

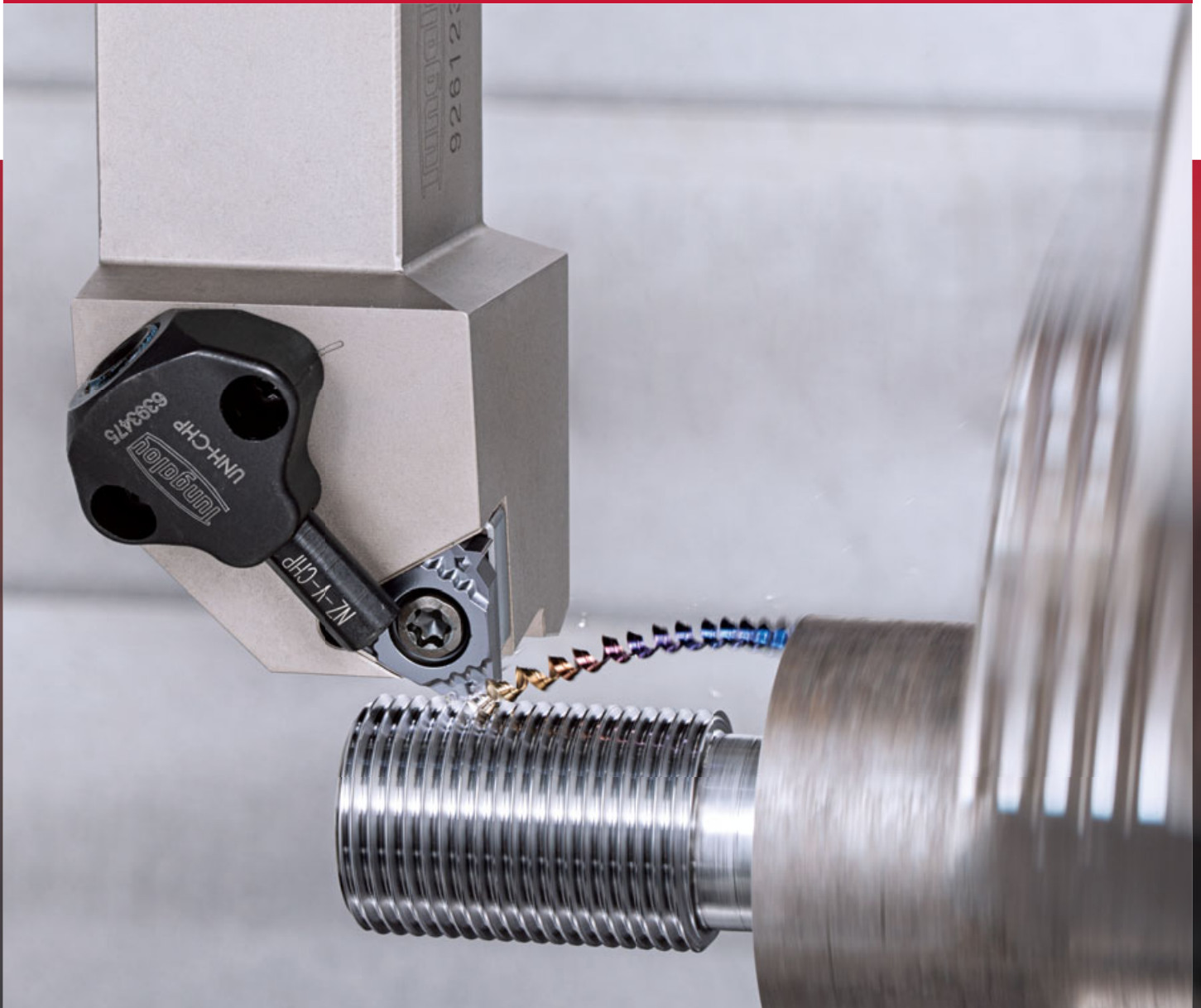


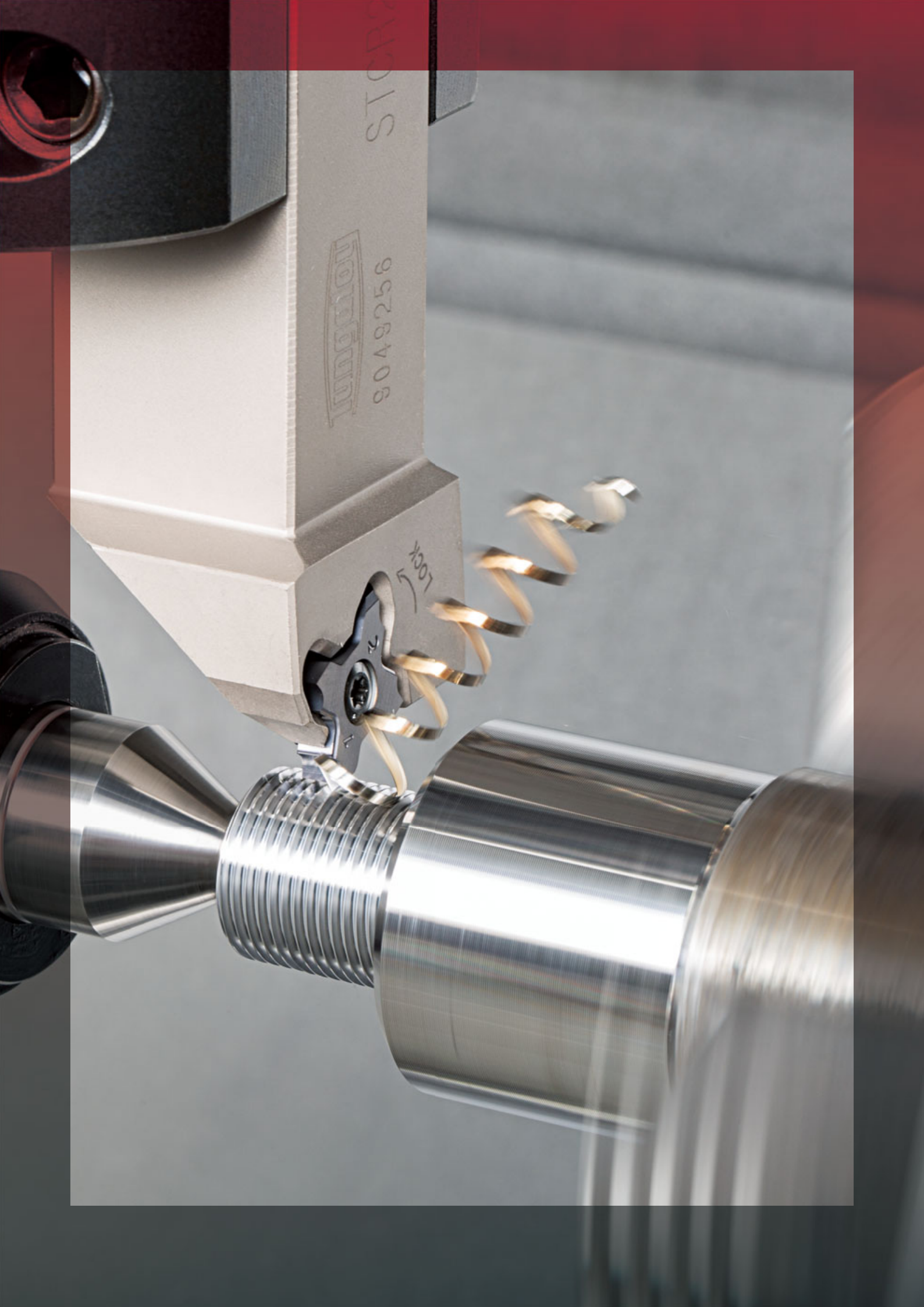
Threading tool

TUNGTHREAD

Tungaloy Report No. 375-G

Expansion of **AH8015 grade** threading inserts with chipbreaker





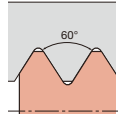
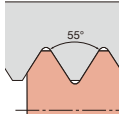
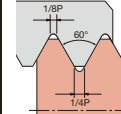
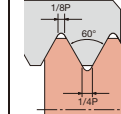
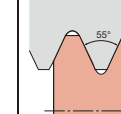
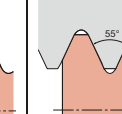
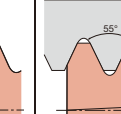
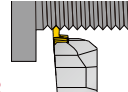
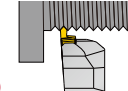
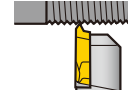
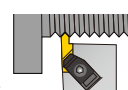


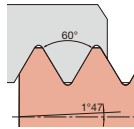
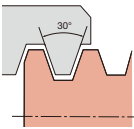
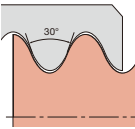
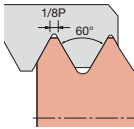
TUNGTHREAD

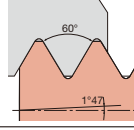
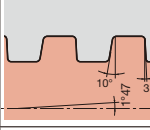
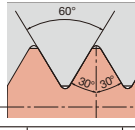
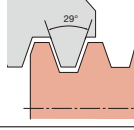
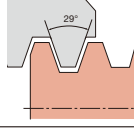
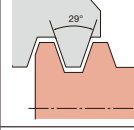


Effective threading tools for CNC lathes,
Swiss-type lathes, and multi-tasking machines

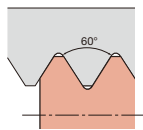
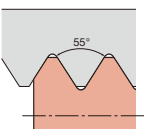
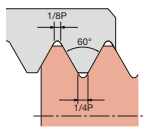
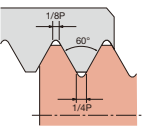
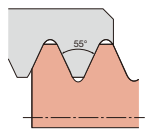
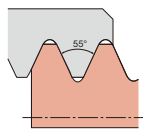
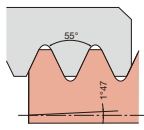
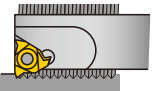
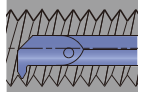
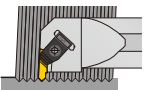
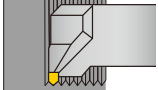
Applicable tool for each external thread type

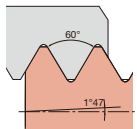
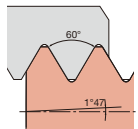
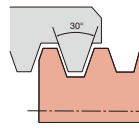
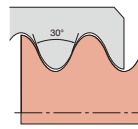
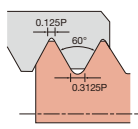
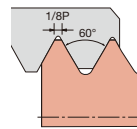
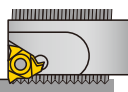
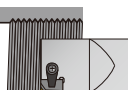
Application	General purpose, Machine parts for machine and automotive parts				For valve and pump parts; pneumatic, hydraulic, oil and gas pipes		
Profile condition	Partial profile (with no profile for the crest)		Full profile (for complete thread profile)				
Insert symbol	60	55	ISO	UN	W		PT
Thread class	- ISO metric - Unified	Whitworth	ISO metric threads, coarse and fine	Unified national threads series, 60° inch threads	- British standard whitworth - British standard fine	- British standard parallel pipe - British standard pipe - Parallel pipe thread (JIS B 9912) - 55° inch thread	- JIS tapered pipe thread - British standard pipe taper
Thread symbols	M, UN, UNC, UNF, UNEF, UNS	G, BSP, PF, BSPP	M	UN, UNR, UNC, UNRC, UNF, UNRF, UNEF, UNREF, UNS, UNRS	BSW, BSF, W	G, BSP, PF, BSPP	R, PT, BSPT
Thread form							
Tool type							
ST type  P.36	0.5 ~ 6 mm 48 ~ 4TPI P.10	0.5 ~ 5 mm 48 ~ 5TPI P.15	0.5 ~ 6 mm P.17	32 ~ 5TPI P.20	28 ~ 5TPI P.22	28 ~ 5TPI P.22	28 ~ 11TPI P.24
TETRAMCUT  P.42	0.4 ~ 3 mm 64 ~ 8TPI P.12	—	0.5 ~ 1.5 mm P.19	—	—	—	—
DUOJUST CUT  P.49	0.2 ~ 1.5 mm 127 ~ 16TPI P.12	—	—	—	—	—	—
J-SERIES  P.51	0.5 ~ 1 mm 48 ~ 25TPI P.13	0.5 ~ 1 mm 48 ~ 25TPI P.16	—	—	—	—	—
TUNG-CLAMP  P.53	1.27 ~ 4.23 mm 20 ~ 6TPI P.13	—	—	—	—	—	—
TT type  P.56	~ 3 mm ~ 8TPI P.14	~ 3 mm ~ 8TPI P.16	—	—	—	—	—

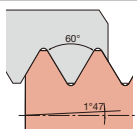
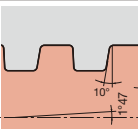
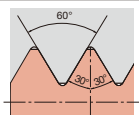
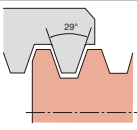
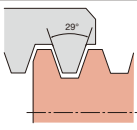
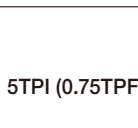
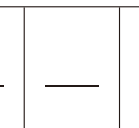
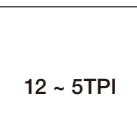
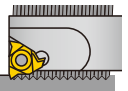
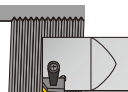
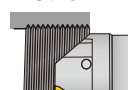
Application	For valve and pump parts; pneumatic, hydraulic, oil and gas pipes		Machine parts		Aerospace threads	
Profile condition	Full profile (for complete thread profile)		Profile including crest radii	Full profile (for complete thread profile)		
Insert symbol	NPT	NPTF	TR	RD	UNJ	
Thread class	National pipe taper thread	NPT thread	- TR - 30° trapezoidal - ISO trapezoidal	Knuckle thread	Unified inch screw threads	
Thread symbols	NPT	NPTF	TR	Rd	UNJ, UNJC, UNJF, UNUEF, UNJS	
Thread form						
Tool type						
ST type 	27 ~ 8TPI	27 ~ 8TPI	1.5 ~ 6 mm	8TPI, 6TPI	32 ~ 8TPI	
P.36	P.25	P.26	P.27	P.27	P.28	
Chaser 	11.5TPI, 8TPI	—	—	—	—	
P.56	P.26					

Application	Oil and gas fields and OCTG drill pipes							Machine parts, Pipe	
Profile condition	Full profile (for complete thread profile)							Profile including crest radii	
Insert symbol	RAPI, RD-CB, R8, 10R	BAPI, 5B	428	438	530	425	435	ACME, NT	NT STUB
Thread class	- API round - API casing - API tubing - Short casing - Long casing - Non-upset tubing - External upset tubing	API buttress casing	- API rotary shoulder connection for drill pipe and collar connections - API Numbered connections - API Full		- API regular - API full hole			ACME 29° trapezoidal thread	STUB ACME 29° trapezoidal thread
			V-0.038R 2TPF	V-0.038R 3TPF	V-0.040R 3TPF	V-0.050R 2TPF	V-0.050R 3TPF		
Thread symbols	CSG, LCSG, TBG, UPTBG	BCSG	NC	NC	REG	REG, FH	REG	-	-
Thread form									
Tool type									
ST type 	10TPI, 8TPI	5TPI (0.75TPF)	—	—	—	—	—	12 ~ 5TPI	—
P.36	P.30	P.33						P.29	
Chaser 	10TPI, 8TPI	5TPI (0.75TPF)	—	—	—	—	—	—	—
P.56	P.31	P.33							
Other 	10TPI, 8TPI	5TPI (0.75TPF) 5TPI (1TPF)	4TPI (2TPF) 4TPI (3TPF) 5TPI (3TPF)					16 ~ 3TPI	16 ~ 3TPI
P.54	P.31	P.33	P.35					P.29	P.30

Applicable tool for each internal thread type

Application	General purpose, Machine parts for machine and automotive parts				For valve and pump parts; pneumatic, hydraulic, oil and gas pipes		
Profile condition	Partial profile (with no profile for the crest)		Full profile (for complete thread profile)				
Insert symbol	60	55	ISO	UN	W		PT
Thread class	- ISO metric - Unified	Whitworth	ISO metric threads, coarse and fine	Unified national threads series, 60° inch threads	- British standard whitworth - British standard fine	- British standard parallel pipe - British standard pipe - Parallel pipe thread (JIS B 9912) - 55° inch thread	- JIS tapered pipe thread - British standard pipe taper
Thread symbols	M, UN, UNC, UNF, UNEF, UNS	G, BSP, PF, BSPP	M	UN, UNR, UNC, UNRC, UNF, UNRF, UNEF, UNREF, UNS, UNRS	BSW, BSF, W	G, BSP, PF, BSPP	R, PT, BSPT
Thread form							
Tool type							
ST type  P.57	0.5 ~ 6 mm 48 ~ 4TPI P.10	0.5 ~ 5 mm 48 ~ 5TPI P.15	0.5 ~ 6 mm P.17	32 ~ 5TPI P.20	28 ~ 5TPI P.22	28 ~ 5TPI P.22	19 ~ 11TPI P.24
TINYTURN  P.60	0.5 ~ 1.5 mm 48 ~ 16TPI P.63	—	—	—	—	—	—
TUNG-CLAMP  P.62	1.27 ~ 4.23 mm 12 ~ 5TPI P.13	—	—	—	—	—	—
TT type  P.65	~ 3 mm ~ 8TPI P.14	~ 3 mm ~ 8TPI P.16	—	—	—	—	—

Application	For valve and pump parts; pneumatic, hydraulic, oil and gas pipes		Machine parts		Aerospace threads	
Profile condition	Full profile (for complete thread profile)		Profile including crest radii	Full profile (for complete thread profile)		Partial profile (with no profile for the crest)
Insert symbol	NPT	NPTF	TR	RD	MJ	UNJ
Thread class	National pipe taper thread	NPT thread	- TR - 30° trapezoidal - ISO trapezoidal	Knuckle thread	Aerospace standard MJ threads	Unified inch screw threads
Thread symbols	NPT	NPTF	TR	Rd	MJ	UNJ, UNJC, UNJF, UNUEF, UNJS
Thread form						
Tool type						
ST type						
 P.57	27 ~ 8TPI P.25	14 ~ 8TPI P.26	1.5 ~ 5 mm P.27	6TPI P.27	1 mm P.28	32 ~ 5TPI P.20
Chaser						
 P.65	11.5TPI, 8TPI P.26	—	—	—	—	—

