	3.97	9.525	4.4	60°	○	○
		RT16.01W-G60P*	LT16.01W-G60P*	1.75-3.0(14-8)	3.97	9.525	4.4	60°	★	○
		RT16.01W-AG60	LT16.01W-AG60	0.5-3.0(48-8)	3.97	9.525	4.4	60°	★	○
		RT22.01W-N60P*	LT22.01W-N60P*	3.5-5.0(7-5)	5.56	12.7	5.5	60°	○	○
	55°	RT16.01W-A55	LT16.01W-A55	0.5-1.5(48-16)	3.97	9.525	4.4	55°	○	○
		RT16.01W-G55	LT16.01W-G55	1.75-3.0(14-8)	3.97	9.525	4.4	55°	○	○
		RT16.01W-G55P*	LT16.01W-G55P*	1.75-3.0(14-8)	3.97	9.525	4.4	55°	★	★
		RT16.01W-AG55	LT16.01W-AG55	0.5-3.0(48-8)	3.97	9.525	4.4	55°	★	○
		RT22.01W-N55P*	LT22.01W-N55P*	3.5-5.0(7-5)	5.56	12.7	5.5	55°	○	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



		Type		Basic dimensions(mm)					Recommended coating grade	
		The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	α°	YBG201	
									R	L
Internal thread	60°	RT16.01N-A60	LT16.01N-A60	0.5-1.5 (48-16)	3.97	9.525	4.4	60°	○	○
		RT16.01N-G60	LT16.01N-G60	1.75-3.0(14-8)	3.97	9.525	4.4	60°	○	○
		RT16.01N-G60P*	LT16.01N-G60P*	1.75-3.0(14-8)	3.97	9.525	4.4	60°	★	○
		RT16.01N-AG60	LT16.01N-AG60	0.5-3.0 (48-8)	3.97	9.525	4.4	60°	★	○
		RT22.01N-N60P*	LT22.01N-N60P*	3.5-5.0 (7-5)	5.56	12.7	5.5	60°	○	○
	55°	RT16.01N-A55	LT16.01N-A55	0.5-1.5(48-16)	3.97	9.525	4.4	55°	○	○
		RT16.01N-G55	LT16.01N-G55	1.75-3.0(14-8)	3.97	9.525	4.4	55°	○	○
		RT16.01N-G55P*	LT16.01N-G55P*	1.75-3.0(14-8)	3.97	9.525	4.4	55°	★	○
		RT16.01N-AG55	LT16.01N-AG55	0.5-3.0(48-8)	3.97	9.525	4.4	55°	★	○
		RT22.01N-N55P*	LT22.01N-N55P*	3.5-5.0(7-5)	5.56	12.7	5.5	55°	○	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General turning

Parting and grooving

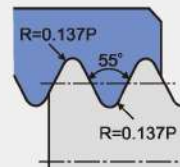
Threading

Thick threading inserts

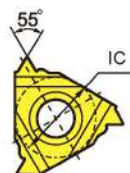


Whitworth thread (with end)

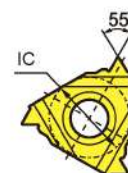
ISO 228/1:1982,
DIN 259, B.S.84:1956
Tolerance class: Medium class A



R type



L type



	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	YBG201	
							R	L
External thread	RT16.01W-8W	LT16.01W-8W	8	3.97	9.525	4.4	○	○
	RT16.01W-9W	LT16.01W-9W	9	3.97	9.525	4.4	○	○
	RT16.01W-10W	LT16.01W-10W	10	3.97	9.525	4.4	○	○
	RT16.01W-11W	LT16.01W-11W	11	3.97	9.525	4.4	○	○
	RT16.01W-12W	LT16.01W-12W	12	3.97	9.525	4.4	○	○
	RT16.01W-14W	LT16.01W-14W	14	3.97	9.525	4.4	○	○
	RT16.01W-16W	LT16.01W-16W	16	3.97	9.525	4.4	○	○

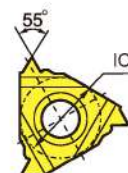
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



L type

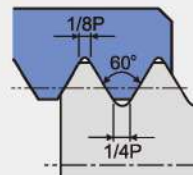


	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	YBG201	
							R	L
Internal thread	RT16.01N-8W	LT16.01N-8W	8	3.97	9.525	4.4	○	○
	RT16.01N-9W	LT16.01N-9W	9	3.97	9.525	4.4	○	○
	RT16.01N-10W	LT16.01N-10W	10	3.97	9.525	4.4	○	○
	RT16.01N-11W	LT16.01N-11W	11	3.97	9.525	4.4	○	○
	RT16.01N-12W	LT16.01N-12W	12	3.97	9.525	4.4	○	○
	RT16.01N-14W	LT16.01N-14W	14	3.97	9.525	4.4	○	○
	RT16.01N-16W	LT16.01N-16W	16	3.97	9.525	4.4	○	○

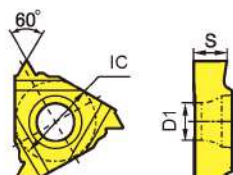
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

Unified thread (with end)