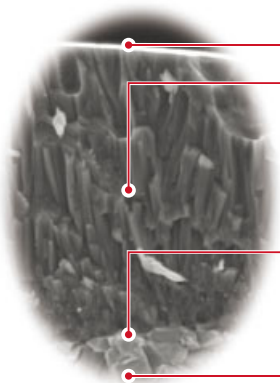
Application	Oil and gas fields and OCTG drill pipes							Machine parts, Pipe	
Profile condition	Full profile (for complete thread profile)							Profile including crest radii	
Insert symbol	RAPI, RD-CB, R8, 10R	BAPI, 5B	428	438	530	425	435	ACME, NT	NT STUB
Thread class	- API round - API casing - API tubing - Short casing - Long casing - Non-upset tubing - External upset tubing	API buttress casing	- API rotary shoulder connection for drill pipe and collar connections					ACME 29° trapezoidal thread	STUB ACME 29° trapezoidal thread
	- API Numbered connections - API Full		- API regular - API full hole						
	V-0.038R 2TPF		V-0.038R 3TPF	V-0.040R 3TPF	V-0.050R 2TPF	V-0.050R 3TPF			
Thread symbols	CSG, LCSG, TBG, UPTBG	BCSG	NC	NC	REG	REG, FH	REG	-	-
Thread form									
Tool type									
ST type	 P.57	10TPI, 8TPI P.30	5TPI (0.75TPF) P.33	—	—	—	—	12 ~ 5TPI P.29	—
Chaser	 P.65	10TPI, 8TPI P.31	5TPI (0.75TPF) P.33	—	—	—	—	—	—
Other	 P.63	10TPI, 8TPI P.31	5TPI (0.75TPF) 5TPI (1TPF) P.33	4TPI (2TPF) 4TPI (3TPF) 5TPI (3TPF) P.35			—	—	

Enhanced lineup of high-performing inserts and grades for all threading applications

New

AH8015

Versatile PVD grade for superior wear and chipping resistance in a wide range of materials



PREMIUMTEC

Nano-multi-layered AlTiN coating with high Al content

- Increases hardness by 20%
- Prevents micro cracks from developing
- **Long tool life & stable machining**

Improved adhesion strength

→ **Prevents notch wear that tends to occur in machining heat-resistant alloys**

Newly developed substrates

Fracture
Chipping

For general purpose

AH725

General-purpose PVD grade for high fracture resistance

Sharpness

SH725

Provides sharp cutting edge and long tool life, ideal for machining small parts

Plastic
deformation

T313V

CVD grade dedicated to threading applications requiring good resistance to plastic deformation

Surface
finish

NS9530

- Cermet grade for superior surface finish quality and wear resistance
- Prevents built-up edge for better surface finish

for Non-ferrous
material

TH10

Uncoated carbide grade for non-ferrous applications

for hardened
steel

BX330

CBN grade for hardened steel

Chip control

Use M-style chipbreaker



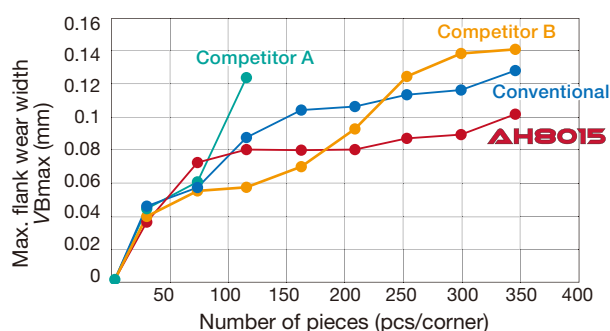
16ER***-M
16IR***-M

	without chipbreaker 16ER15ISO	with chipbreaker 16ER15ISO-M
Radial infeed		
Flank infeed		

Workpiece material : S45C / C45
Screw Size : M24 X 1.5
Cutting speed : Vc = 180 m/min
Machining : External threading

CUTTING PERFORMANCE

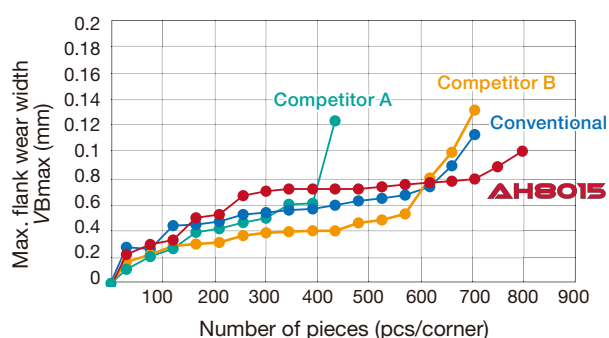
M SUS304 / X5CrNi18-9



Insert : 16ER15IS
 Cutting speed : $V_c = 80$ m/min
 Pitch : $p = 1.5$ mm
 Machining : External threading
 Infeed method : Radial infeed
 Coolant : Wet

AH8015 provided good wear resistance for threading stainless steel parts.

P S45C / C45



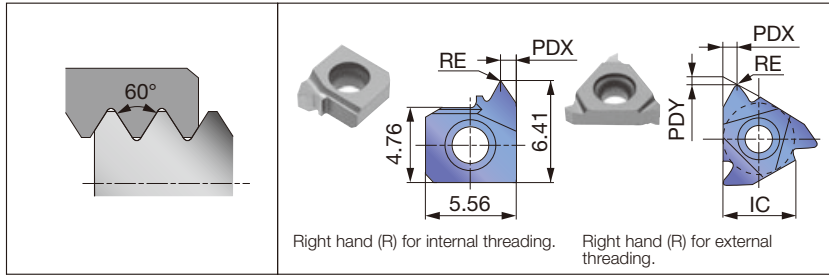
Insert : 16ER15IS
 Cutting speed : $V_c = 150$ m/min
 Pitch : $p = 1.5$ mm
 Machining : External threading
 Infeed method : Radial infeed
 Coolant : Wet

AH8015 provided good wear resistance for threading steel parts.

GRADES

Grade	Recommended workpiece material	Feature
PREMIUMTEC AH8015	P M K S	- Versatile PVD grade for a good combination of wear and chipping resistance across a wide range of materials
AH725	P M	- General-purpose PVD grade for high fracture resistance - Complementary grade
SH725	P M K S	- Ideal PVD grade for small parts turning due to excellent sharpness and high adhesion strength offering incredible wear resistance
NS9530	P	- Cermet grade for superior surface finish quality and wear resistance - Prevents built-up edge on the cutting edge for better surface finish
T05HP	P M K	- CVD grade for superior wear resistance - Dedicated carbide substrate for excellent resistance to plastic deformation
T05TP	P M K	- CVD grade for superior wear and chipping resistance - High adhesion coating prevent the sudden insert damage
T313V	P M K	- CVD grade dedicated to threading application requiring excellent resistance to fracture
TH10	N S H	- Uncoated carbide grade for non-ferrous applications
BX330	H	- CBN grade for hardened steel

60° thread angle



Applicable toolholder

Insert size	External	Internal
6		SNR/L000*K06SC... SNR/L000*H06...
06		SIR0005...
08		SIR0007...
11	SER**11	SNR/L**11...
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...
27	CER/L**27...	CNR/L**27...

Partial-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert									Internal insert									
				Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE	
					Coated		Uncoated	Coated						Uncoated								
					AH8015	AH725	T313V	TH10						AH8015	AH725	GH330	T313V					TH10
6	0.5 - 1.5	48 - 16	R										6IRA60	●	●		●	-	0.9	-	0.04	
06	0.5 - 1.25	48 - 20	R										06IRA60			●**		4	0.6	0.6	0.05	
08	0.5 - 1.5	48 - 16	R										08IRA60		●**			5	0.7	0.6	0.05	
11	0.5 - 1.5	48 - 16	R	11ERA60		●			6.35	0.9	0.8	0.06	11IRA60	●	●		●	●	6.35	0.9	0.7	0.04
11	0.5 - 1.5	48 - 16	L										11ILA60		●		●	●	6.35	0.9	0.7	0.04
16	0.5 - 1.5	48 - 16	R	16ERA60	●	●	●	●	9.525	0.9	0.7	0.06	16IRA60	●	●		●	●	9.525	0.9	0.7	0.04
16	0.5 - 1.5	48 - 16	L	16ELA60		●	●	●	9.525	0.9	0.7	0.06	16ILA60		●		●	●	9.525	0.9	0.7	0.04
16	0.5 - 3	48 - 8	R	16ERAG60	●	●	●		9.525	1.6	1.2	0.06	16IRAG60	●	●		●		9.525	1.6	1.2	0.04
16	1.75 - 3	14 - 8	R	16ERG60	●	●	●	●	9.525	1.6	1.2	0.22	16IRG60	●	●		●	●	9.525	1.6	1.2	0.12
16	1.75 - 3	14 - 8	L	16ELG60		●	●		9.525	1.6	1.2	0.22	16ILG60		●		●	●	9.525	1.6	1.2	0.12
22	3.5 - 5	7 - 5	R	22ERN60	●	●	●	●	12.7	2.5	1.7	0.44	22IRN60	●	●		●	●	12.7	2.5	1.7	0.25
22	3.5 - 5	7 - 5	L	22ELN60		●	●		12.7	2.5	1.7	0.44	22ILN60		●		●		12.7	2.5	1.7	0.25
27	4 - 6	6 - 4	R	27ERZ60		●	●		15.875	3.2	2.2	0.5	27IRZ60		●		●		15.875	3.2	2.2	0.28

●** : Both ..06IR... and ..08IR... inserts have 3 cutting edges.

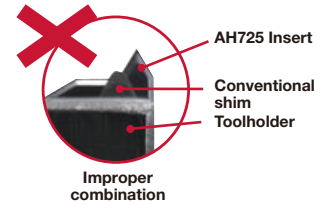
Partial-profile insert

Insert size	Pitch	TPI	Hand of cut	External insert							
				Designation	Grade	IC	PDX	PDY	RE		
					CBN						
					BX330						
16	1 - 2	20 - 13	R	1QP-16ER60-014-SP	●	9.525	0.95	0.7	0.14		
16	1.5 - 3	16 - 8	R	1QP-16ER60-020-SP	●	9.525	1.55	1.2	0.2		

Partial-profile insert with chipbreaker

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert													
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE						
					Coated		Cermet						Coated		Cermet										
					AH8015	AH725	NS9530						AH8015	AH725	NS9530										
11	0.5 - 1.5	48 - 16	R									11IRA60-B	●				6.35	0.9	0.7	0.04					
11	0.5 - 1.5	48 - 16	R									11IRA60-M	●				●	6.35	0.9	0.7	0.04				
16	0.5 - 1.5	48 - 16	R	16ERA60-B		●*				9.525	0.9	0.8	0.05	16IRA60-B		●*				9.525	0.9	0.8	0.05		
16	0.5 - 1.5	48 - 16	R	16ERA60-M		●				●	9.525	0.9	0.7	0.06	16IRA60-M		●				●	9.525	0.9	0.7	0.04
16	0.5 - 3	48 - 8	R	16ERAG60-B		●*				9.525	1.7	1.2	0.08	16IRAG60-B		●*				9.525	1.7	1.2	0.05		
16	0.5 - 3	48 - 8	R	16ERAG60-M		●		●		●	9.525	1.6	1.2	0.06	16IRAG60-M		●		●		●	9.525	1.6	1.2	0.04
16	1.75 - 3	14 - 8	R	16ERG60-B		●*				9.525	1.7	1.2	0.25	16IRG60-B		●*				9.525	1.7	1.2	0.1		
16	1.75 - 3	14 - 8	R	16ERG60-M		●				●	9.525	1.6	1.2	0.22	16IRG60-M		●				●	9.525	1.6	1.2	0.14
22	3.5 - 5	7 - 5	R	22ERN60-B		●				12.7	2.5	1.7	0.32	22IRN60-B		●				12.7	2.5	1.7	0.19		

- ●* : The cutting edge position needs re-adjusting for these inserts have different PDY and PDX dimensions (Note: for size 16 inserts only).
 - requires the use of dedicated shim.
- When using a new AH725 with chipbreaker, the conventional shim may need to be replaced with a new standard shim. Please refer to the page 67.



Thread form

60°

55°

M
(Metric)

UN
(Unified)

W
(Whitworth)

BSPT
(R, PT)

NPT

NPTF

TR
(Metric, 30° Trapezoidal)

Round
(DIN405)

UNJ

MJ

ACME
(29° Trapezoidal)

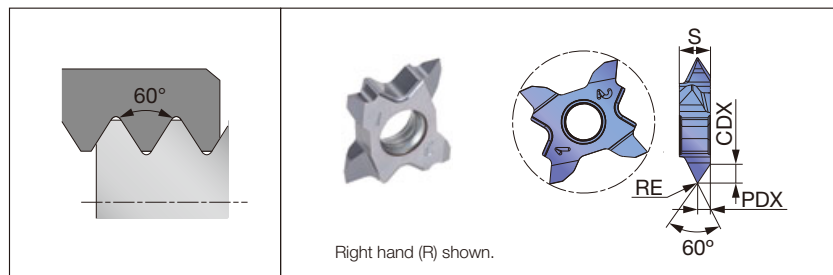
STUB
ACME
(29° Trapezoidal)

API
Round

API
Buttress

API
Rotary
Shoulder
Connection

60° thread angle



Applicable toolholder

External
STCR/L**-18
STCR/L**18-CHP
JS**-STCL18
C*STCFL**18-CHP
C*STCR/L**18-CHP
QC**STCR/L18 (-Y)
QC**STCR/L18 (-Y)-CHP

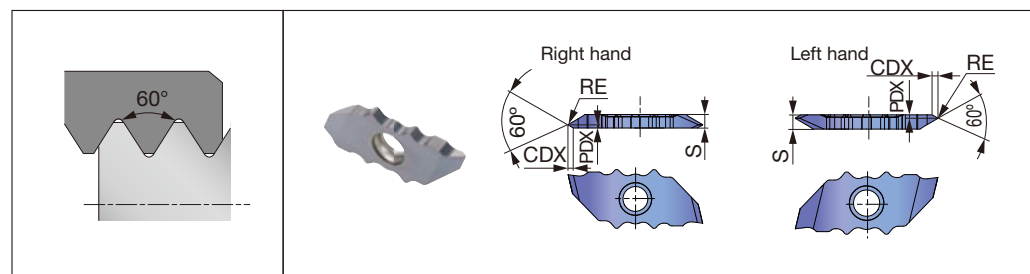
Partial-profile insert

Pitch (Reference)	TPI	Hand of cut	External insert						
			Designation	Grade		PDX	CDX	RE	S
				Coated					
				SH725	AH725				
0.4 - 1	25 - 64	R	TCT18FR-60A-005	●		0.6	0.99	0.05	4
1 - 2	25 - 12	R	TCT18FR-60A-010	●		1	1.63	0.1	4
0.8 - 3	8 - 32	R/L	TCT18R/L-60N-010		●	1.6	2.67	0.1	4
1.5 - 3	8 - 16	R/L	TCT18R/L-60N-020		●	1.6	2.57	0.2	4

DUOJUST

INSERT

60° thread angle



Applicable toolholder

External
JSXXR/L**09
JSXXR/L**09-CHP
JS**-SXXL09

Partial-profile insert

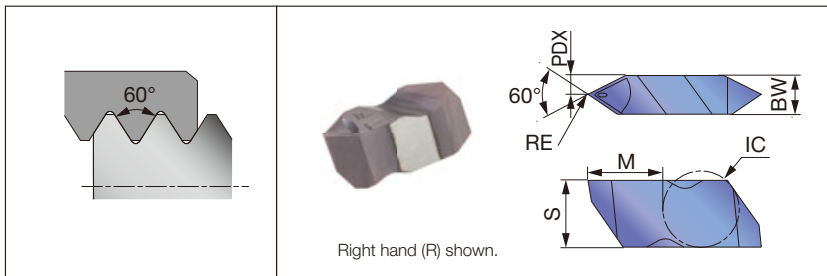
Insert size	Pitch (Reference)	TPI	Hand of cut	External insert						
				Designation	Grade		PDX	CDX	RE	S
					Coated					
					SH725					
					R	L				
12	0.2 - 0.4	64 - 127	R/L	JXTG12FR/L-60A-000	●	●	0.25	0.4	0.05 max flat	2.5
12	0.2 - 0.4	64 - 127	R/L	JXTG12FR/L-60B-000	●	●	2.25	0.4	0.05 max flat	2.5
12	0.4 - 1	25 - 64	R/L	JXTG12FR/L-60A-005	●	●	0.6	0.99	0.05	2.5
12	0.4 - 1	25 - 64	R/L	JXTG12FR/L-60B-005	●	●	1.9	0.99	0.05	2.5
12	1 - 1.5	16 - 25	R/L	JXTG12FR/L-60N-010	●	●	1.25	2.07	0.1	2.5

	Type A	Type B	Type N
Right hand			
Left hand			

Reference pages: TetraMini-Cut : External toolholders → **42 - 48**
DuoJust-Cut : External toolholders → **49 - 50**

● : Line up
Package quantity = 5 pcs.

60° thread angle



Applicable toolholder

External	Internal
FLASR/L-1616M3	A**M-FLER/L3
FLSR/L-**M3	HS**-FLER3W

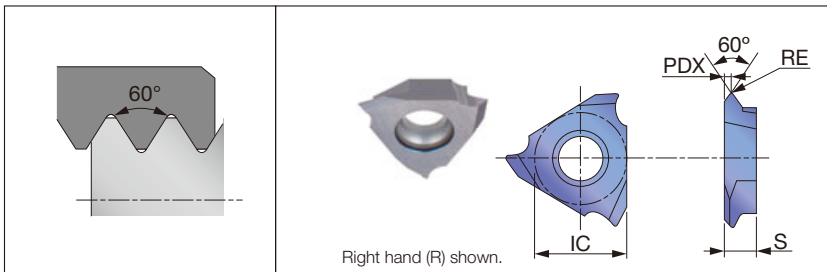
Partial-profile insert for external and internal threads

TPI for external	TPI for internal	Hand of cut	External Pitch (Reference)	Internal Pitch (Reference)	Designation	Grade	IC	PDX	BW	RE	S	M
						Coated						
						AH725						
6 - 20	5 - 12	R/L	1.27 - 4.23	2.11 - 5.08	FLT-3R/L-HCB	●	9.525	2.49	4.95	0.17	8.74	10.16
6 - 11	5 - 6	R/L	2.31 - 4.23	4.23 - 5.08	FLT-3R/LC-HCB	●	9.525	2.49	4.95	0.35	8.74	10.16
8 - 20	8 - 12	R/L	1.27 - 3.175	2.11 - 3.175	FLT-3R/L-CB	●	9.525	2.49	4.95	0.17	8.74	10.16

J-SERIES

INSERT

60° thread angle



Applicable toolholder

External
JSTTR/L**3
JS**-TTL3

Partial-profile insert

Pitch (Reference)	TPI	Hand of cut	External insert												
			Designation	Grade								IC	PDX	S	RE
				Coated				Cermet		Uncoated					
				SH725		J740		NS9530		TH10					
			R	L	R	L	R	L	R	L					
0.5 - 1	25 - 48	R/L	JTTR/L3005F	●	●	●		●		●		9.525	0.6	3.18	0.05
0.5 - 1	25 - 48	R/L	JTTR/L3010F	●	●	●		●		●		9.525	1.1	3.18	0.1

60° thread angle



Applicable toolholder

External
JSXBR**K8
JSXBR**K8-C

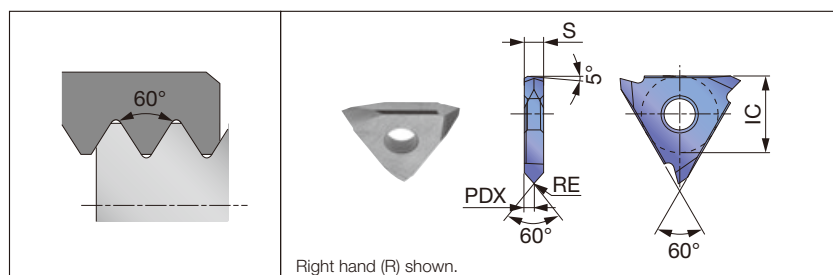
Partial-profile insert

Pitch (Reference)	TPI	Hand of cut	External insert					
			Designation	Grade		IC	S	RE
				Coated	Uncoated			
				J740	TH10			
0.5 - 1	25 - 48	R	JXT1R6000F	●	●	8	3.97	0.03
0.5 - 1	25 - 48	R	JXT2R6000F	●	●	8	3.97	0.03

TUNGTHREAD

INSERT

TT type / 60° thread angle



Applicable toolholder

External	Internal
TT-***RE/LI	TT-2525RI

Partial-profile insert for external and internal threads

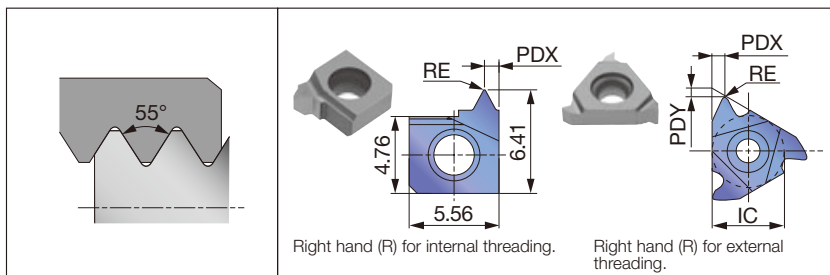
Pitch (Reference)	TPI	Hand of cut	Designation	Grade		IC	PDX	S	RE
				Cermet	Uncoated				
				NS9530	TH10				
≤ 3	≥ 8	R	TTR42M-005	●	●	12.7	1.6	3.2	0.05
≤ 3	≥ 8	L	TTL42M-005	●	●	12.7	1.6	3.2	0.05

Reference pages: J-Series : External toolholders → 52

TT type : External toolholders → 56, Internal toolholders → 65

● : Line up
Package quantity = 5 pcs.

55° thread angle (General purpose)



Applicable toolholder

Insert size	External	Internal
6		SNR/L000*K06SC... SNR/L000*H06...
06		SIR0005...
08		SIR0007...
11	SER**11	SNR/L**11...
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...

Partial-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert											
				Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE		
					Coated		Uncoated	Coated						Uncoated									
					AH8015	AH725		T313V							TH10	AH8015	AH725	GH330				T313V	TH10
6	0.5 - 1.5	48 - 16	R									6IRA55							-	0.9	-	0.07	
06	0.5 - 1.25	48 - 20	R									06IRA55								4	0.5	0.5	0.08
08	0.5 - 1.5	48 - 16	R									08IRA55								5	0.7	0.6	0.08
11	0.5 - 1.5	48 - 16	R	11ERA55					6.35	0.9	0.8	0.05	11IRA55						6.35	0.9	0.7	0.07	
16	0.5 - 1.5	48 - 16	R	16ERA55					9.525	0.9	0.7	0.07	16IRA55						9.525	0.9	0.7	0.07	
16	0.5 - 3	48 - 8	R	16ERAG55					9.525	1.7	1.2	0.07	16IRAG55						9.525	1.7	1.2	0.07	
16	1.75 - 3	14 - 8	R	16ERG55					9.525	1.6	1.2	0.25	16IRG55						9.525	1.7	1.2	0.25	
22	3.5 - 5	7 - 5	R	22ERN55					12.7	2.5	1.7	0.5	22IRN55						12.7	2.5	1.7	0.5	

Partial-profile insert with chipbreaker

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert							
				Designation	Grade		IC	PDX	PDY	RE	Designation	Grade		IC	PDX	PDY	RE		
					Coated							Coated							
					AH725							AH725							
16	0.5 - 3	48 - 16	R	16ERAG55-B	●*			9.525	1.7	1.2	0.07	16IRAG55-B	●*			9.525	1.7	1.2	0.05
16	1.75 - 3	14 - 8	R	16ERG55-B	●*			9.525	1.7	1.2	0.23	16IRG55-B	●*			9.525	1.7	1.2	0.2

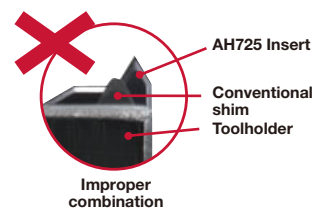
- ●* : The cutting edge position needs re-adjusting for these inserts have different PDY and PDX dimensions (Note: for size 16 inserts only).

- ●** : Both ..06IR... and ..08IR... inserts have 3 cutting edges.

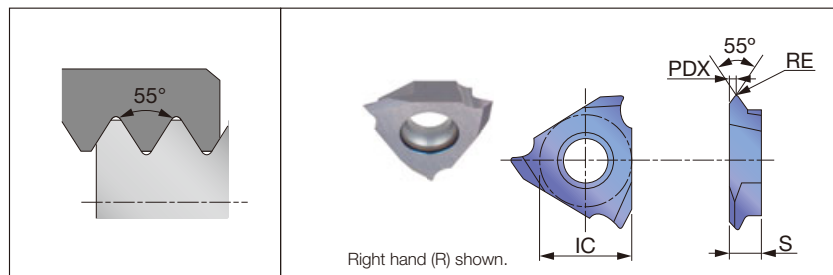
- ■ requires the use of dedicated shim.

When using a new AH725 with chipbreaker, the conventional shim may need to be replaced with a new standard shim.

Please refer to the page 67.



55° thread angle (General purpose)



Applicable toolholder

External
JSTTR/L**3
JS**-TTL3

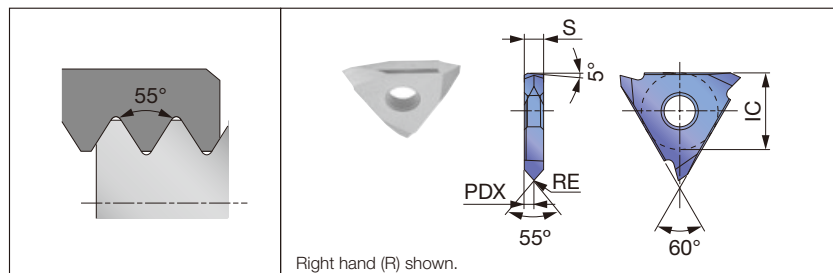
Partial-profile insert

Pitch (Reference)	TPI	Hand of cut	External insert								
			Designation	Grade				IC	PDX	S	RE
				Coated							
				SH725		J740					
				R	L	R	L				
0.5 - 1	25 - 48	R/L	JTTR/L3005F-55	●		●		9.525	0.6	3.18	0.05

TUNGTHREAD

INSERT

TT type / 55° thread angle (General purpose)



Applicable toolholder

External	Internal
TT-****RE/LI	TT-2525RI

Partial-profile insert for external and internal threads

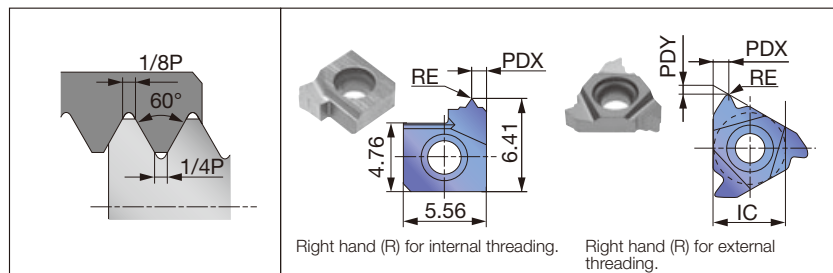
Pitch (Reference)	TPI	Hand of cut	Designation	Grade		IC	PDX	S	RE
				Cermet	Uncoated				
				NS9530	TH10				
≤ 3	≥ 8	R	TTR42W-005	●	●	12.7	1.6	3.2	0.05
≤ 3	≥ 8	L	TTL42W-005	●	●	12.7	1.6	3.2	0.05

Reference pages: J-Series : External toolholders → 51

TT type : External toolholders → 56, Internal toolholders → 65

● : Line up
Package quantity = 5 pcs.

ISO metric (General purpose)



Applicable toolholder

Insert size	External	Internal
6		SNR/L000*K06SC... SNR/L000*H06...
06		SIR0005...
08		SIR0007...
11	SER**11	SNR/L**11...
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...
27	CER/L**27...	CNR/L**27...

Thread form

60°

55°

M
(Metric)

UN
(Unified)

W
(Whitworth)

BSPT
(R, PT)

NPT

NPTF

TR
(Metric, 30° Trapezoidal)

Round
(DIN405)

UNJ

MJ

ACME
(29° Trapezoidal)

STUB
ACME
(29° Trapezoidal)

API
Round

API
Buttress

API
Rotary
Shoulder
Connection

Full-profile insert

Insert size	Pitch (Reference)	Hand of cut	External insert								Internal insert									
			Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE
				Coated		Uncoated	Coated						Uncoated							
				AH8015	AH725		T313V							TH10	AH8015	AH725				
6	0.75	R									6IR075ISO		●		●	-	0.5	-	0.05	
6	1	R									6IR10ISO	●	●		●	-	0.9	-	0.07	
6	1.25	R									6IR125ISO	●	●		●	-	0.9	-	0.09	
6	1.5	R									6IR15ISO	●	●		●	-	0.9	-	0.11	
6	1.75	R									6IR175ISO	●	●		●	-	0.9	-	0.12	
6	2	R									6IR20ISO	●	●		●	-	0.9	-	0.14	
06	0.5	R									06IR05ISO		●**			4	0.4	0.6	0.04	
06	0.75	R									06IR075ISO		●**			4	0.5	0.6	0.06	
06	1	R									06IR10ISO		●**			4	0.6	0.6	0.05	
06	1.25	R									06IR125ISO		●**			4	0.6	0.6	0.07	
08	1	R									08IR10ISO		●**			5	0.6	0.6	0.07	
08	1.25	R									08IR125ISO		●**			5	0.7	0.7	0.09	
08	1.5	R									08IR15ISO		●**			5	0.7	0.7	0.1	
08	1.75	R									08IR175ISO		●**			5	0.8	0.6	0.15	
11	0.35	R	11ER035ISO		●			6.35	0.4	0.6	0.04									
11	0.5	R	11ER05ISO		●			6.35	0.6	0.6	0.07	11IR05ISO		●		●	6.35	0.5	1.2	0.04
11	0.7	R	11ER07ISO		●			6.35	0.6	0.6	0.11									
11	0.75	R	11ER075ISO		●			6.35	0.6	0.6	0.11	11IR075ISO	●	●			6.35	0.5	1.2	0.05
11	0.8	R	11ER080ISO		●			6.35	0.6	0.6	0.12									
11	1	R	11ER10ISO		●			6.35	0.7	0.7	0.15	11IR10ISO	●	●		●	6.35	0.9	0.7	0.07
11	1	L									11IL10ISO	●	●			6.35	0.9	0.7	0.07	
11	1.25	R	11ER125ISO		●			6.35	0.9	0.8	0.16	11IR125ISO		●			6.35	0.9	0.7	0.09
11	1.25	L									11IL125ISO		●			6.35	0.9	0.7	0.09	
11	1.5	R	11ER15ISO		●			6.35	0.8	1	0.19	11IR15ISO	●	●		●	6.35	0.9	0.7	0.11
11	1.5	L									11IL15ISO	●	●			6.35	0.9	0.7	0.11	
11	1.75	R									11IR175ISO		●		●	6.35	0.9	0.7	0.12	
11	1.75	L									11IL175ISO		●			6.35	0.9	0.7	0.12	
11	2	R									11IR20ISO	●	●		●	6.35	0.9	0.7	0.14	
11	2	L									11IL20ISO	●	●			6.35	0.9	0.7	0.14	

●** : Both ..06IR... and ..08IR... inserts have 3 cutting edges.

Reference pages: External toolholders → 36 - 41, Internal toolholders → 57 - 59

● : Line up
Package quantity = 5 pcs.

Full-profile insert

Insert size	Pitch (Reference)	Hand of cut	External insert									Internal insert									
			Designation	Grade				IC	PDX	PDY	RE	Designation	Grade					IC	PDX	PDY	RE
				Coated			Uncoated						Coated			Uncoated					
				AH8015	AH725	T313V							TH10	AH8015	AH725		GH330				
16	0.5	R	16ER05ISO	●	●		●	9.525	0.5	1.2	0.06	16IR05ISO		●				9.525	0.5	1.2	0.04
16	0.75	R	16ER075ISO	●	●	●	●	9.525	0.5	1.2	0.09	16IR075ISO		●				9.525	0.5	1.2	0.05
16	1	R	16ER10ISO	●	●	●	●	9.525	0.9	0.7	0.13	16IR10ISO	●	●		●	●	9.525	0.9	0.7	0.07
16	1	L										16IL10ISO	●	●				9.525	0.9	0.7	0.07
16	1.25	R	16ER125ISO	●	●	●		9.525	0.9	0.7	0.16	16IR125ISO		●				9.525	0.9	0.7	0.09
16	1.25	L										16IL125ISO		●				9.525	0.9	0.7	0.09
16	1.5	R	16ER15ISO	●	●	●	●	9.525	0.9	0.7	0.19	16IR15ISO	●	●		●	●	9.525	0.9	0.7	0.11
16	1.5	L	16EL15ISO	●				9.525	0.9	0.7	0.19	16IL15ISO	●	●				9.525	0.9	0.7	0.11
16	1.75	R	16ER175ISO	●	●	●		9.525	1.6	1.2	0.22	16IR175ISO		●		●		9.525	1.6	1.2	0.12
16	2	R	16ER20ISO	●	●	●	●	9.525	1.6	1.2	0.25	16IR20ISO	●	●		●	●	9.525	1.6	1.2	0.14
16	2	L	16EL20ISO	●	●			9.525	1.6	1.2	0.25	16IL20ISO		●				9.525	1.6	1.2	0.14
16	2.5	R	16ER25ISO	●	●	●	●	9.525	1.6	1.2	0.31	16IR25ISO	●	●		●	●	9.525	1.6	1.2	0.18
16	3	R	16ER30ISO	●	●	●	●	9.525	1.6	1.2	0.38	16IR30ISO	●	●		●	●	9.525	1.6	1.2	0.21
16	3	L										16IL30ISO		●				9.525	1.6	1.2	0.21
22	3.5	R	22ER35ISO	●	●	●		12.7	2.5	1.7	0.44	22IR35ISO	●	●		●		12.7	2.5	1.7	0.25
22	4	R	22ER40ISO	●	●	●		12.7	2.5	1.7	0.5	22IR40ISO	●	●		●		12.7	2.5	1.7	0.28
22	4.5	R	22ER45ISO	●	●			12.7	2.5	1.7	0.56	22IR45ISO	●	●				12.7	2.5	1.7	0.32
22	5	R	22ER50ISO		●	●		12.7	2.5	1.7	0.63	22IR50ISO		●		●		12.7	2.5	1.7	0.35
27	6	R	27ER60ISO		●	●		15.875	3.2	2.2	0.75	27IR60ISO		●		●		15.875	3.2	2.2	0.42

Full-profile insert with chipbreaker

Insert size	Pitch (Reference)	Hand of cut	External insert								Internal insert							
			Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
				Coated		Cermet						Coated		Cermet				
				AH8015	AH725	NS9530						AH8015	AH725	NS9530				
11	0.5	R									11IR05ISO-B	●		6.35	0.5	1.2	0.04	
11	0.5	R									11IR05ISO-M		●	6.35	0.5	1.2	0.04	
11	0.75	R									11IR075ISO-B	●		6.35	0.5	1.2	0.05	
11	0.75	R									11IR075ISO-M		●	6.35	0.5	1.2	0.05	
11	1	R									11IR10ISO-B	●		6.35	0.9	0.7	0.08	
11	1	R									11IR10ISO-M	●		●	6.35	0.9	0.7	0.08
11	1.25	R									11IR125ISO-B	●		6.35	0.9	0.7	0.1	
11	1.25	R									11IR125ISO-M	●		●	6.35	0.9	0.7	0.1
11	1.5	R									11IR15ISO-B	●		6.35	0.9	0.7	0.12	
11	1.5	R									11IR15ISO-M	●		●	6.35	0.9	0.7	0.12
11	1.75	R									11IR175ISO-B	●		6.35	0.9	0.7	0.12	
11	1.75	R									11IR175ISO-M		●	6.35	0.9	0.7	0.12	
11	2	R									11IR20ISO-B	●		6.35	0.9	0.7	0.14	
11	2	R									11IR20ISO-M	●		●	6.35	0.9	0.7	0.14

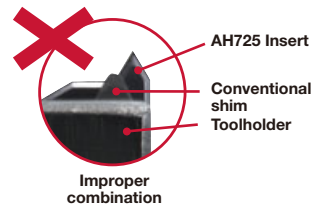
Reference pages: External toolholders → **36 - 41**, Internal toolholders → **57 - 59**

● : Line up
Package quantity = 5 pcs.