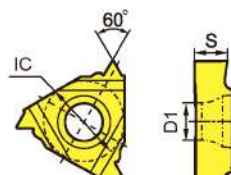
ASME B1.1-1989
Tolerance class: 2A/2B



R type



L type

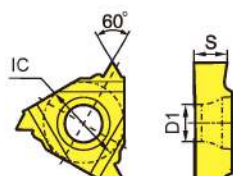


	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	YBG201	
							R	L
External thread	RT16.01W-8UN	LT16.01W-8UN	8	3.97	9.525	4.4	○	○
	RT16.01W-10UN	LT16.01W-10UN	10	3.97	9.525	4.4	○	○
	RT16.01W-12UN	LT16.01W-12UN	12	3.97	9.525	4.4	○	○
	RT16.01W-14UN	LT16.01W-14UN	14	3.97	9.525	4.4	○	○
	RT16.01W-16UN	LT16.01W-16UN	16	3.97	9.525	4.4	○	○
	RT16.01W-18UN	LT16.01W-18UN	18	3.97	9.525	4.4	○	○
	RT16.01W-20UN	LT16.01W-20UN	20	3.97	9.525	4.4	○	○

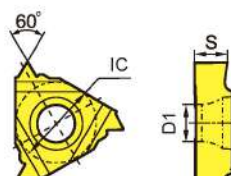
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



L type



	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	YBG201	
							R	L
Internal thread	RT16.01N-8UN	LT16.01N-8UN	8	3.97	9.525	4.4	○	○
	RT16.01N-10UN	LT16.01N-10UN	10	3.97	9.525	4.4	○	○
	RT16.01N-12UN	LT16.01N-12UN	12	3.97	9.525	4.4	○	○
	RT16.01N-14UN	LT16.01N-14UN	14	3.97	9.525	4.4	○	○
	RT16.01N-16UN	LT16.01N-16UN	16	3.97	9.525	4.4	○	○
	RT16.01N-18UN	LT16.01N-18UN	18	3.97	9.525	4.4	○	○
	RT16.01N-20UN	LT16.01N-20UN	20	3.97	9.525	4.4	○	○
	RT16.01N-24UN	LT16.01N-24UN	24	3.97	9.525	4.4	○	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General turning

Parting and grooving

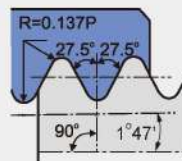
Threading

Thick threading inserts

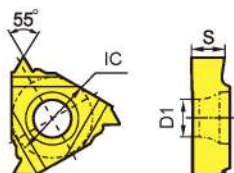


British taper pipe thread (with end)

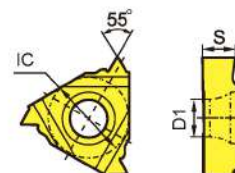
ISO 7/1: 1994
B.S.21: 1985
Standard BSPT



R type



L type

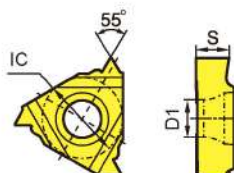


	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	YBG201	
							R	L
External thread	RT16.01W-11 BSPT	LT16.01W-11 BSPT	11	3.97	9.525	4.4	○	○
	RT16.01W-14 BSPT	LT16.01W-14 BSPT	14	3.97	9.525	4.4	○	○
	RT16.01W-19 BSPT	LT16.01W-19 BSPT	19	3.97	9.525	4.4	○	○
	RT16.01W-28 BSPT	LT16.01W-28 BSPT	28	3.97	9.525	4.4	○	○

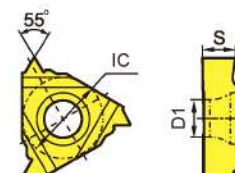
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



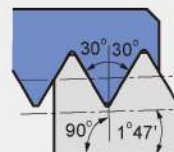
L type



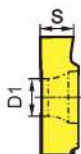
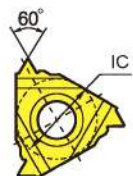
	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	YBG201	
							R	L
Internal thread	RT16.01N-11 BSPT	LT16.01N-11 BSPT	11	3.97	9.525	4.4	○	○
	RT16.01N-14 BSPT	LT16.01N-14 BSPT	14	3.97	9.525	4.4	○	○
	RT16.01N-19 BSPT	LT16.01N-19 BSPT	19	3.97	9.525	4.4	○	○
	RT16.01N-28 BSPT	LT16.01N-28 BSPT	28	3.97	9.525	4.4	○	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

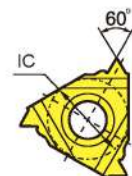
American taper pipe thread (with end)

ASME B1.20.1-1983
Standard NPT

R type



L type

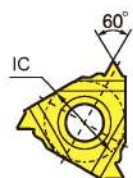


	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	YBG201	
							R	L
External thread	RT16.01W-8NPT	LT16.01W-8NPT	8	3.97	9.525	4.4	○	○
	RT16.01W-11.5 NPT	LT16.01W-11.5NPT	11.5	3.97	9.525	4.4	○	○
	RT16.01W-14NPT	LT16.01W-14NPT	14	3.97	9.525	4.4	○	○
	RT16.01W-18NPT	LT16.01W-18NPT	18	3.97	9.525	4.4	○	○
	RT16.01W-27NPT	LT16.01W-27NPT	27	3.97	9.525	4.4	○	○

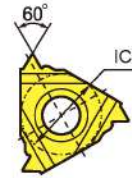
★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order