Full-profile insert with chipbreaker

Insert size	Pitch (Reference)	Hand of cut	External insert								Internal insert							
			Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
				Coated		Cermet						Coated		Cermet				
				AH8015	AH725	NS9530						AH8015	AH725	NS9530				
16	0.5	R	16ER05ISO-M		●	9.525	0.5	1.2	0.06									
16	0.75	R	16ER075ISO-B		●*	9.525	0.6	0.6	0.08									
16	0.75	R	16ER075ISO-M	●	●	9.525	0.5	1.2	0.09									
16	1	R	16ER10ISO-B		●*	9.525	0.7	0.7	0.11	16IR10ISO-B		●*	9.525	0.7	0.6	0.05		
16	1	R	16ER10ISO-M	●	●	●	9.525	0.9	0.7	0.13	16IR10ISO-M	●	●	9.525	0.9	0.7	0.08	
16	1.25	R	16ER125ISO-B		●*	9.525	0.9	0.8	0.14	16IR125ISO-B		●*	9.525	0.9	0.8	0.06		
16	1.25	R	16ER125ISO-M	●	●	●	9.525	0.9	0.7	0.16	16IR125ISO-M	●	●	9.525	0.9	0.7	0.1	
16	1.5	R	16ER15ISO-B		●*	9.525	1	0.8	0.19	16IR15ISO-B		●*	9.525	1	0.8	0.08		
16	1.5	R	16ER15ISO-M	●	●	●	9.525	0.9	0.7	0.19	16IR15ISO-M	●	●	●	9.525	0.9	0.7	0.12
16	1.75	R	16ER175ISO-B		●*	9.525	1.2	0.9	0.25	16IR175ISO-B		●*	9.525	1.2	0.9	0.10		
16	1.75	R	16ER175ISO-M	●	●	●	9.525	1.6	1.2	0.22	16IR175ISO-M		●	9.525	1.6	1.2	0.14	
16	2	R	16ER20ISO-B		●*	9.525	1.3	1	0.28	16IR20ISO-B		●*	9.525	1.3	1	0.11		
16	2	R	16ER20ISO-M	●	●	●	9.525	1.6	1.2	0.25	16IR20ISO-M	●	●	9.525	1.6	1.2	0.14	
16	2.5	R	16ER25ISO-B		●*	9.525	1.5	1.1	0.3	16IR25ISO-B		●*	9.525	1.5	1.1	0.14		
16	2.5	R	16ER25ISO-M	●	●	●	9.525	1.6	1.2	0.31	16IR25ISO-M	●	●	9.525	1.6	1.2	0.18	
16	3	R	16ER30ISO-B		●*	9.525	1.6	1.2	0.38	16IR30ISO-B		●*	9.525	1.5	1.1	0.22		
16	3	R	16ER30ISO-M	●	●	●	9.525	1.6	1.2	0.38	16IR30ISO-M	●	●	9.525	1.6	1.2	0.21	
22	3.5	R	22ER35ISO-B		●	12.7	2.3	1.6	0.48									
22	4	R	22ER40ISO-B		●	12.7	2.3	1.6	0.52									

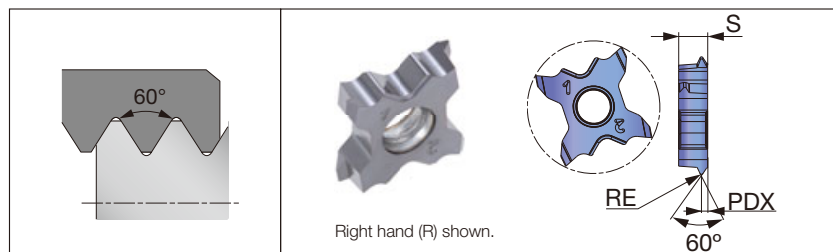
- * : The cutting edge position needs re-adjusting for these inserts have different PDY and PDX dimensions (Note: for size 16 inserts only).
 - requires the use of dedicated shim.
- When using a new AH725 with chipbreaker, the conventional shim may need to be replaced with a new standard shim. Please refer to the page 67.



TETRAMCUT

INSERT

ISO metric (General purpose)



Applicable toolholder

External
STCR/L**-18
STCR/L**18-CHP
JS**-STCL18
C*STCFL**18-CHP
C*STCR/L**18-CHP
QC**STCR/L18 (-Y)
QC**STCR/L18 (-Y)-CHP

Partial-profile insert

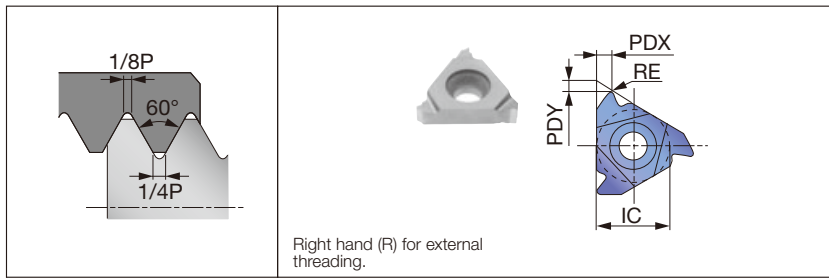
Pitch	Hand of cut	External insert					
		Designation	Grade		PDX	RE	S
			Coated				
			SH725	AH725			
0.5	R	TCT18FR-05ISO	●		0.35	0.06	4
0.7	R	TCT18FR-07ISO	●		0.45	0.09	4
0.75	R	TCT18FR-075ISO	●		0.5	0.09	4
0.8	R	TCT18FR-08ISO	●		0.5	0.1	4
1	R	TCT18R-10ISO		●	0.6	0.13	4
1.25	R	TCT18R-125ISO		●	0.7	0.17	4
1.5	R	TCT18R-15ISO		●	0.8	0.2	4

● : Line up / 5 pieces per package

● : New product
● : Line up
Package quantity = 5 pcs.

Reference pages: External toolholders → 36 - 41, TetraMini-Cut → 42 - 44, Internal toolholders → 57 - 59

Unified (General purpose)



Applicable toolholder

Insert size	External	Internal
11	SER**11	SNR/L**11...
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...

Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert							
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					Coated								Coated						
					AH8015	AH725	T313V						AH8015	AH725	T313V				
11 (0.794)	32	R									11IR32UN	●	6.35	0.5	1.2	0.06			
11 (0.907)	28	R									11IR28UN	●	6.35	0.5	1.2	0.06			
11 (1.058)	24	R									11IR24UN	●	6.35	0.9	0.7	0.07			
11 (1.27)	20	R									11IR20UN	●	6.35	0.9	0.7	0.09			
11 (1.411)	18	R									11IR18UN	●	6.35	0.9	0.7	0.1			
11 (1.588)	16	R									11IR16UN	●●	6.35	0.9	0.7	0.11			
11 (1.814)	14	R									11IR14UN	●	6.35	0.9	0.7	0.13			
16 (0.794)	32	R	16ER32UN	●	●	9.525	0.5	1.2	0.1	16IR32UN	●	9.525	0.5	1.2	0.06				
16 (0.907)	28	R	16ER28UN	●	●	9.525	0.5	1.2	0.11	16IR28UN	●	9.525	0.5	1.2	0.06				
16 (1.058)	24	R	16ER24UN	●	●	9.525	0.9	0.7	0.13	16IR24UN	●	9.525	0.9	0.7	0.07				
16 (1.27)	20	R	16ER20UN	●	●	9.525	0.9	0.7	0.16	16IR20UN	●	9.525	0.9	0.7	0.09				
16 (1.411)	18	R	16ER18UN	●	●	9.525	0.9	0.7	0.18	16IR18UN	●	9.525	0.9	0.7	0.1				
16 (1.588)	16	R	16ER16UN	●	●●	9.525	0.9	0.7	0.2	16IR16UN	●●	9.525	0.9	0.7	0.11				
16 (1.814)	14	R	16ER14UN	●	●●	9.525	1.6	1.2	0.23	16IR14UN	●●	9.525	1.6	1.2	0.13				
16 (1.954)	13	R	16ER13UN		●	9.525	1.6	1.2	0.24	16IR13UN	●	9.525	1.6	1.2	0.14				
16 (2.117)	12	R	16ER12UN	●	●●	9.525	1.6	1.2	0.27	16IR12UN	●●	9.525	1.6	1.2	0.15				
16 (2.309)	11	R	16ER11UN		●	9.525	1.6	1.2	0.29	16IR11UN	●	9.525	1.6	1.2	0.16				
16 (2.54)	10	R	16ER10UN	●	●	9.525	1.6	1.2	0.32	16IR10UN	●	9.525	1.6	1.2	0.18				
16 (2.822)	9	R	16ER9UN		●	9.525	1.6	1.2	0.35	16IR9UN	●	9.525	1.6	1.2	0.2				
16 (3.175)	8	R	16ER8UN		●●	9.525	1.6	1.2	0.4	16IR8UN	●●	9.525	1.6	1.2	0.22				
22 (3.629)	7	R	22ER7UN		●	12.7	2.5	1.7	0.45	22IR7UN	●	12.7	2.5	1.7	0.25				
22 (4.233)	6	R	22ER6UN		●	12.7	2.5	1.7	0.53	22IR6UN	●	12.7	2.5	1.7	0.3				
22 (5.08)	5	R	22ER5UN		●	12.7	2.5	1.7	0.64	22IR5UN	●	12.7	2.5	1.7	0.36				

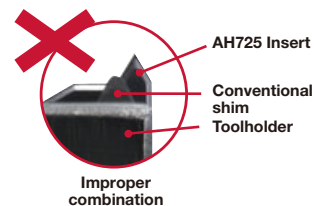
Reference pages: External toolholders → **36 - 41**, Internal toolholders → **57 - 59**

● : Line up
Package quantity = 5 pcs.

Full-profile insert with chipbreaker

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert							
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					Coated		Cermet						Coated		Cermet				
					AH8015	AH725	NS9530						AH8015	AH725	NS9530				
16 (1.058)	24	R	16ER24UN-B	●*			9.525	0.8	0.7	0.11									
16 (1.058)	24	R	16ER24UN-M	●			9.525	0.9	0.7	0.13									
16 (1.27)	20	R	16ER20UN-B	●*			9.525	0.9	0.8	0.14	16IR20UN-B	●*			9.525	0.9	0.8	0.06	
16 (1.27)	20	R	16ER20UN-M	●	●		9.525	0.9	0.7	0.16	16IR20UN-M	●			9.525	0.9	0.7	0.09	
16 (1.411)	18	R	16ER18UN-B	●*			9.525	1	0.8	0.15	16IR18UN-B	●*			9.525	1	0.8	0.08	
16 (1.411)	18	R	16ER18UN-M	●	●		9.525	0.9	0.7	0.18	16IR18UN-M	●	●			9.525	0.9	0.7	0.1
16 (1.588)	16	R	16ER16UN-B	●*			9.525	1.1	0.9	0.19	16IR16UN-B	●*			9.525	1.1	0.9	0.09	
16 (1.588)	16	R	16ER16UN-M	●	●		9.525	0.9	0.7	0.2	16IR16UN-M	●			9.525	0.9	0.7	0.11	
16 (1.814)	14	R	16ER14UN-B	●*			9.525	1.2	1	0.22	16IR14UN-B	●*			9.525	1.2	0.9	0.11	
16 (1.814)	14	R	16ER14UN-M	●	●		9.525	1.6	1.2	0.23	16IR14UN-M	●	●			9.525	1.6	1.2	0.13
16 (1.954)	13	R	16ER13UN-B	●*			9.525	1.3	1	0.24									
16 (2.117)	12	R	16ER12UN-B	●*			9.525	1.4	1.1	0.25	16IR12UN-B	●*			9.525	1.4	1.1	0.12	
16 (2.117)	12	R	16ER12UN-M	●	●		9.525	1.6	1.2	0.27	16IR12UN-M	●	●			9.525	1.6	1.2	0.15
16 (3.175)	8	R	16ER8UN-B	●*			9.525	1.6	1.2	0.41	16IR8UN-B	●*			9.525	1.5	1.1	0.20	
16 (3.175)	8	R	16ER8UN-M	●	●		9.525	1.6	1.2	0.4	16IR8UN-M	●	●			9.525	1.6	1.2	0.22

- * : The cutting edge position needs re-adjusting for these inserts have different PDY and PDX dimensions (Note: for size 16 inserts only).
 - requires the use of dedicated shim.
- When using a new AH725 with chipbreaker, the conventional shim may need to be replaced with a new standard shim. Please refer to the page 67.



Thread form

60°

55°

M
(Metric)

UN
(Unified)

W
(Whitworth)

BSPT
(R, PT)

NPT

NPTF

TR
(Metric, 30° Trapezoidal)

Round
(DIN405)

UNJ

MJ

ACME
(29° Trapezoidal)

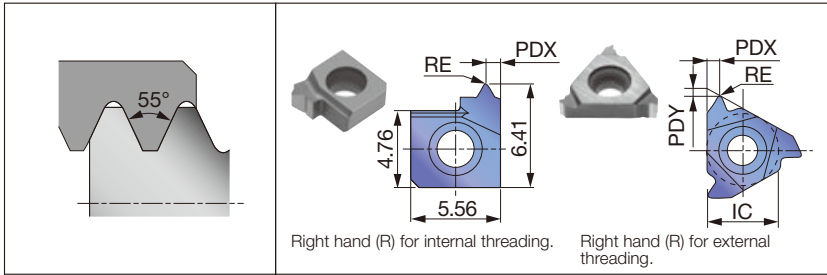
STUB
ACME
(29° Trapezoidal)

API
Round

API
Buttress

API
Rotary
Shoulder
Connection

Whitworth, Parallel pipe thread



Applicable toolholder

Insert size	External	Internal
6		SNR/L000*K06SC... SNR/L000*H06...
11	SER**11	SNR/L**11...
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...

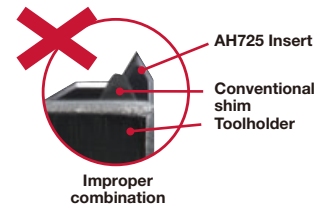
Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert									
				Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE
					Coated		Uncoated	Coated						Uncoated							
					AH8015	AH725		T313V							TH10	AH8015	AH725				
6 (1.337)	19	R										61R19W	●	●	●	●	-	0.9	-	0.17	
11 (1.337)	19	R										111R19W	●	●	●	●	6.35	0.9	0.7	0.17	
11 (1.814)	14	R										111R14W	●	●	●	●	6.35	0.9	0.7	0.23	
16 (0.907)	28	R		16ER28W	●	●			9.525	0.9	0.7	0.11	161R28W	●				9.525	0.9	0.7	0.11
16 (0.97)	26	R		16ER26W	●				9.525	0.9	0.7	0.12	161R26W	●				9.525	0.9	0.7	0.12
16 (1.27)	20	R		16ER20W	●				9.525	0.9	0.7	0.16	161R20W	●				9.525	0.9	0.7	0.16
16 (1.337)	19	R		16ER19W	●	●	●		9.525	0.9	0.7	0.17	161R19W	●				9.525	0.9	0.7	0.17
16 (1.411)	18	R		16ER18W	●				9.525	0.9	0.7	0.18	161R18W	●				9.525	0.9	0.7	0.18
16 (1.588)	16	R		16ER16W	●	●			9.525	0.9	0.7	0.2	161R16W	●	●			9.525	0.9	0.7	0.2
16 (1.814)	14	R		16ER14W	●	●	●	●	9.525	1.6	1.2	0.23	161R14W	●	●	●	●	9.525	1.6	1.2	0.23
16 (1.814)	14	L		16EL14W	●				9.525	1.6	1.2	0.23									
16 (2.117)	12	R		16ER12W	●	●			9.525	1.6	1.2	0.27	161R12W	●	●			9.525	1.6	1.2	0.27
16 (2.309)	11	R		16ER11W	●	●	●	●	9.525	1.6	1.2	0.29	161R11W	●	●	●	●	9.525	1.6	1.2	0.29
16 (2.54)	10	R		16ER10W	●	●			9.525	1.6	1.2	0.32	161R10W	●	●			9.525	1.6	1.2	0.32
16 (2.822)	9	R		16ER9W	●				9.525	1.6	1.2	0.35	161R9W	●				9.525	1.6	1.2	0.35
16 (3.175)	8	R		16ER8W	●	●			9.525	1.6	1.2	0.4	161R8W	●	●			9.525	1.6	1.2	0.4
22 (3.629)	7	R		22ER7W	●				12.7	2.5	1.7	0.45	221R7W	●				12.7	2.5	1.7	0.45
22 (4.233)	6	R		22ER6W	●				12.7	2.5	1.7	0.53	221R6W	●				12.7	2.5	1.7	0.53
22 (5.08)	5	R		22ER5W	●				12.7	2.5	1.7	0.64	221R5W	●				12.7	2.5	1.7	0.64

Full-profile insert with chipbreaker

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert							
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					Coated		Cermet						Coated		Cermet				
					AH8015	AH725	NS9530						AH8015	AH725	NS9530				
16 (1.337)	19	R	16ER19W-B	●*		9.525	1	0.8	0.16										
16 (1.337)	19	R	16ER19W-M	●		●	9.525	0.9	0.7	0.17	16IR19W-M		●	9.525	0.9	0.7	0.17		
16 (1.588)	16	R	16ER16W-B	●*		9.525	1.1	0.9	0.2	16IR16W-B	●*		9.525	1.1	0.9	0.18			
16 (1.814)	14	R	16ER14W-B	●*		9.525	1.2	1	0.24	16IR14W-B	●*		9.525	1.2	1	0.21			
16 (1.814)	14	R	16ER14W-M	●		●	9.525	1.6	1.2	0.23	16IR14W-M	●	●	9.525	1.6	1.2	0.23		
16 (2.309)	11	R	16ER11W-B	●*		9.525	1.5	1.1	0.27	16IR11W-B	●*		9.525	1.5	1.1	0.27			
16 (2.309)	11	R	16ER11W-M	●		●	9.525	1.6	1.2	0.29	16IR11W-M	●	●	9.525	1.6	1.2	0.29		

- ●* : The cutting edge position needs re-adjusting for these inserts have different PDY and PDX dimensions (Note: for size 16 inserts only).
 - requires the use of dedicated shim.
- When using a new AH725 with chipbreaker, the conventional shim may need to be replaced with a new standard shim. Please refer to the page [67](#).