R type



L type



	Type		Basic dimensions(mm)				Recommended coating grade	
	The right hand tools	The left hand tools	Pitch/mm (pitch/Inch)	S	IC	D1	YBG201	
							R	L
Internal thread	RT16.01N-8NPT	LT16.01N-8NPT	8	3.97	9.525	4.4	○	○
	RT16.01N-11.5NPT	LT16.01N-11.5NPT	11.5	3.97	9.525	4.4	○	○
	RT16.01N-14NPT	LT16.01N-14NPT	14	3.97	9.525	4.4	○	○
	RT16.01N-18NPT	LT16.01N-18NPT	18	3.97	9.525	4.4	○	○
	RT16.01N-27NPT	LT16.01N-27NPT	27	3.97	9.525	4.4	○	○

★Recommended grade (always stock available) ●Available grade (always stock available) ○Make-to-order

General turning

Parting and grooving

Threading

Thick threading inserts

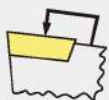


Thick threading insert tools code key

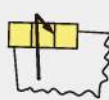
Clamping system

Top clamping

Screw clamping



C



S

Thread type

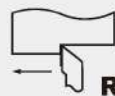
N > Internal thread

W > External thread

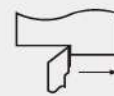
Cutting direction

Right hand

Left hand



R



L

S

W

R

20

20

K

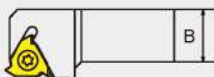
16

Nose height (mm)



Note: 00 for round tool holder.
Only to integer, for example: h=8mm is labeled as 08.

Shank width (mm)



Note: Diameter for round tool holder
for example: b=8mm is labeled as 08.

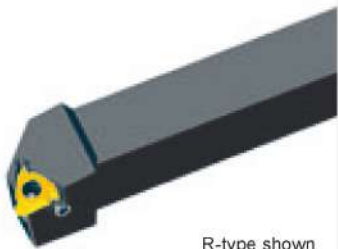
Tool length (mm)

Code	H	K	M	P	Q	R	S	T	U
Length	100	125	150	170	180	200	250	300	350

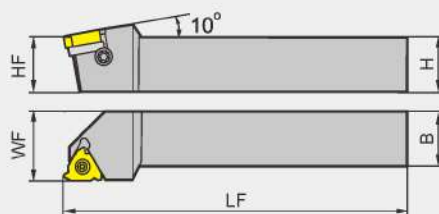
Insert size (mm)

Code	11	16	22
Triangle side length	11	16	22
Diameter of IC	6.35	9.525	12.70

External threading tools



R-type shown



Type		Stock	Basic dimensions(mm)					Applicable inserts	Inserts screw	Shim	Shim screw	Wrench
			H	HF	B	LF	WF					
SWR	1616H16	▲	16	16	16	100	20	RT16.01W-□□□□	I60M3.5×12	MT16-□□M	SM4×8C	WT15IP
	2020K16	▲	20	20	20	125	25					
	2525M16	▲	25	25	25	150	32					
	3225P16	▲	32	32	25	170	32					
	3232P16	▲	32	32	32	170	40					
	2525M22	▲	25	25	25	150	32	RT22.01W-□□□□	I60M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	3225P22	▲	32	32	25	170	32					
	3232P22	▲	32	32	32	170	40					
	4040S22	△	40	40	40	250	50					
SWL	1616H16	▲	16	16	16	100	20	LT16.01W-□□□□	I60M3.5×12	MT16-□□M	SM4×8C	WT15IP
	2020K16	▲	20	20	20	125	25					
	2525M16	▲	25	25	25	150	32					
	3225P16	▲	32	32	25	170	32					
	3232P16	▲	32	32	32	170	40					
	2525M22	▲	25	25	25	150	32	LT22.01W-□□□□	I60M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	3225P22	▲	32	32	25	170	32					
	3232P22	▲	32	32	32	170	40					
	4040S22	△	40	40	40	250	50					

▲Stock available

△Make-to-order

General turning

Parting and grooving

Threading

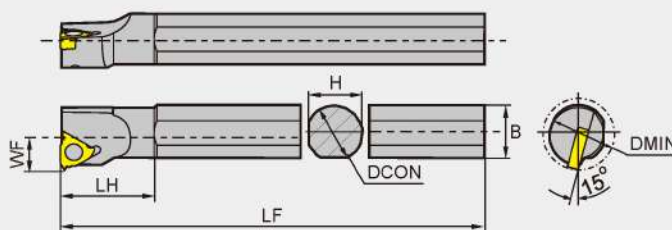
Tools for thick threading insert



Internal threading tools



R-type shown



Type	Stock	Basic dimensions(mm)								Applicable inserts	Inserts screw	Shim	Shim screw	Wrench
		DCON	LF	B	DMIN	WF	H	LH						
SNR	0016K11	▲	16	125	16	12	10	15	20.9	RT11.01N-□□□□	I60 M2.5×6.5	---	---	WT07IP
	0016M11	▲	16	150	15.5	16	10.5	15	25.9		I60 M3.5×8	---	---	WT15IP
	0016M16	▲	16	150	15.5	20	12	15	27		I60 M3.5×12	MT16-□□M	SM4×8C	WT15IP
	0020M16	▲	20	150	19	25	14	18	28.7	RT16.01N-□□□□	I60 M3.5×12	MT16-□□M	SM4×8C	WT15IP
	0020Q16	▲	20	180	19	25	14	18	34		I60 M5×10	---	---	WT20IP
	0025M16	▲	25	150	24	32	17	23	28.8		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0032R16	▲	32	200	31	40	22	30	30.9		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0032S16	▲	32	250	31	40	22	30	30.9		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0040T16	▲	40	300	38.5	50	27	37	31.5		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0050U16	▲	50	350	49.5	63	35	49	40.2		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0020Q22	▲	20	180	21.5	25	15	18	35	RT22.01N-□□□□	I60 M5×10	---	---	WT20IP
	0025R22	▲	25	200	24	32	19	23	39		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0032S22	▲	32	250	31	40	22	30	36.4		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0040T22	▲	40	300	38.5	50	27	37	37.2	LT16.01N-□□□□	I60 M5×10	---	---	WT20IP
	0050U22	▲	50	350	48.5	63	35	47	42.6		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0016K11	▲	16	125	16	12	10	15	20.9		I60 M2.5×6.5	---	---	WT07IP
	0016M11	▲	16	150	15.5	16	10.5	15	25.9		I60 M3.5×8	---	---	WT15IP
	0016M16	▲	16	150	15.5	20	12	15	27		I60 M3.5×12	MT16-□□M	SM4×8C	WT15IP
SNL	0020M16	▲	20	150	19	25	14	18	28.7	LT16.01N-□□□□	I60 M3.5×12	MT16-□□M	SM4×8C	WT15IP
	0020Q16	▲	20	180	19	25	14	18	34		I60 M5×10	---	---	WT20IP
	0025M16	▲	25	150	24	32	17	23	28.8		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0032R16	▲	32	200	31	40	22	30	30.9		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0032S16	▲	32	250	31	40	22	30	30.9		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0040T16	▲	40	300	38.5	50	27	37	31.5		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0050U16	▲	50	350	49.5	63	35	49	40.2	LT22.01N-□□□□	I60 M5×10	---	---	WT20IP
	0020Q22	▲	20	180	21.5	25	15	18	35		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0025R22	▲	25	200	24	32	19	23	39		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0032S22	▲	32	250	31	40	22	30	36.4	LT22.01N-□□□□	I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0040T22	▲	40	300	38.5	50	27	37	37.2		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP
	0050U22	▲	50	350	48.5	63	35	47	42.6		I60 M5×17	MT22-□□M	SM4×8C	WT15IP WT20IP

▲Stock available

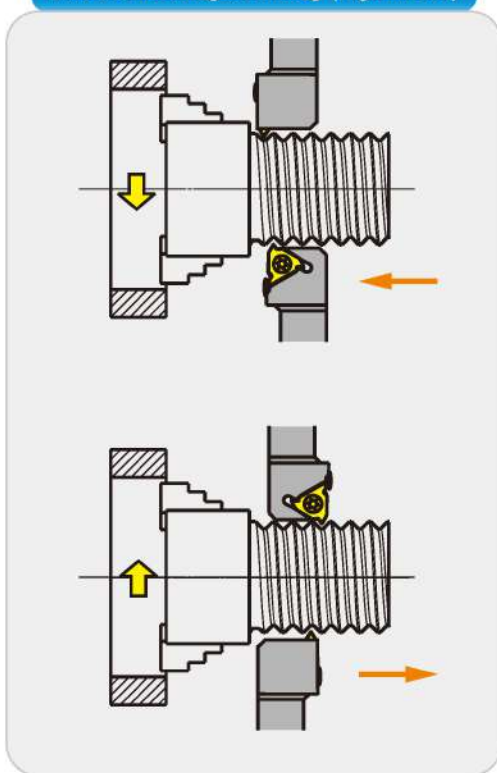
△Make-to-order

Please follow the steps to get the best threading result:

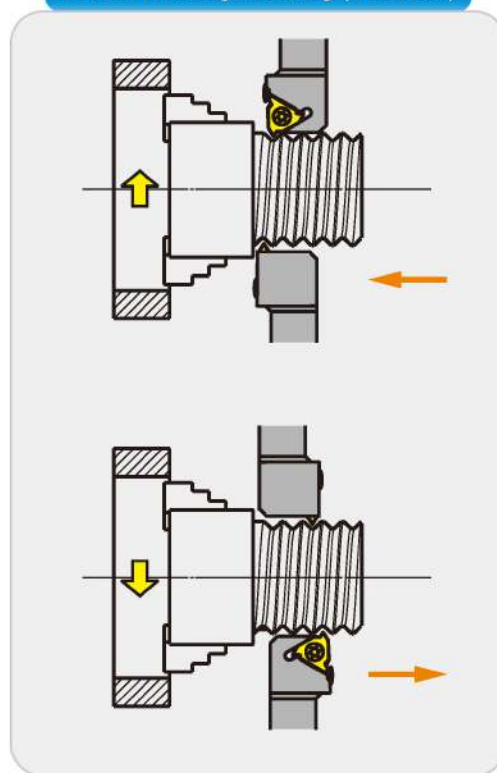
- 1 Select proper thread machining method.
- 2 Define helical angle and select shim.
- 3 Select proper insert and tool holder size.
- 4 By checking reference table of standard threading programs, select feasible cutting parameters.
- 5 Select feed way.