Thread form

60°

55°

M
(Metric)

UN
(Unified)

W
(Whitworth)

BSPT
(R, PT)

NPT

NPTF

TR
(Metric, 30° Trapezoidal)

Round
(DIN405)

UNJ

MJ

ACME
(29° Trapezoidal)

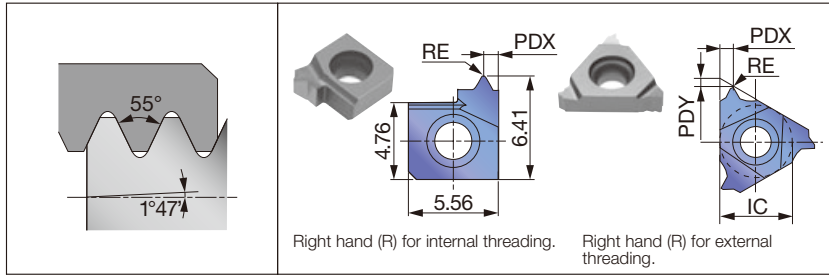
STUB
ACME
(29° Trapezoidal)

API
Round

API
Buttress

API
Rotary
Shoulder
Connection

BSPT (for Pipe)



Applicable toolholder

Insert size	External	Internal
6		SNR/L000*K06SC... SNR/L000*H06...
11	SER**11	SNR/L**11...
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...

Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert									
				Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE
					Coated		Uncoated	Coated						Uncoated							
					AH8015	AH725		T313V							TH10	AH8015	AH725				
6	(1.337)	19	R									6IR19PT	●	●	●	-	0.9	-	0.14		
11	(1.337)	19	R									11IR19PT	●	●	●	●	6.35	0.9	0.7	0.14	
11	(1.814)	14	R									11IR14PT	●	●	●	●	6.35	0.9	0.7	0.16	
16	(0.907)	28	R	16ER28PT		●	●		9.525	0.9	0.7	0.09									
16	(1.337)	19	R	16ER19PT	●	●	●		9.525	0.9	0.7	0.14	16IR19PT		●		9.525	0.9	0.7	0.14	
16	(1.814)	14	R	16ER14PT	●	●	●		9.525	1.6	1.2	0.16	16IR14PT	●	●	●	●	9.525	1.6	1.2	0.16
16	(2.309)	11	R	16ER11PT	●	●	●		9.525	1.6	1.2	0.26	16IR11PT	●	●	●	●	9.525	1.6	1.2	0.26

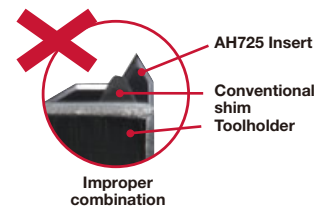
Full-profile insert with chipbreaker

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert							
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					Coated		Cermet						Coated		Cermet				
					AH8015	AH725	NS9530						AH8015	AH725	NS9530				
16 (1.337)	19	R	16ER19PT-M			●	9.525	0.9	0.7	0.18	16IR19PT-M			●	9.525	0.9	0.7	0.18	
16 (1.814)	14	R	16ER14PT-B			●*	9.525	1.2	1	0.24	16IR14PT-B			●*	9.525	1.2	1	0.21	
16 (1.814)	14	R	16ER14PT-M	●		●	9.525	1.6	1.2	0.25	16IR14PT-M	●		●	9.525	1.6	1.2	0.25	
16 (2.309)	11	R	16ER11PT-B			●*	9.525	1.5	1.1	0.31	16IR11PT-B			●*	9.525	1.5	1.1	0.28	
16 (2.309)	11	R	16ER11PT-M	●		●	9.525	1.6	1.2	0.32	16IR11PT-M	●		●	9.525	1.6	1.2	0.32	

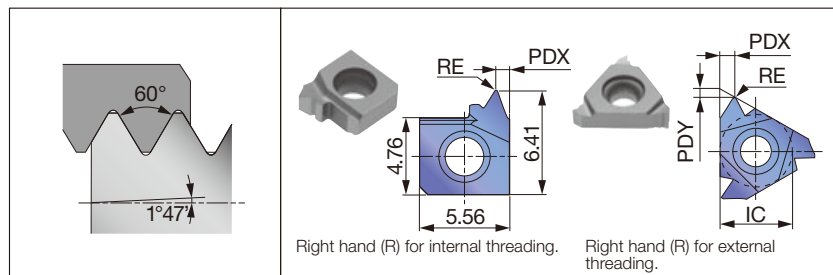
- ●* : The cutting edge position needs re-adjusting for these inserts have different PDY and PDX dimensions (Note: for size 16 inserts only).

- requires the use of dedicated shim.

When using a new AH725 with chipbreaker, the conventional shim may need to be replaced with a new standard shim. Please refer to the page 67.



NPT (for Pipe)



Applicable toolholder

Insert size	External	Internal
6		SNR/L000*K06SC... SNR/L000*H06...
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...

Thread form

60°

55°

M
(Metric)

UN
(Unified)

W
(Whitworth)

BSPT
(R, PT)

NPT

NPTF

TR
(Metric, 30° Trapezoidal)

Round
(DIN405)

UNJ

MJ

ACME
(29° Trapezoidal)

STUB ACME
(29° Trapezoidal)

API
Round

API
Buttress

API
Rotary Shoulder Connection

Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert									
				Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE
					Coated		Uncoated	Coated						Uncoated							
					AH8015	AH725		T313V							TH10	AH8015	AH725				
6	(1.411)	18	R									6IR18NPT	●	●	-	0.9	-	0.03			
16	(0.941)	27	R	16ER27NPT	●				9.525	0.5	1.2	0.02	16IR27NPT	●			9.525	0.5	1.2	0.02	
16	(1.411)	18	R	16ER18NPT	●	●			9.525	0.9	0.7	0.03	16IR18NPT	●			9.525	0.9	0.7	0.03	
16	(1.814)	14	R	16ER14NPT	●				9.525	1.6	1.2	0.04	16IR14NPT	●	●	●	9.525	1.6	1.2	0.04	
16	(2.209)	11.5	R	16ER115NPT	●				9.525	1.6	1.2	0.05	16IR115NPT	●		●	9.525	1.6	1.2	0.05	
16	(3.175)	8	R	16ER8NPT	●				9.525	1.6	1.2	0.07	16IR8NPT	●	●		9.525	1.6	1.2	0.07	

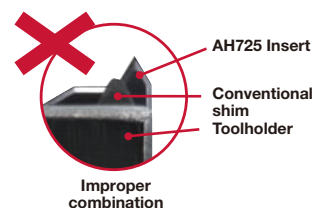
Full-profile insert with chipbreaker

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert											
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE				
					Coated	Cermet	AH8015						AH725	NS9530	Coated					Cermet	AH8015	AH725	NS9530
16 (1.411)	18	R	16ER18NPT-B	●*		9.525	1	0.8	0.05														
16 (1.411)	18	R	16ER18NPT-M	●	●	9.525	0.9	0.7	0.07	16IR18NPT-M	●		9.525	0.9	0.7	0.07							
16 (1.814)	14	R	16ER14NPT-B	●*		9.525	1.2	0.9	0.05	16IR14NPT-B	●*		9.525	1.2	0.9	0.05							
16 (1.814)	14	R	16ER14NPT-M	●	●	9.525	1.6	1.2	0.08	16IR14NPT-M	●	●	9.525	1.6	1.2	0.08							
16 (2.209)	11.5	R	16ER115NPT-B	●*		9.525	1.5	1.1	0.09	16IR115NPT-B	●*		9.525	1.5	1.1	0.09							
16 (2.209)	11.5	R	16ER115NPT-M	●	●	9.525	1.6	1.2	0.09	16IR115NPT-M	●	●	9.525	1.6	1.2	0.09							
16 (3.175)	8	R	16ER8NPT-B	●*		9.525	1.8	1.3	0.12	16IR8NPT-B	●*		9.525	1.8	1.3	0.12							

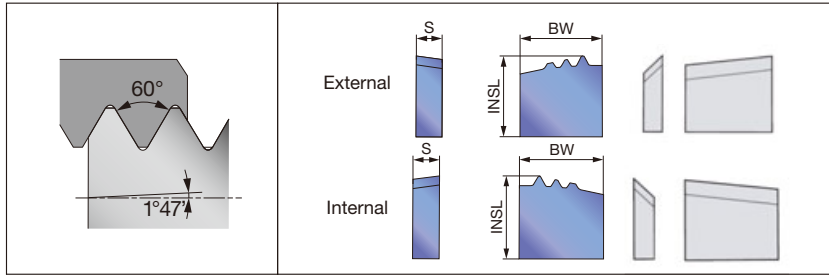
- ●* : The cutting edge position needs re-adjusting for these inserts have different PDY and PDX dimensions (Note: for size 16 inserts only).

- requires the use of dedicated shim.

When using a new AH725 with chipbreaker, the conventional shim may need to be replaced with a new standard shim. Please refer to the page 67.



NPT (for Pipe)



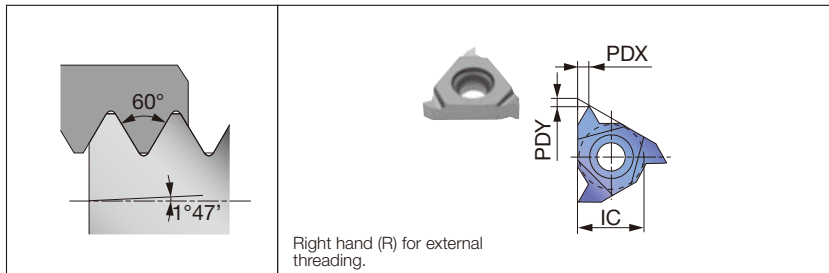
Applicable toolholder

External	Internal
CLVOR-**M...	SI-CLHOR...

Full-profile insert (chaser)

Pitch (Reference)	TPI	Taper		External insert							Internal insert						
				Designation	Grade	BW	INSL	S	Chip breaking attachment	Designation	Grade	BW	INSL	S	Chip breaking attachment		
		Coated	Coated														
		mm/mm	TPF		AH725						AH725						
(2.209)	11.5	1/16	0.75	CR-11.5NPT-4E	●	16	15.7	5.2	CR-8R / 10R-3E / 4E-CB	CR-11.5NPT-4I	●	16	15.7	5.2	CR-8R / 10R-3I / 4I-CB		
(3.175)	8	1/16	0.75	CR-8NPT-4E	●	16	15.7	5.2	CR-8R / 10R-3E / 4E-CB	CR-8NPT-4I	●	16	15.7	5.2	CR-8R / 10R-3I / 4I-CB		

NPTF (for Pipe)



Applicable toolholder

Insert size	External	Internal
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...

Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert						Internal insert					
				Designation	Grade	IC	PDX	PDY	RE	Designation	Grade	IC	PDX	PDY	RE
					Coated						Coated				
					AH725						AH725				
16 (0.941)	27	R		16ER27NPTF	●	9.525	0.5	1.2	-						
16 (1.411)	18	R		16ER18NPTF	●	9.525	0.9	0.7	-						
16 (1.814)	14	R		16ER14NPTF	●	9.525	1.6	1.2	-	16IR14NPTF	●	9.525	1.6	1.2	-
16 (2.209)	11.5	R		16ER115NPTF	●	9.525	1.6	1.2	-	16IR115NPTF	●	9.525	1.6	1.2	-
16 (3.175)	8	R		16ER8NPTF	●	9.525	1.6	1.2	-	16IR8NPTF	●	9.525	1.6	1.2	-

Reference pages: NPT : External toolholders → **56**, Internal toolholders → **65**
 NPTF : External toolholders → **36 - 41**, Internal toolholders → **57 - 59**

● : Line up
 Package quantity = 5 pcs.

30° Trapezoidal / DIN103 (for Machine parts)



Applicable toolholder

Insert size	External	Internal
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...
27	CER/L**27...	CNR/L**27...

With the special full-profile insert

Insert size	Pitch (Reference)	Hand of cut	External insert						Internal insert					
			Designation	Grade		IC	PDX	PDY	Designation	Grade		IC	PDX	PDY
				Coated						Coated				
				AH725	T313V					AH725	T313V			
16	1.5	R	16ER15TR	●		9.525	0.9	0.7	16IR15TR	●		9.525	0.9	0.7
16	2	R	16ER20TR	●	●	9.525	1.6	1.3	16IR20TR	●	●	9.525	1.6	1.3
16	3	R	16ER30TR	●	●	9.525	1.6	1.3	16IR30TR	●	●	9.525	1.6	1.3
22	4	R	22ER40TR	●	●	12.7	2.5	2	22IR40TR	●	●	12.7	2.5	2
22	5	R	22ER50TR	●	●	12.7	2.5	2	22IR50TR	●	●	12.7	2.5	2
27	6	R	27ER60TR	●	●	15.875	3.2	2.5						

Round / DIN405 (for Machine parts)



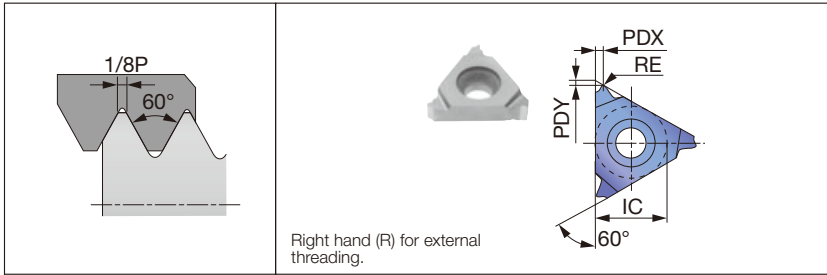
Applicable toolholder

Insert size	External	Internal
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...

Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert							Internal insert						
				Designation	Grade	IC	PDX	PDY	RE	Designation	Grade	IC	PDX	PDY	RE		
					Coated						Coated						
					AH725						AH725						
16	(3.175)	8	R	16ER8RD-B	●	9.525	1.3	1.4	0.75								
16	(4.233)	6	R	16ER6RD-B	●	9.525	1.7	1.5	1.01	16IR6RD-B	●	9.525	1.5	1.4	0.94		

UNJ (for Aerospace industry)



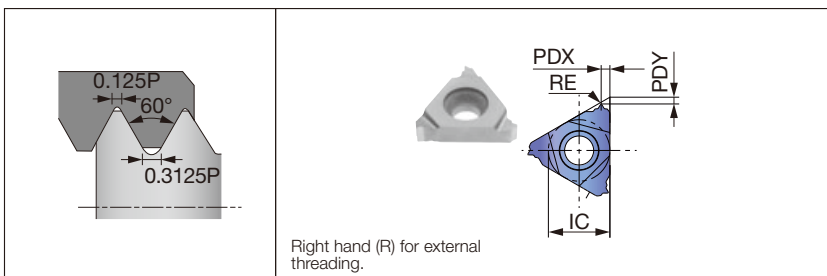
Applicable toolholder

Insert size	External
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16

Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert						
				Designation	Grade		IC	PDX	PDY	RE
					Coated					
					AH8015	AH725				
16 (0.794)	32	R	16ER32UNJ	●	●	9.525	0.5	1.2	0.13	
16 (0.907)	28	R	16ER28UNJ	●	●	9.525	0.5	1.2	0.15	
16 (1.058)	24	R	16ER24UNJ	●	●	9.525	0.9	0.7	0.18	
16 (1.27)	20	R	16ER20UNJ	●	●	9.525	0.9	0.7	0.21	
16 (1.411)	18	R	16ER18UNJ	●	●	9.525	0.9	0.7	0.24	
16 (1.588)	16	R	16ER16UNJ	●	●	9.525	0.9	0.7	0.26	
16 (1.814)	14	R	16ER14UNJ	●	●	9.525	1.6	1.2	0.3	
16 (2.117)	12	R	16ER12UNJ	●	●	9.525	1.6	1.2	0.35	
16 (2.54)	10	R	16ER10UNJ	●	●	9.525	1.6	1.2	0.42	
16 (3.175)	8	R	16ER8UNJ	●	●	9.525	1.6	1.2	0.53	

MJ (for Aerospace industry)



Applicable toolholder

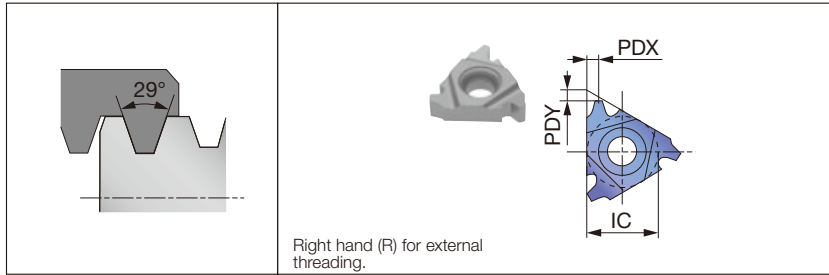
Insert size	Internal
11	SNR/L**11...

Insert size	Pitch (Reference)	Hand of cut	Internal insert					
			Designation	Grade	IC	PDX	PDY	RE
				Coated				
				AH8015				
11	1	R	11IR10MJ	●	6.35	0.9	0.7	0.05

Reference pages: UNJ : External toolholders → **36 - 41**
MJ : Internal toolholders → **58**

● : Line up
Package quantity = 5 pcs.

29° Trapezoidal / ACME (for Machine parts, Pipe)



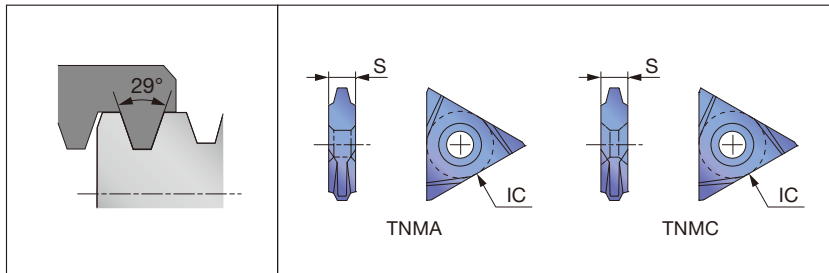
Applicable toolholder

Insert size	External	Internal
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...

With the special full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert						Internal insert					
				Designation	Grade		IC	PDX	PDY	Designation	Grade		IC	PDX	PDY
					Coated						Coated				
					AH725	T313V					AH725	T313V			
16 (2.117)	12	R	16ER12ACME	●		9.525	1.6	1.3	16IR12ACME	●		9.525	1.6	1.3	
16 (2.540)	10	R	16ER10ACME	●		9.525	1.6	1.3	16IR10ACME	●		9.525	1.6	1.3	
16 (3.175)	8	R	16ER8ACME	●	●	9.525	1.6	1.3	16IR8ACME	●	●	9.525	1.6	1.3	
22 (4.233)	6	R	22ER6ACME	●	●	12.7	2.5	2	22IR6ACME	●	●	12.7	2.5	2	
22 (5.080)	5	R	22ER5ACME	●	●	12.7	2.5	2	22IR5ACME	●	●	12.7	2.5	2	

29° Trapezoidal / ACME (for Machine parts, Pipe)



Applicable toolholder

External
MTVOR-**M...
STVOR-**M...

On edge

Pitch	TPI	Taper		External insert			
		mm/mm	TPF	Designation	Grade	IC	S
					Coated		
					AH725		
(1.588)	16	-	-	TNMA43NT16PEXT-PT	●	12.7	4.8
(1.814)	14	-	-	TNMA43NT14PEXT-PT	●	12.7	4.8
(2.117)	12	-	-	TNMA43NT12PEXT-PT	●	12.7	4.8
(2.54)	10	-	-	TNMA43NT10PEXT-PT	●	12.7	4.8
(3.175)	8	-	-	TNMA43NT8PEXT-PT	●	12.7	4.8
(4.233)	6	-	-	TNMA43NT6PEXT-PT	●	12.7	4.8
(5.08)	5	-	-	TNMA54NT5PEXT-PT	●	15.875	6.4
(6.35)	4	-	-	TNMA54NT4PEXT-PT	●	15.875	6.4
(8.47)	3	-	-	TNMA54NT3PEXT-PT	●	15.875	6.4
(1.588)	16	-	-	TNMC43NT16PEXT-PT	●	12.7	4.8
(1.814)	14	-	-	TNMC43NT14PEXT-PT	●	12.7	4.8
(2.117)	12	-	-	TNMC43NT12PEXT-PT	●	12.7	4.8
(2.54)	10	-	-	TNMC43NT10PEXT-PT	●	12.7	4.8
(3.175)	8	-	-	TNMC43NT8PEXT-PT	●	12.7	4.8
(4.233)	6	-	-	TNMC43NT6PEXT-PT	●	12.7	4.8
(5.08)	5	-	-	TNMC54NT5PEXT-PT	●	15.875	6.4
(6.35)	4	-	-	TNMC54NT4PEXT-PT	●	15.875	6.4
(8.47)	3	-	-	TNMC54NT3PEXT-PT	●	15.875	6.4

● : Line up
Package quantity = 5 pcs.

Reference pages: 29° Trapezoidal With the special full-profile insert : External toolholders → 36 - 41, Internal toolholders → 57 - 59
29° Trapezoidal On edge : External toolholders → 55

29° Trapezoidal/ STUB ACME (for Machine parts, Pipe)

On edge

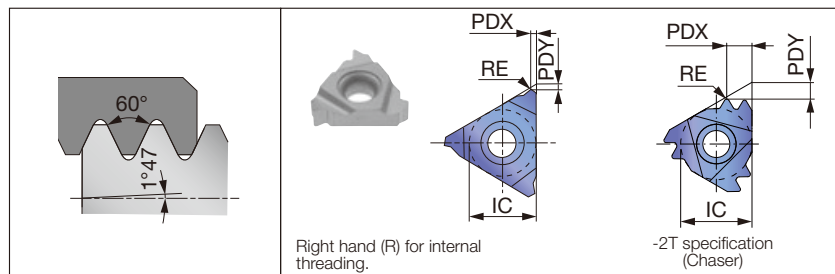
Pitch (Reference)	TPI	Taper		External insert			
		mm/mm	TPF	Designation	Grade	IC	S
					Coated AH725		
(1.588)	16	-	-	TNMA43NT16PSTUBE-PT	●	12.7	4.8
(1.814)	14	-	-	TNMA43NT14PSTUBE-PT	●	12.7	4.8
(2.117)	12	-	-	TNMA43NT12PSTUBE-PT	●	12.7	4.8
(2.54)	10	-	-	TNMA43NT10PSTUBE-PT	●	12.7	4.8
(3.175)	8	-	-	TNMA43NT8PSTUBE-PT	●	12.7	4.8
(4.233)	6	-	-	TNMA43NT6PSTUBE-PT	●	12.7	4.8
(5.08)	5	-	-	TNMA54NT5PSTUBE-PT	●	15.875	6.4
(6.35)	4	-	-	TNMA54NT4PSTUBE-PT	●	15.875	6.4
(8.47)	3	-	-	TNMA54NT3PSTUBE-PT	●	15.875	6.4
(1.588)	16	-	-	TNMC43NT16PSTUBE-PT	●	12.7	4.8
(1.814)	14	-	-	TNMC43NT14PSTUBE-PT	●	12.7	4.8
(2.117)	12	-	-	TNMC43NT12PSTUBE-PT	●	12.7	4.8
(2.54)	10	-	-	TNMC43NT10PSTUBE-PT	●	12.7	4.8
(3.175)	8	-	-	TNMC43NT8PSTUBE-PT	●	12.7	4.8
(4.233)	6	-	-	TNMC43NT6PSTUBE-PT	●	12.7	4.8
(5.08)	5	-	-	TNMC54NT5PSTUBE-PT	●	15.875	6.4
(6.35)	4	-	-	TNMC54NT4PSTUBE-PT	●	15.875	6.4
(8.47)	3	-	-	TNMC54NT3PSTUBE-PT	●	15.875	6.4

Applicable toolholder

External
MTVOR-**M...
STVOR-**M...

Note: ACME and STUB ACME can cut crest radius. Crest flat of ACME and STUB ACME need to be cut by another tool.

API Round (for Energy)



Applicable toolholder

Insert size	External	Internal
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...

Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert							
				Designation	Grade		IC	PDX	PDY	RE	Designation	Grade		IC	PDX	PDY	RE		
					Coated							Coated							
					AH725	T313V						AH8015	AH725					T313V	
16	(2.54)	10	R	16ER10RAPI	●		9.525	1.6	1.2	0.36	16IR10RAPI	●	●	9.525	1.6	1.2	0.36		
16	(3.175)	8	R	16ER8RAPI	●		9.525	1.6	1.2	0.43	16IR8RAPI	●	●	●	9.525	1.6	1.2	0.43	
22	(3.175)	8	R								22IR8RAPI-2T	●			12.7	4.5	3	0.43	

Full-profile insert with chipbreaker

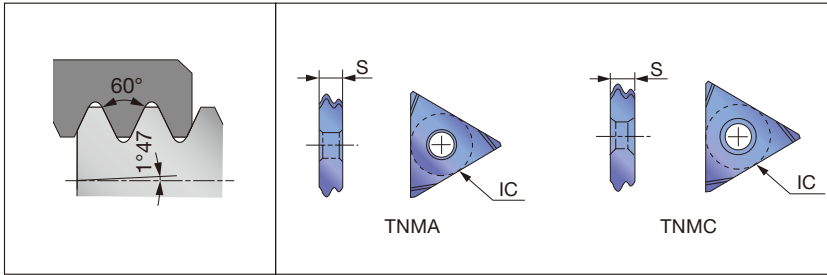
Insert size	Pitch (Reference)	TPI	Hand of cut	External insert								Internal insert							
				Designation	Grade	IC	PDX	PDY	RE	Designation	Grade	IC	PDX	PDY	RE				
					Coated						Coated								
					AH725						AH725								
16	(2.54)	10	R	16ER10RD-CB	●	9.525	1.2	1.5	0.36	16IR10RD-CB	●	9.525	1.2	1.5	0.36				
16	(3.175)	8	R	16ER8RD-CB	●	9.525	1.3	1.5	0.43	16IR8RD-CB	●	9.525	1.3	1.5	0.43				

Reference pages: 29° Trapezoidal : External toolholders → 55

API Round : External toolholders → 36 - 41, Internal toolholders → 57 - 59

● : Line up
Package quantity = 5 pcs.

API Round (for Energy)

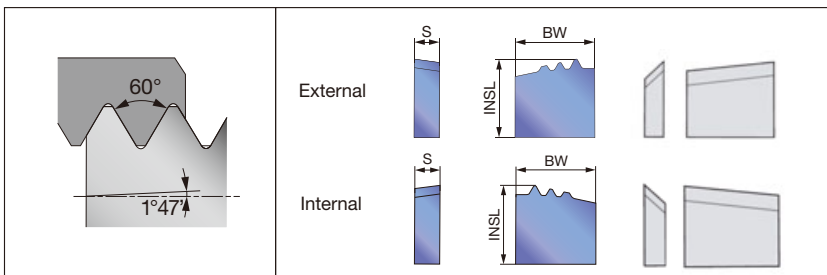


Applicable toolholder

External	Internal
MTVOR-**M...	HS**-MTHOR...
STVOR-**M...	

On edge

Pitch (Reference)	TPI	Taper		External insert				Internal insert			
		mm/mm	TPF	Designation	Grade Coated AH725	IC	S	Designation	Grade Coated AH725	IC	S
(2.54)	10	1/16	0.75	TNMA4310RDEXT	●	12.7	4.8	TNMA4310RDINT	●	12.7	4.8
(3.175)	8	1/16	0.75	TNMA438RDEXT	●	12.7	4.8	TNMA438RDINT	●	12.7	4.8
(2.54)	10	1/16	0.75	TNMC4310RDEXT	●	12.7	4.8	TNMC4310RDINT	●	12.7	4.8
(3.175)	8	1/16	0.75	TNMC438RDEXT	●	12.7	4.8	TNMC438RDINT	●	12.7	4.8

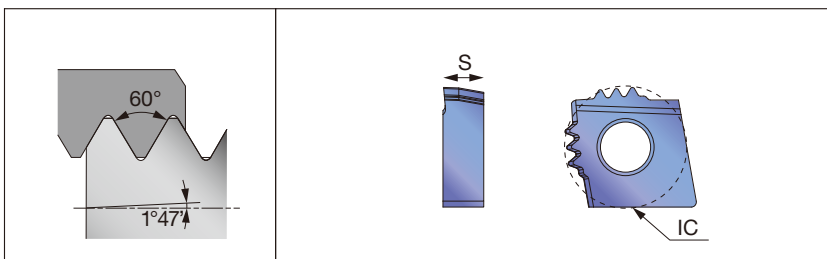


Applicable toolholder

External	Internal
CLVOR-**M...	SI-CLHOR...

Full-profile insert (chaser)

Pitch (Reference)	TPI	Taper		External insert						Internal insert					
		mm/mm	TPF	Designation	Grade Coated AH725	BW	INSL	S	Chip breaking attachment	Designation	Grade Coated AH725	BW	INSL	S	Chip breaking attachment
(3.175)	8	1/16	0.75	CR-8R-3E	●	16	15	5.2	CR-8R / 10R-3E / 4E-CB	CR-8R-3I	●	16	15	5.2	CR-8R / 10R-3I / 4I-CB
(2.54)	10	1/16	0.75	CR-10R-3E	●	16	15.9	5.2	CR-8R / 10R-3E / 4E-CB	CR-10R-3I	●	16	15.9	5.2	CR-8R / 10R-3I / 4I-CB



Full-profile insert (chaser)

Pitch (Reference)	TPI	Taper		External insert			
		mm/mm	TPF	Designation	Grade Coated AH725	IC	S
(2.54)	10	1/16	0.75	CNGA-10R-3E	●	19.05	6.4
(3.175)	8	1/16	0.75	CNGA-8R-3E	●	19.05	6.4

Note: Toolholders need to be customized for these types of inserts.

Reference pages: API Round On edge : External toolholders → 55, Internal toolholders → 64
API Round Full-profile insert : External toolholders → 56, Internal toolholders → 65

● : Line up
Package quantity = 5 pcs.

Thread
form

60°

55°

M
(Metric)

UN
(Unified)

W
(Whitworth)

BSPT
(R, PT)

NPT

NPTF

TR
(Metric, 30°
Trapezoidal)

Round
(DIN405)

UNJ

MJ

ACME
(29° Trapezoidal)

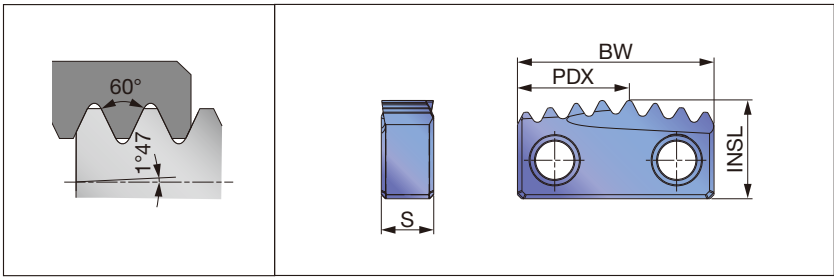
STUB
ACME
(29° Trapezoidal)

API
Round

API
Buttress

API
Rotary
Shoulder
Connection

API Round (for Energy)

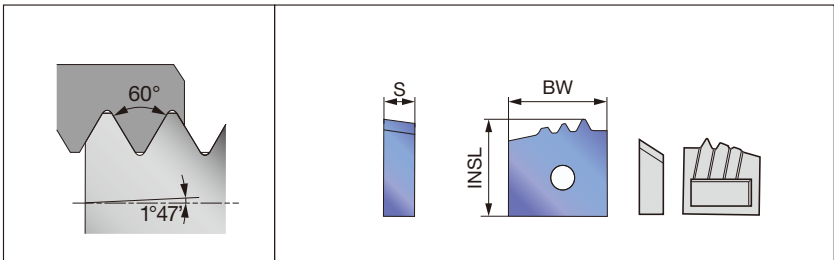


Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	Internal insert			
				Designation	Grade	BW	INSL
					Coated		
					T05TP		
22	(5.08)	5	R	CR-8R-4I-W24	●	24	12
						13.65	6.4

Note: Toolholders need to be customized for these types of inserts.

API Round (for Energy) For tool-rotating machines

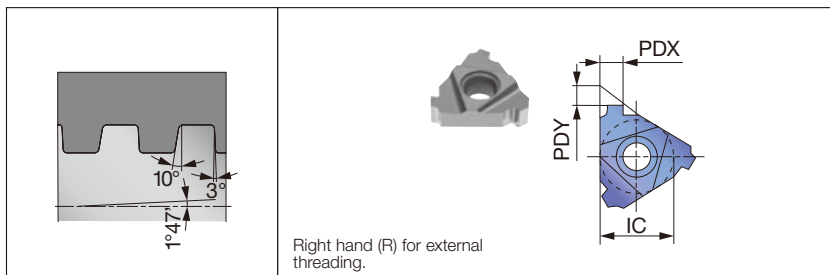


Full-profile insert (chaser)

Pitch (Reference)	TPI	Taper		External insert					
		mm/ mm	TPF	Designation	Grade	BW	INSL	S	Chip breaking attachment
					Coated				
					AH725				
(3.175)	8	1/16	0.75	CR-8R-3E#1	●	16	14.7	5.2	TD39318R-1-CBW/CAVITY
(3.175)	8	1/16	0.75	CR-8R-3E#2	●	16	14.9	5.2	TD39328R-2-CBW/CAVITY
(3.175)	8	1/16	0.75	CR-8R-3E#3	●	16	15	5.2	TD39338R-3-CBW/CAVITY

Note: Toolholders need to be customized for these types of inserts.

API Buttress (for Energy industry)

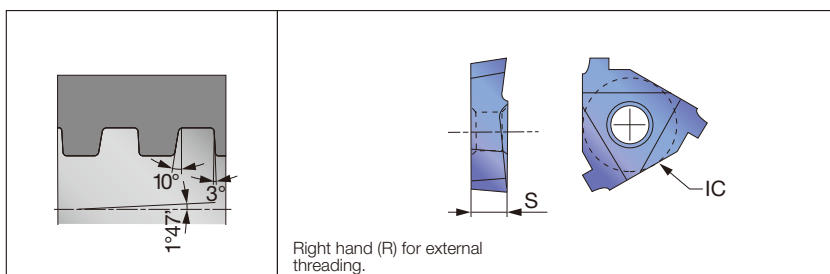


Applicable toolholder

Insert size	External	Internal
22	CER/L**22... SER**22-CHP	TSNR/L**22... SNR/L**22... TCNR/L**22... CNR/L**22...

Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	External insert					Internal insert				
				Designation	Grade	IC	PDX	PDY	Designation	Grade	IC	PDX	PDY
					Coated					Coated			
					AH725					AH725			
22	(5.08)	5	R	22ER5BAPI	●	12.7	3.72	2.2	22IR5BAPI	●	12.7	3.45	2.2

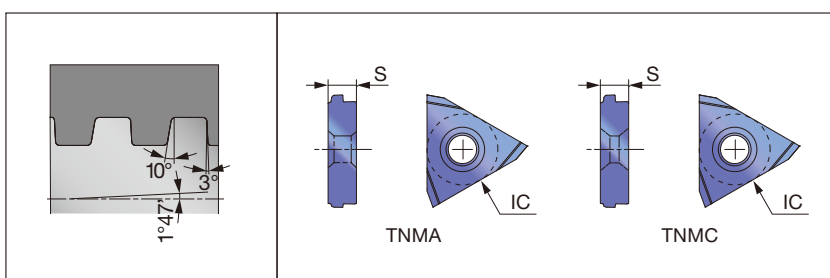


Applicable toolholder

External	Internal
MTVNR**M5	HS**-LNFR...

Full-profile insert (single side)

Pitch (Reference)	TPI	Taper		External insert				Internal insert			
		mm/mm	TPF	Designation	Grade	IC	S	Designation	Grade	IC	S
					Coated				Coated		
					AH725				AH725		
(5.08)	5	1/16	0.75	L535B75EXT-FC	●	15.875	4.8	L535B75INT-FC	●	15.875	4.8
(5.08)	5	1/12	1	L535B1EXT-FC	●	15.875	4.8	L535B1INT-FC	●	15.875	4.8



Applicable toolholder

External	Internal
MTVOR-**M.. STVOR-**M...	HS**-MTHOR...