Machining method of threading tools

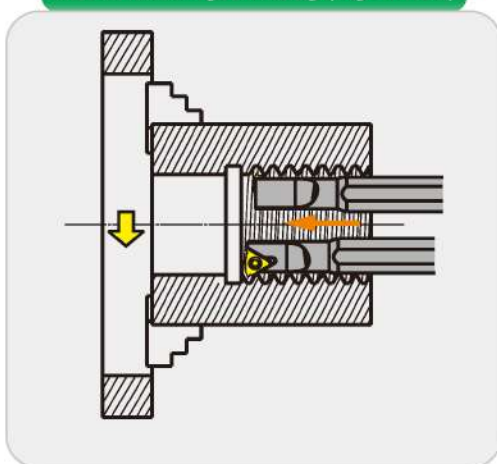
External threading machining (Right thread)



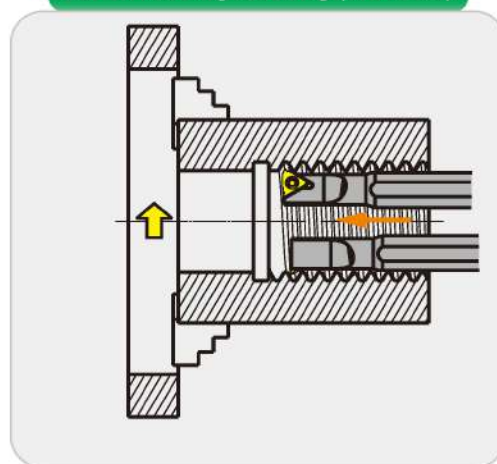
External threading machining (Left thread)



Internal threading machining (Right thread)



Internal threading machining (Left thread)





Decide helical angle and select shim

The clearance angle of threading inserts is actually along the edge (flank). This has significant effect on heat diffusion, spread of abrasion as well as tool life, security and pitch quality. The clearance angle of threading pitch on clearance face is determined by thread helical angle. These two angles are similar to each other to some extent. If inclined angle of insert is different from the helical angle, then the clearance angle won't be the same either.

The helical angle of pitch has to be the same with the inclined angle of insert to prevent over wearing on the clearance face which could affect tool life. the helical angle is calculated as below:

$$\theta = \arctan \frac{P}{d_2 \times \pi}$$

P= Pitch

d₂= pitch diameter

The most common inclined angle is 1°.

MT standard shim and its inclined angle is also 1°.

Calculation of clearance angle:

Clearance angle is calculated as below:

$$\beta = \arctan (\tan \theta \times \tan \alpha)$$

2θ=Thread profile angle

α=The rake angle of external standard threading tools is 10°; the rake angle of internal standard threading tools is 15°.

The shim has to be changed when helical angle of thread is ≤ clearance angle of tool, which could cause intervene on insert flank.

Please change the shim to adjust the difference between helical angle of thread and inclined angle of shim to be within 2°~0°.

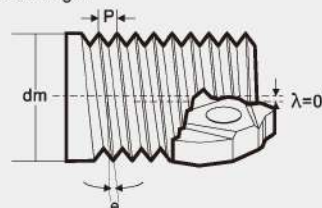
For example: when P=1.5, d₂=24mm,
helical angle 1.14°-(2°~0°)=inclined angle (-0.86°~1.14°)
it is feasible to use standard shim 1°.

Shim specification table is as follows:

Screw pitch range	Insert dimensions	Inclined angle	Shim
0.5-3.0	16	0	MT16-00MN
		1	MT16-01MN
		2	MT16-02MN
		3	MT16-03MN
3.5-6.0	22	0	MT22-00MN
		1	MT22-01MN
		2	MT22-02MN
		3	MT22-03MN

Note: the standard angle of shim for our threading tools is 1°.
(MT16-01MN or MT22-01MN)

θ = Helical angle



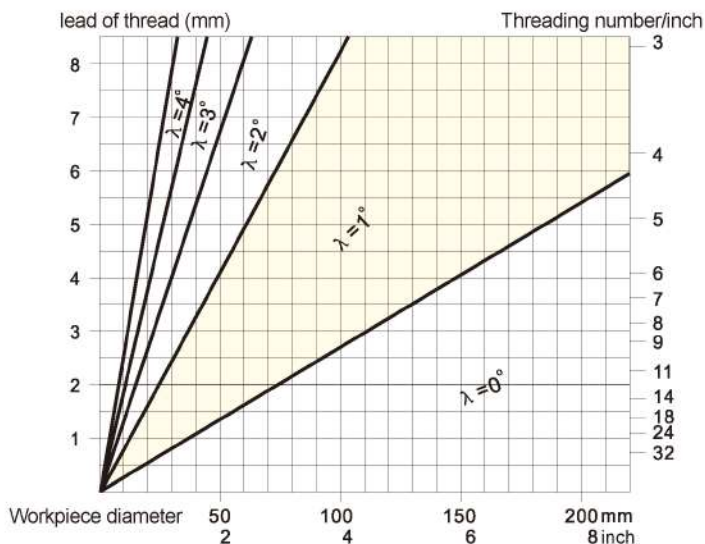
λ = Inclined angle



Please refer to the table below for actual value:

Thread profile angle 2θ	β	
	External thread	Internal thread
60°	5.8°	8.79°
55°	5.24°	7.94°
30°	2.7°	4.1°
29°	2.6°	3.96°

Select shim:





Select proper inserts and size of tool holder (Please refer to detailed table of threading tools and inserts)

Parameter table for threading program under different standards

■ Table of recommended in-feed for metric ISO external threading

Screw pitch (mm)	0.5	0.75	1	1.25	1.5	1.75	2	2.5	3	3.5	4	4.5	5	5.5	6
Total in-feed (mm)	0.38	0.53	0.68	0.85	1.02	1.16	1.33	1.67	1.98	2.3	2.61	2.93	3.25	3.56	3.88
Number of passes	4	4	5	6	7	8	9	11	12	13	14	14	15	16	17
Sequence of threading tool pass	Radial feed/pass units: mm														
1	0.12	0.18	0.2	0.2	0.23	0.24	0.26	0.26	0.26	0.3	0.33	0.35	0.38	0.4	0.4
2	0.1	0.15	0.15	0.18	0.19	0.2	0.22	0.23	0.24	0.28	0.3	0.32	0.35	0.38	0.38
3	0.09	0.12	0.14	0.15	0.17	0.18	0.18	0.21	0.22	0.25	0.28	0.3	0.32	0.35	0.36
4	0.07	0.08	0.11	0.13	0.13	0.14	0.15	0.18	0.2	0.22	0.25	0.28	0.3	0.32	0.34
5			0.08	0.11	0.12	0.12	0.13	0.15	0.18	0.2	0.22	0.26	0.28	0.3	0.32
6				0.08	0.1	0.1	0.12	0.12	0.17	0.2	0.2	0.25	0.25	0.28	0.3
7					0.08	0.1	0.1	0.12	0.16	0.18	0.18	0.22	0.22	0.25	0.28
8						0.08	0.09	0.12	0.15	0.15	0.18	0.2	0.2	0.22	0.25
9							0.08	0.1	0.12	0.12	0.15	0.18	0.2	0.2	0.22
10								0.1	0.1	0.12	0.12	0.15	0.18	0.18	0.2
11								0.08	0.1	0.1	0.12	0.12	0.15	0.15	0.18
12									0.08	0.1	0.1	0.12	0.12	0.13	0.15
13										0.08	0.1	0.1	0.12	0.12	0.12
14											0.08	0.08	0.1	0.1	0.12
15													0.08	0.1	0.1
16														0.08	0.08
17															0.08

General turning

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■ Table of recommended in-feed for metric ISO internal threading

Screw pitch (mm)	0.5	0.75	1	1.25	1.5	1.75	2	2.5	3	3.5	4	4.5	5	5.5	6
Total in-feed (mm)	0.35	0.48	0.66	0.83	0.97	1.14	1.27	1.58	1.8	2.15	2.44	2.73	3.02	3.31	3.6
Number of passes	4	4	5	6	7	8	9	11	12	13	14	14	15	16	17
Sequence of threading tool pass	Radial feed/pass units: mm														
1	0.11	0.15	0.18	0.2	0.22	0.22	0.24	0.25	0.25	0.26	0.26	0.28	0.28	0.3	0.3
2	0.09	0.13	0.15	0.18	0.18	0.18	0.2	0.22	0.23	0.25	0.25	0.26	0.28	0.3	0.3
3	0.08	0.12	0.14	0.15	0.16	0.16	0.18	0.2	0.2	0.23	0.24	0.25	0.26	0.28	0.28
4	0.07	0.08	0.11	0.12	0.13	0.15	0.15	0.18	0.18	0.21	0.22	0.25	0.26	0.28	0.28
5			0.08	0.1	0.11	0.13	0.12	0.15	0.16	0.2	0.2	0.24	0.25	0.26	0.26
6				0.08	0.09	0.12	0.12	0.12	0.15	0.18	0.2	0.22	0.23	0.25	0.25
7					0.08	0.1	0.1	0.12	0.15	0.16	0.18	0.2	0.21	0.23	0.25
8						0.08	0.08	0.1	0.12	0.14	0.18	0.2	0.2	0.23	0.23
9							0.08	0.1	0.1	0.12	0.16	0.18	0.2	0.2	0.23
10								0.07	0.1	0.12	0.15	0.18	0.18	0.2	0.21
11								0.07	0.08	0.1	0.12	0.15	0.18	0.18	0.2
12									0.08	0.1	0.1	0.13	0.15	0.15	0.2
13										0.08	0.1	0.11	0.15	0.15	0.18
14											0.08	0.08	0.11	0.12	0.15
15													0.08	0.1	0.12
16														0.08	0.08
17															0.08

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■ Table of recommended in-feed for American unified standard external threading

Screw pitch (mm)	24	20	18	16	14	12	10	8
Total in-feed (mm)	0.72	0.85	0.92	1.06	1.2	1.39	1.67	2.07
Number of passes	5	6	6	7	8	9	10	12
Sequence of threading tool pass	Radial feed/pass units: mm							
1	0.2	0.2	0.22	0.23	0.24	0.24	0.25	0.25
2	0.18	0.18	0.2	0.2	0.21	0.22	0.23	0.23
3	0.15	0.16	0.16	0.18	0.18	0.2	0.21	0.23
4	0.11	0.13	0.14	0.15	0.15	0.18	0.2	0.2
5	0.08	0.1	0.12	0.12	0.13	0.15	0.18	0.2
6		0.08	0.08	0.1	0.11	0.13	0.15	0.18
7				0.08	0.1	0.11	0.15	0.18
8					0.08	0.08	0.12	0.15
9						0.08	0.1	0.15
10							0.08	0.12
11								0.1
12								0.08