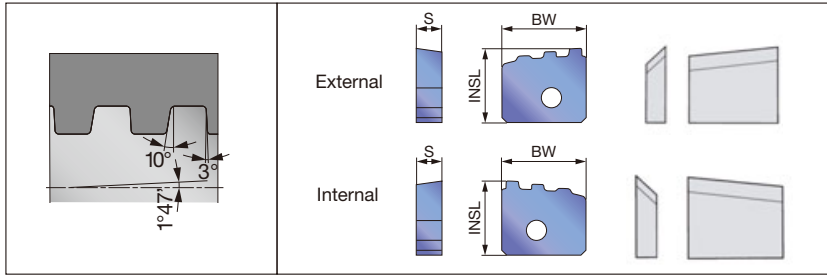
On edge

Pitch (Reference)	TPI	Taper		External insert				Internal insert			
		mm/mm	TPF	Designation	Grade	IC	S	Designation	Grade	IC	S
					Coated				Coated		
					AH725				AH725		
(5.08)	5	1/12	1	TNMA545B1EXT-FC	●	15.875	6.4	TNMA545B1INT-FC	●	15.875	6.4
(5.08)	5	1/16	0.75	TNMA545B75EXT-FC	●	15.875	6.4	TNMA545B75INT-FC	●	15.875	6.4
(5.08)	5	1/12	1	TNMC545B1EXT-FC	●	15.875	6.4	TNMC545B1INT-FC	●	15.875	6.4
(5.08)	5	1/16	0.75	TNMC545B75EXT-FC	●	15.875	6.4	TNMC545B75INT-FC	●	15.875	6.4

Reference pages: API Buttress Full-profile insert : External toolholders → [36, 38](#), Internal toolholders → [58 - 59](#)
 API Buttress Full-profile insert (single side) : External toolholders → [54](#), Internal toolholders → [63](#)
 Buttress On edge : External toolholders → [55](#), Internal toolholders → [64](#)

● : Line up
 Package quantity = 5 pcs.

API Buttress (for Energy industry)

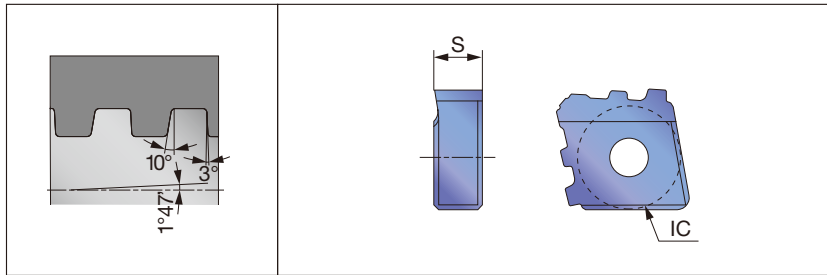


Applicable toolholder

External	Internal
CLVOR-**M...	SI-CLHOR...

Full-profile insert (chaser)

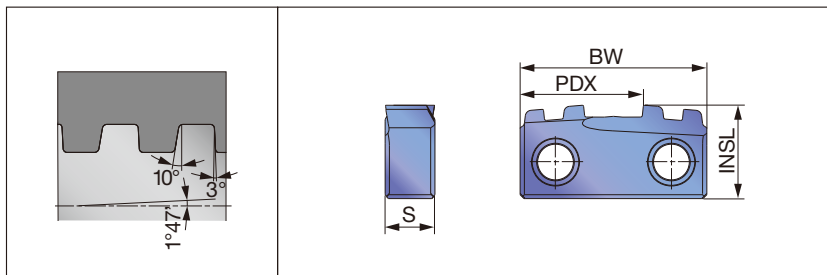
Pitch (Reference)	TPI	Taper		External insert							Internal insert						
				Designation	Grade	BW	INSL	S	Chip breaking attachment	Designation	Grade	BW	INSL	S	Chip breaking attachment		
		Coated	Coated														
		mm/mm	TPF		AH725						AH725						
(5.08)	5	1/16	0.75	CR-5B75-4E	●	20.4	15.9	5.1	CR-5B75 / 5B1-4E-CB	CR-5B75-3I	●	16	15.8	5.2	CR-8R / 10R-3I / 4I-CB		



Full-profile insert (chaser)

Pitch (Reference)	TPI	Taper		External insert			
				Designation	Grade	IC	S
		Coated					
		AH725					
(5.08)	5	1/16	0.75	CNGA-5B75-3E	●	19.05	6.4

Note: Toolholders need to be customized for these types of inserts.

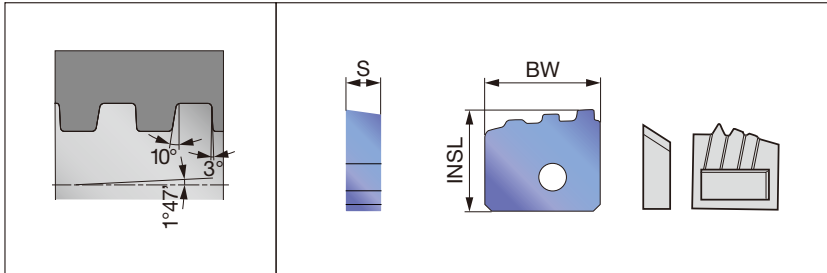


Full-profile insert

Insert size	Pitch (Reference)	TPI	Hand of cut	Internal insert					
				Designation	Grade	BW	INSL	PDX	S
					Coated				
					T05HP				
22	(5.08)	5	R	CR-5B75-2I-W24	●	24	12	15.85	6.4

Note: Toolholders need to be customized for these types of inserts.

API Buttress (for Energy industry) For tool-rotating machines

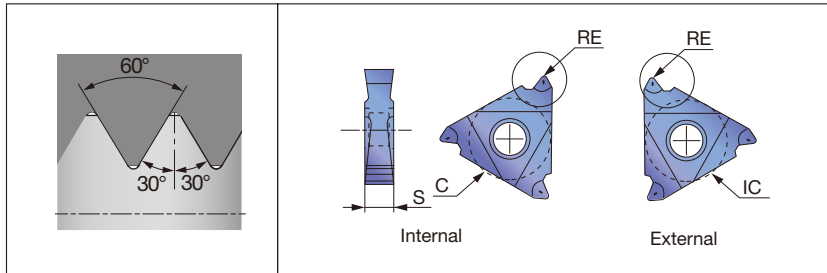


Full-profile insert (chaser)

Pitch (Reference)	TPI	Taper		External insert						
				Designation	Grade	BW	INSL	S	RE	Chip breaking attachment
		Coated								
		AH725								
(5.08)	5	1/16	0.75	CR-5B75-3E#1	●	17	14.6	5.2	TD46015B75-1-CBW/CAVITY	
(5.08)	5	1/16	0.75	CR-5B75-3E#2	●	17	14.8	5.2	TD46025B75-2-CBW/CAVITY	
(5.08)	5	1/16	0.75	CR-5B75-3E#3	●	17	15	5.2	TD46035B75-3-CBW/CAVITY	

Note: Toolholders need to be customized for these types of inserts.

API Rotary shoulder connection (for Energy industry)



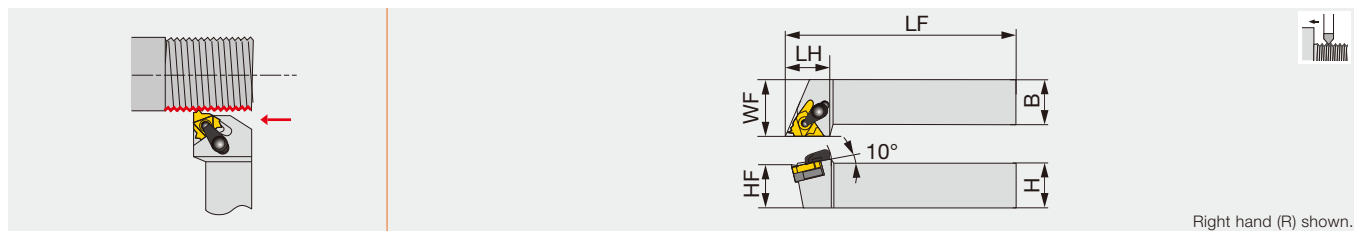
Applicable toolholder

External	Internal
MTVNR-3232M54	HS**-LNFR-54API

Full-profile insert (Double side)

Pitch (Reference)	TPI	Connection	Taper		Designation	Grade Coated AH725	IC	S	RE
			mm/mm	TPF					
(6.35)	4	V-0.038R	1/6	2	LDS54428FT-CB#1	●	15.875	6.4	0.97
(6.35)	4	V-0.038R	1/4	3	LDS54438FT-CB#2	●	15.875	6.4	0.97
(6.35)	4	V-0.050	1/6	2	LDS54425FT-CB#3	●	15.875	6.4	0.64
(6.35)	4	V-0.050	1/4	3	LDS54435FT-CB#4	●	15.875	6.4	0.64
(5.08)	5	V-0.040	1/4	3	LDS54530FT-CB#5	●	15.875	6.4	0.51

External threading toolholder, alternative clamping of screw-on or clamp-on only for DT type



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	Insert
CER/L1212H16DT	12	12	100	24	12	16	16ER/L...
CER/L1616H16DT	16	16	100	24	16	20	16ER/L...
CER/L2020K16DT	20	20	125	24	20	25	16ER/L...
CER/L2525M16DT	25	25	150	28	25	32	16ER/L...
CER/L2525M22DT	25	25	150	31.3	25	32	22ER/L...
CER3232P16T	32	32	170	32	32	40	16ER...
CER3232P22T	32	32	170	32	32	40	22ER...
CER2525M27T	25	25	150	34	25	32	27ER...
CER3232P27T	32	32	170	34	32	40	27ER...

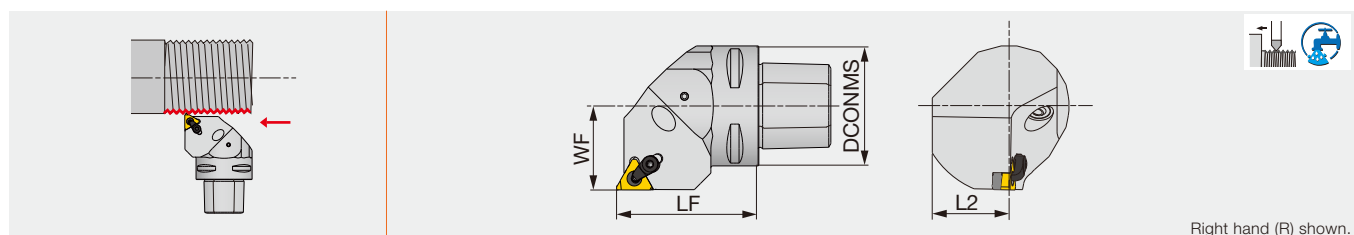
Note: A clamp set consists of a clamp and a clamping screw. A shim set consists of a shim and a shim screw to secure the shim to the shank.
Standard shims can be used on both right- and left-hand toolholders. Please use either of the sides depending on the tool hand.
When using DT type, please remove either the clamp set or the insert clamping screw.

Designation	Clamp set	Clamping screw	Shim screw	Shim	Shim set	Wrench 1	Wrench 2	Wrench 3
CER/L**16DT	CSP16	CSTB-3.5ST	DTS5-3.5	A16-1DT	-	P-3.5	T-15F	-
CER/L2525M22DT	CSP22	CSTB-4ST	DTS6-4	GX22-1DT	-	P-4	T-15F	T-20F
CER3232P16T	CSP16	-	-	-	A16-1	-	T-15F	-
CER3232P22T	CSP22	-	-	-	NXE22-1	-	T-20F	-
CER**27T	CSP27	-	-	-	NXE27-1	P-4	-	-

TUNGCAP

C-CER/L

External threading toolholder, alternative clamping of screw-on or clamp-on



Right hand (R) shown.

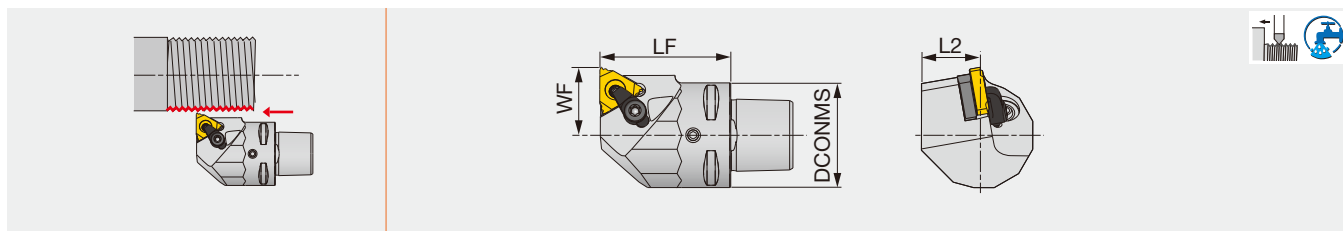
Designation	DCONMS	LF	L2	WF	Insert
C3CER/L22040-16ERN ⁽²⁾	32	40	20	22	16ER/L...
C4CER/L27050-16ERN ⁽²⁾	40	50	25	27	16ER/L...
C5CER/L35060-16ER ⁽¹⁾	50	60	32	35	16ER/L...
C5CER/L35060-16ERN ⁽²⁾	50	60	32	35	16ER/L...
C6CER/L45065-16ER ⁽¹⁾	63	65	41	45	16ER/L...
C6CER/L45065-16ERN ⁽²⁾	63	65	41	45	16ER/L...

(1) Applicable for 3 MPa coolant (2) Applicable for 7 MPa coolant

Designation	Clamp set	Clamping screw	Coolant parts	Shim screw	Shim	Wrench 1	Wrench 2
C3CE*22040-16ERN	CSP16	CSTB-3.5ST	SATZ-M8X1-M3	DTS5-3.5	A16-1DT	P-3.5	T-15F
C4CE*27050-16ERN	CSP16	CSTB-3.5ST	SATZ-M8X1-M3	DTS5-3.5	A16-1DT	P-3.5	T-15F
C5CE*35060-16ER	CSP16	CSTB-3.5ST	EZ104	DTS5-3.5	A16-1DT	P-3.5	T-15F
C5CE*35060-16ERN	CSP16	CSTB-3.5ST	SATZ-M10X1-M5	DTS5-3.5	A16-1DT	P-3.5	T-15F
C6CE*45065-16ER	CSP16	CSTB-3.5ST	EZ104	DTS5-3.5	A16-1DT	P-3.5	T-15F
C6CE*45065-16ERN	CSP16	CSTB-3.5ST	SATZ-M10X1-M5	DTS5-3.5	A16-1DT	P-3.5	T-15F

Reference pages: Inserts → 10 - 11, 15, 18 - 30, 33

External threading toolholder, alternative clamping of screw-on or clamp-on



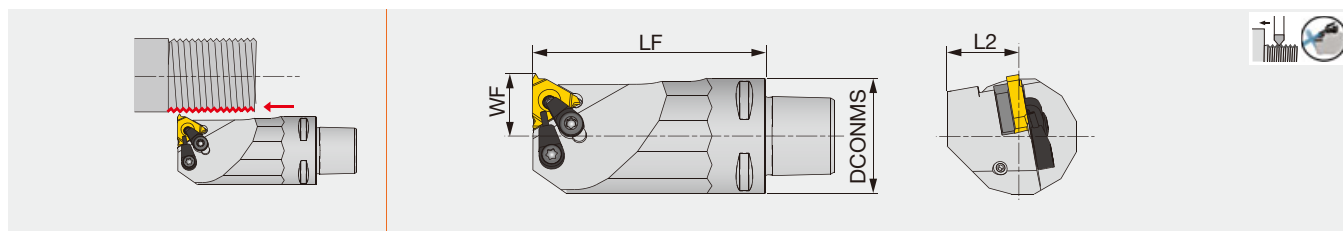
Designation	DCONMS	LF	L2	WF	Insert
C3CEL22040-16ERN-B	32	40	18	22	16ER...

Applicable for 7 MPa coolant
Cannot be used for boring

SPARE PARTS

Designation	Shim	Shim screw	Clamping screw	Clamping screw	Wrench 1	Wrench 2	Coolant parts
C3CEL22040-16ERN-B	A16-1DT	DTS5-3.5	CSTB-3.5ST	CSP16	T-15F	P-3.5	SATZ-M8X1-M3

External threading toolholder, alternative clamping of screw-on or clamp-on, with high pressure coolant capability



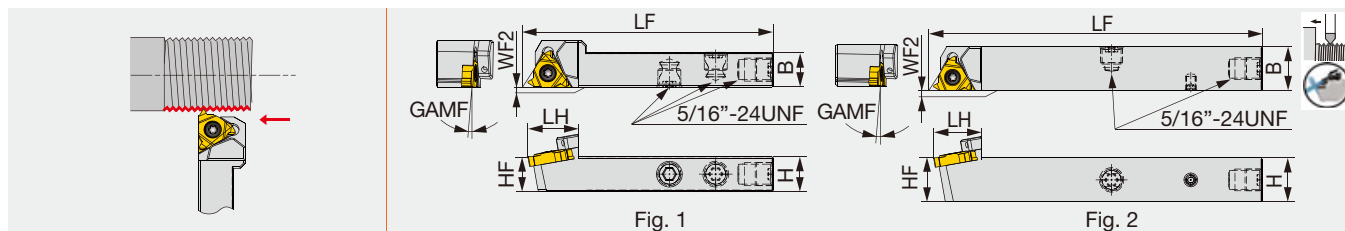
Designation	DCONMS	LF	L2	WF	Insert
C3CEL18065-16ERB-CHP	32	65	20	18	16ER...

Applicable for 14 MPa coolant
Cannot be used for boring

SPARE PARTS

Designation	Shim	Shim screw	Clamping screw	Clamping screw	Wrench 1	Wrench 2	Coolant unit
C3CEL18065-16ERB-CHP	A16-1DT	DTS5-3.5	CSTB-3.5ST	CSP16	T-15F	P-3.5	S-CU-CHP

External threading toolholder with DirectTungJet connection, with high pressure coolant capability

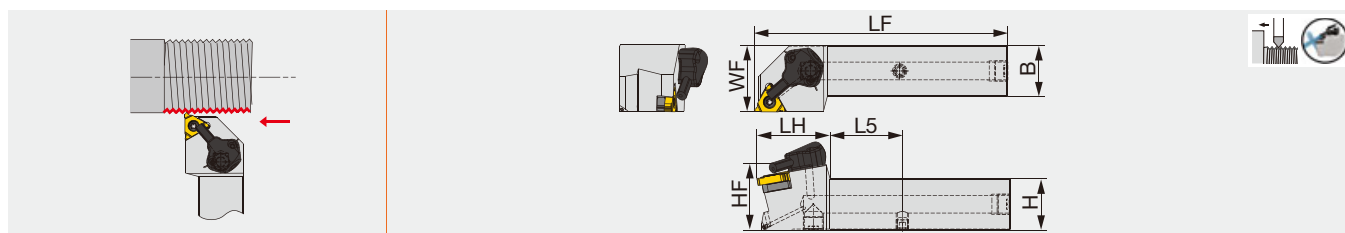


Designation	H	B	LF	LH	HF	WF	GAMF	Fig.	Insert
JSE2R1212F16-CHP	12	12	85	19	12	0	1°	1	16ER...
JSE2R1212X16-CHP	12	12	120	19	12	0	1°	2	16ER...
JSE2R1616X16-CHP	16	16	120	19	16	0	1°	2	16ER...