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Application information for threading



■ Table of recommended in-feed for American unified standard internal threading

Screw pitch	24	20	18	16	14	12	10	8
Total in-feed (mm)	0.71	0.83	0.92	1.03	1.16	1.29	1.53	1.9
Number of passes	5	6	6	7	8	9	10	12
Sequence of threading tool pass	Radial feed/pass units: mm							
1	0.19	0.2	0.22	0.23	0.24	0.24	0.25	0.25
2	0.17	0.18	0.2	0.2	0.2	0.2	0.23	0.23
3	0.15	0.15	0.17	0.17	0.18	0.18	0.2	0.23
4	0.12	0.12	0.14	0.14	0.15	0.15	0.18	0.2
5	0.08	0.1	0.11	0.12	0.12	0.12	0.15	0.18
6		0.08	0.08	0.1	0.1	0.12	0.13	0.15
7				0.07	0.1	0.1	0.11	0.15
8					0.07	0.1	0.11	0.12
9						0.08	0.1	0.12
10							0.07	0.1
11								0.1
12								0.07

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■ Table of recommended in-feed for Whitworth internal and external threading

Screw pitch	28	20	19	18	16	14	12	11	10	9	8
Total in-feed (mm)	0.66	0.88	0.91	0.99	1.09	1.25	1.42	1.58	1.71	1.9	2.13
Number of passes	5	6	6	7	8	8	8	9	10	11	12
Order to follow in threading operation	Radial feed/pass units: mm										
1	0.18	0.2	0.2	0.2	0.2	0.22	0.23	0.24	0.24	0.23	0.23
2	0.15	0.18	0.18	0.18	0.18	0.2	0.21	0.22	0.22	0.22	0.22
3	0.14	0.16	0.17	0.15	0.16	0.2	0.21	0.2	0.2	0.21	0.22
4	0.11	0.14	0.15	0.15	0.15	0.18	0.2	0.2	0.2	0.2	0.21
5	0.08	0.12	0.13	0.13	0.12	0.15	0.2	0.18	0.18	0.2	0.2
6		0.08	0.08	0.1	0.12	0.12	0.16	0.18	0.16	0.18	0.2
7				0.08	0.08	0.1	0.12	0.15	0.15	0.15	0.18
8					0.08	0.08	0.09	0.12	0.15	0.15	0.16
9								0.09	0.12	0.13	0.15
10									0.09	0.13	0.15
11										0.1	0.12
12											0.09



■ Table of recommended in-feed for NPT internal and external threading

Screw pitch	27	18	14	11.5	8
Total in-feed (mm)	0.77	1.14	1.46	1.77	2.54
Number of passes	6	8	10	12	14
Sequence of threading tool pass	Radial feed/pass units: mm				
1	0.19	0.22	0.24	0.24	0.24
2	0.16	0.2	0.22	0.22	0.24
3	0.14	0.18	0.2	0.2	0.23
4	0.11	0.15	0.15	0.18	0.22
5	0.09	0.12	0.15	0.15	0.22
6	0.08	0.1	0.12	0.15	0.2
7		0.1	0.12	0.13	0.2
8		0.07	0.1	0.13	0.18
9			0.08	0.11	0.16
10			0.08	0.1	0.16
11				0.08	0.15
12				0.08	0.12
13					0.12
14					0.1

■ Table of recommended in-feed for BSPT internal and external threading with wiper edge

Screw pitch	28	19	14	11
Total in-feed (mm)	0.66	0.94	1.25	1.56
Number of passes	5	6	8	10
Order to follow in threading operation	Radial feed/pcs units: mm			
1	0.18	0.22	0.22	0.22
2	0.15	0.2	0.2	0.2
3	0.14	0.18	0.18	0.2
4	0.11	0.15	0.16	0.18
5	0.08	0.11	0.15	0.15
6		0.08	0.15	0.15
7			0.11	0.13
8			0.08	0.13
9				0.11
10				0.09



Table of recommended cutting parameters

ISO	Material		Unit cutting force Kc0.4 N/mm ²	Hardness HB	Grade
					YBG201 YBG202 YBG203 YBG205
					Cutting speed(m/min)
P	Carbon steel	C=0.15%	1900	125	150-175
		C=0.35%	2100	150	140-155
		C=0.60%	2250	200	130-145
	Alloy steel	Anneal	2100	180	110-130
		Hardened	2600	275	80-100
		Hardened	2700	300	70-90
		Hardened	2850	350	60-80
	High alloy steel	Anneal	2600	200	90-115
		Hardened	3900	325	70-90
	Cast steel	Non-alloy	2000	180	180-210
		low alloy	2500	200	90-115
		High alloy	2700	225	90-115
		Martensite steel 12%Mn	3600	250	40-50
M	Stainless steel	Austenite	2450	180	110-130
		Martensite/Ferrite	2300	200	130-170
K	Malleable cast iron	Ferrite	1100	130	110-140
		Pearlite	1100	230	85-105
	Gray cast iron	Low tensile-strength	1100	180	110-140
		High tensile-strength	1500	260	90-115
	Nodular cast iron	Ferrite	1100	160	110-130
		Pearlite	1800	250	80-100
N	Al alloy	Non-aging treatment	500	60	1300-1450
		Aging treatment	800	100	450-500
	Cast aluminum alloy	Non-aging treatment	750	75	430-470
		Aging treatment	900	90	250-290
S	Iron base	Anneal	3000	200	35-50
		Aging	3050	280	25-35
	Ni- or Co-base	Anneal	3500	250	15-25
		Aging	4150	350	10-20
		Casting	4150	320	10-15
H	Hardened steel	Hardened steel	4500	HRC55	40-50

Note: •The values in the above table are range values. High values in the range could be considered in actual cutting. When trying new cutting speed, please check the cutting edge condition before operation.

•In stainless steel threading, high cutting speed should be used to prevent built-up edge.

•The cutting parameters should be reduced when cutting small pitch thread and when using tools with small nose radius.

•When cutting thread by tools with small nose radius, such as NPT standard thread, it is advisable to use tools with big nose radius first to rough, so as to improve the life of tools with small nose radius.

General turning

Parting and grooving

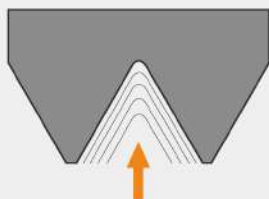
Threading

Application information for threading



In-feed way of threading tools

Radial in-feed



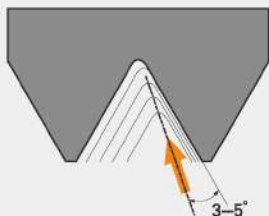
- Easy operating, high general.
- V-shape chip caused by long chip steel workpiece will produce big bend stress on cutting edge.
- It requires low cutting depth, sharp cutting edge and good tough material.
- Big quantity of heat when cutting, V-shape chip is hard to control.
- Because the interface of cutting chips on the right and left side is long, so it is easy to cause vibration and make the cutting edge suffer more overloading.

Flank in-feed



- Cutting edge suffer small bend stress, stable estate, it is easy for chips formation in deep cutting depth.
- There are enough space to leave chips flow when flank in-feed.
- Big abrasion on right flank.

Modified flank in-feed



- Right Cutting Edge also engage on cutting depth to a certain extent, it can reduce the abrasion on right side of clearance face.
- Cutting edge suffer small bend stress, stable estate, it is easy for chips formation in deep cutting depth.
- Good Cutting Performance.

Alternate flank in-feed



- Cutting edge trade off when machining, equality abrasion on left and right side of clearance face on cutting edge, it can improve the life of tools.
- Chips are flowing from both of right and left side, good chips flowing.
- Recommend using in big screw-pitch thread cutting.



Recommend adopting flank in-feed or alternate flank in-feed under allowable range of machining equipment or programmer, it can eliminate the machining vibration effectively, and it has enough space discharge the chips between pitch. Cutting edge suffer a small stress, machining stable, it likes the general turning process when machining thread, good chip control without chip tangling.



Common problems in threading and solutions

Problem	Cause	Solutions
Wear on clearance face	Cutting speed too high.	Reduce cutting speed.
	Low cutting depth, friction and wear.	Reduce frequency of feed and friction of cutting edge.
	Inserts are over the center line.	Adopt correct center height.
Asymmetric wear on right and left cutting edge	The inclined angle of insert is different from the helical angle of thread.	Change to proper shim to get correct inclined angle.
	Flank in-feed is not correct.	Change the way of flank in-feed.
Breakage	Cutting speed too low.	Increase cutting speed.
	Cutting force too high.	Increase frequency of feed and reduce Max in-feed.
	Unstable clamping.	Check if workpiece vibrates. Reduce overhang of tool. Verify clamping of workpiece and tool.
	Chip tangling.	Increase the pressure of cooling liquid to blow away chips.
Plastic deformation	High cutting speed, high temperature on cutting area.	Reduce cutting speed. Increase feed frequency and reduce Max cutting depth.
	Insufficient cooling fluid.	Increase cooling fluid supply.
Low thread surface quality	Cutting speed too low. The insert is over the center line. Chips are not under control.	Increase cutting speed. Adjust centre height. Change the operation way of tools to well control chips.
Incorrect profile	Incorrect center height.	Adjust centre height.
	Pitch on machine is not correct.	Adjust machine.
Shallow profile	Cutting speed set wrong.	Adjust cutting depth.
Surface damage	Chip involved in or touched the machined surface.	Change to flank in-feed to control chip flow direction.
Built-up edge	Temperature of cutting edge is too low. Usually occur when machining stainless steel and low carbon steel.	Increase cutting speed as well as pressure and concentration of cooling fluid. Choose inserts with good toughness.
Crack on surface	Cutting force too high.	Reduce the cutting depth of each feed.
Vibration	Incorrect clamping of workpiece or tool.	Verify clamping of workpiece and tool. Minimize overhang of tool.
	Incorrect cutting parameters.	Increase cutting speed or reduce it substantially.
	Incorrect tool clamping.	Adjust center height.