SPARE PARTS

Designation	Clamping screw	Wrench
JSE2R**16-CHP	CSTB-3.5	T-15F

Screw-on external threading toolholders-High-pressure coolant capability with tube and direct connection



Designation	H	B	LF	LH	HF	WF	L5	Insert
SER2020X16-CHP-MC	20	20	107	36	20	25	27.9	16ER...
SER2525X16-CHP-MC	25	25	122	36	25	32	33.75	16ER...
SER2525X22-CHP-MC	25	25	122	36	25	32	33.75	22ER...

SPARE PARTS

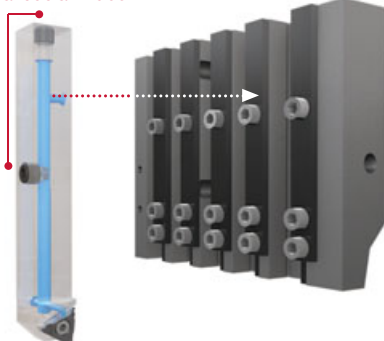
Designation	Clamping screw	Wrench	Shim screw	Shim	Coolant unit	Coolant plug	Wrench
SER**X16-CHP-MC	CSTB-3.5ST	T-15F	DTS5-3.5	A16-1DT	CU-V-CHP	PLUGG1/8-6.5TL360	P-3.5
SER**X22-CHP-MC	CSTB-4ST	T-15F	DTS6-4	GX22-1DT	CU-CW-CHP	PLUGG1/8-6.5TL360	P-4

No need for coolant tube setup.

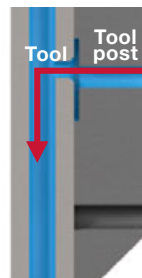
Eliminates chip entanglement on tubes and streamlines tool replacement.

Coolant is supplied from the tool post directly to the tools

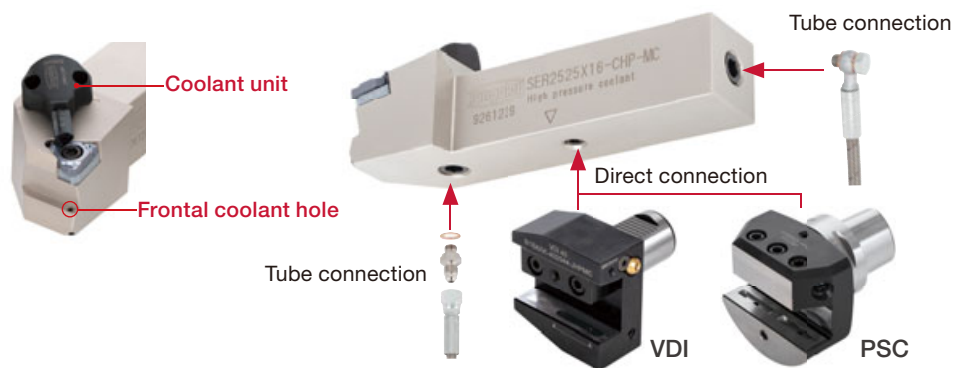
Internal thread
Optional connection with
external coolant tube



Detailed view of the coolant
flow after connection



Optimized two streams of high-pressure coolant jets to maximize productivity.
Applicable direct connection with tube free.



Improvement of chip control

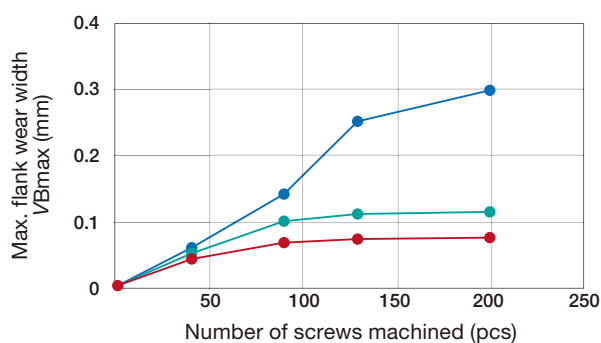
P SCM415

	1 pass	2 pass	3 pass	4 pass	5 pass	6 pass
Internal coolant 7 MPa						
Internal coolant 1 MPa						
External coolant						

Tool holder : SER2525X16-CHP-MC
Insert : 16ER15ISO AH725
Cutting speed : $V_c = 150$ m/min
Pitch : $p = 1.5$ mm
Infeed method : Radial infeed (6 pass)

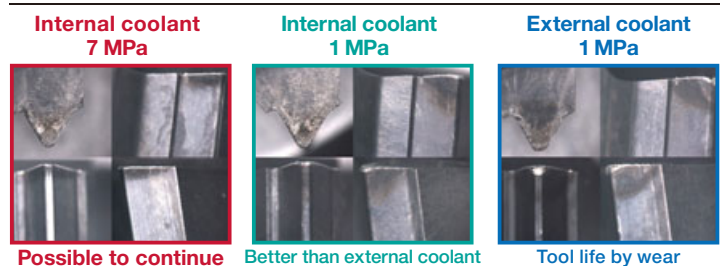
Improvement of tool life

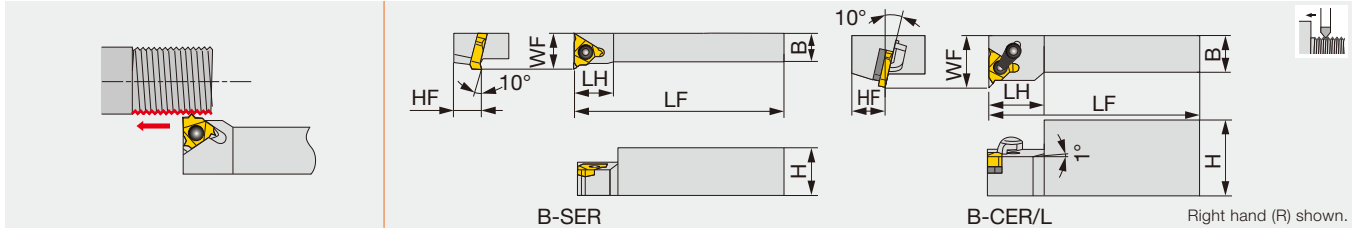
M SUS304 / X5CrNi18-9



Tool holder : SER2525X16-CHP-MC
Insert : 16ER15ISO AH725
Cutting speed : $V_c = 120$ m/min
Pitch : $p = 1.5$ mm
Infeed method : Radial infeed (6 pass)

After 200 thread

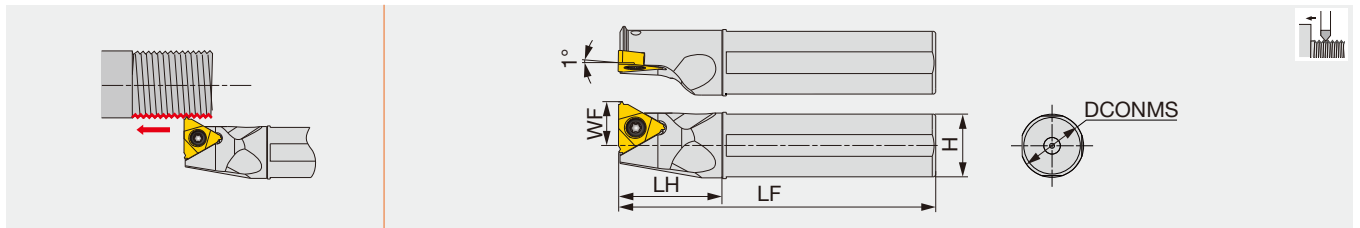




Designation	H	B	LF	LH	HF	WF	Insert
B-SER10H16	20	10	100	15	10	16	16ER...
B-SER12K16	24	12	125	18	12	18	16ER...
B-CER/L16M16	32	16	150	24	16	22	16ER/L...

SPARE PARTS

Designation	Clamp set	Shim set	Clamping screw	Wrench
B-SER**16	-	-	CSTB-3.5	T-15F
B-CER/L16M16	CSP16	A16-1	-	T-15F



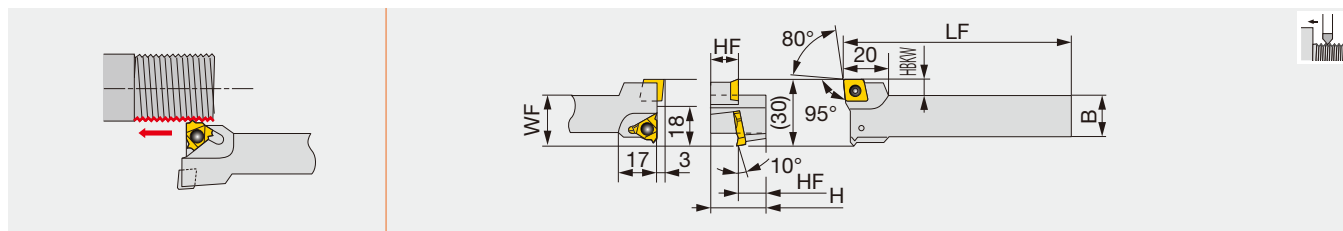
Designation	DCONMS	H	LF	LH	WF	Insert
JS16F-SEL16	16	15	85	25	11	16ER...
JS19G-SEL16	19.05	18	90	30	12.5	16ER...
JS19X-SEL16	19.05	18	120	30	12.5	16ER...
JS20G-SEL16	20	19	90	30	13	16ER...
JS20X-SEL16	20	19	120	30	13	16ER...
JS25HSEL16	25	24	100	30	15.5	16ER...
JS254X-SEL16	25.4	24	120	30	15.7	16ER...

Note: Use the right-hand insert (16ER...) for a left-hand holder (JS***-SEL...).

SPARE PARTS

Designation	Clamping screw	Wrench
JS***-SEL16	CSTB-3.5	T-15F

External threading toolholder for multi-functional Swiss lathes

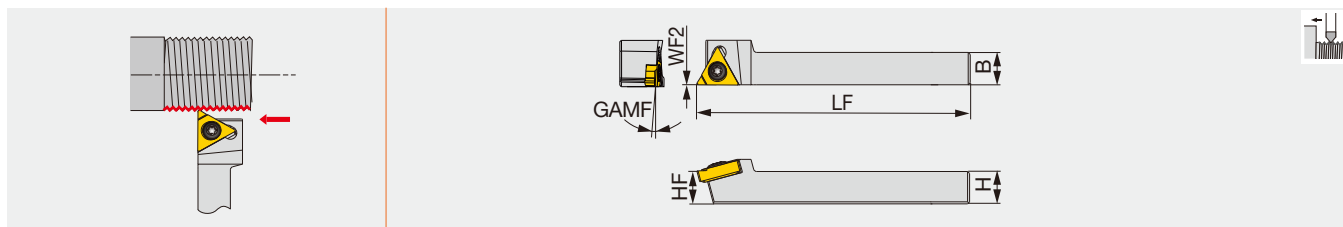


Designation	H	B	LF	HF	WF	HBKW	Insert
BC-SER12K16	24	16	125	12	23	7	16ER..., CC*T09T3...

SPARE PARTS

Designation	Clamping screw	Wrench
BC-SER12K16	CSTB-3.5	T-15F

Screw-on external threading toolholders

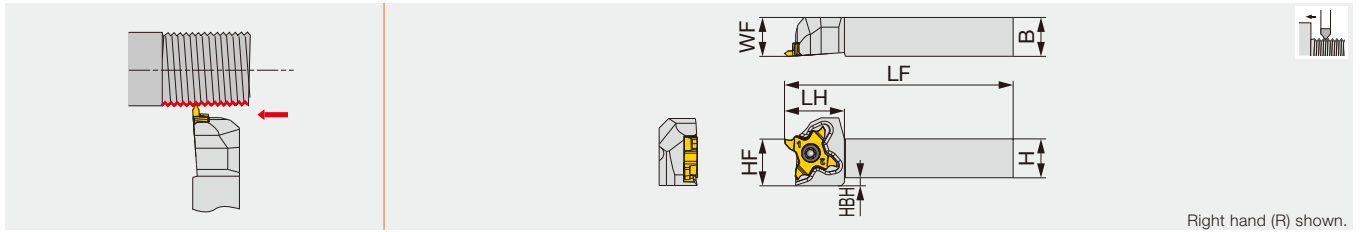


Designation	H	B	LF	HF	WF	GAMF	Insert
SER0808H11	8	8	100	8	0	1.5°	11ER...
SER1010H11	10	10	100	10	0	1.5°	11ER...

SPARE PARTS

Designation	Clamping screw	Wrench
SER**H11	SR M2.6-L6.7-S11	T-8/5

External grooving and threading toolholder



Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	HBH	Insert	Torque*
STCR/L1010X18	10	10	120	18.5	10	10	4.5	TCT18...	1.2
STCR/L1212F18	12	12	85	18.5	12	12	2.5	TCT18...	1.2
STCR/L1212X18	12	12	120	18.5	12	12	2.5	TCT18...	1.2
STCR/L1616X18	16	16	120	18.5	16	16	-	TCT18...	1.2
STCR/L2020H18	20	20	100	18.5	20	20	-	TCT18...	1.2
STCR/L2020X18	20	20	120	23	20	25	-	TCT18...	1.2
STCR/L2525Z18	25	25	135	23	25	30	-	TCT18...	1.2

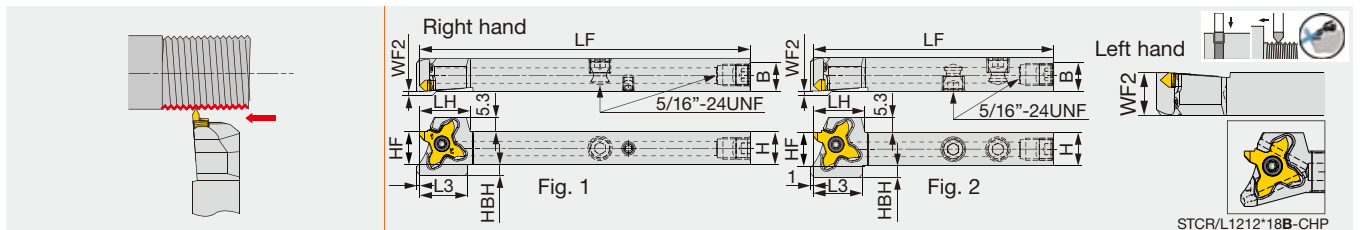
Torque* : Recommended clamping torque (N·m)

Note: Use the right-hand insert (TC*18R...) for a right-hand holder (STCR...); the left-hand insert (TC*18L...) for a left-hand holder (STCL...).

SPARE PARTS

Designation	Clamping screw	Wrench
STCR...	CSTC-4L100DL	T-1008/5
STCL...	CSTC-4L100DR	T-1008/5

External grooving and threading toolholder, with high pressure coolant capability



STCR/L1212*18B-CHP

Designation	H	B	LF	LH	HL	HF	WF**	HBH	Fig.	Insert	Torque*
STCR/L1012H18-CHP ⁽¹⁾	10	12	100	17.1	10	17.1	0/12	4	1	TCT18...	1.2
STCR/L1212F18B-CHP	12	12	120	18.5	17.5	12	0/12	4	2	TCT18...	1.2
STCR/L1212X18B-CHP ⁽¹⁾	12	12	120	18.5	17.5	12	0/12	4	1	TCT18...	1.2
STCR/L1616X18-CHP ⁽¹⁾	16	16	120	18.5	-	16	0/16	-	1	TCT18...	1.2

Torque* : Recommended clamping torque (N·m)

WF** : The first value before "/" indicates the WF for the right-hand holder and the second value after "/" for the left-hand holder.

(1) Compatible to the direct internal coolant supply system without the use of external coolant hose.

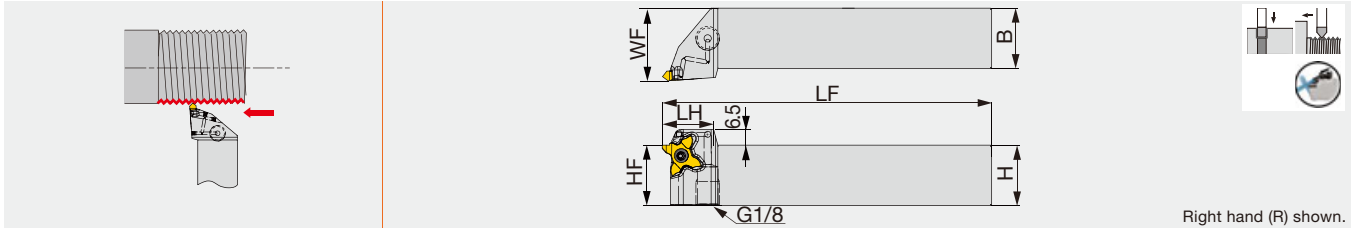
Note: This toolholder can be used with threading and grooving inserts.

Use the right-hand insert (TC*18R...) for a right-hand holder (STCR...); the left-hand insert (TC*18L...) for a left-hand holder (STCL...).

SPARE PARTS

Designation	Clamping screw	Wrench
STCL**18-CHP	CSTC-4L100DR	T-1008/5
STCR**18-CHP	CSTC-4L100DL	T-1008/5

External threading with high pressure coolant capability



Designation	H	B	LF	LH	HBL	HF	WF	HBH	Insert	Torque*
STCR/L2020X18-CHP	20	20	120	23	-	20	25	-	TC*18...	1.2
STCR/L2525Z18-CHP	25	25	135	23	-	25	30	-	TC*18...	1.2

Torque* : Recommended clamping torque (N·m)

Note: Use the right-hand insert (TC*18R...) for a right-hand toolholders (STCR...); the left-hand insert (TC*18L...) for a left-hand holder (STCL...).

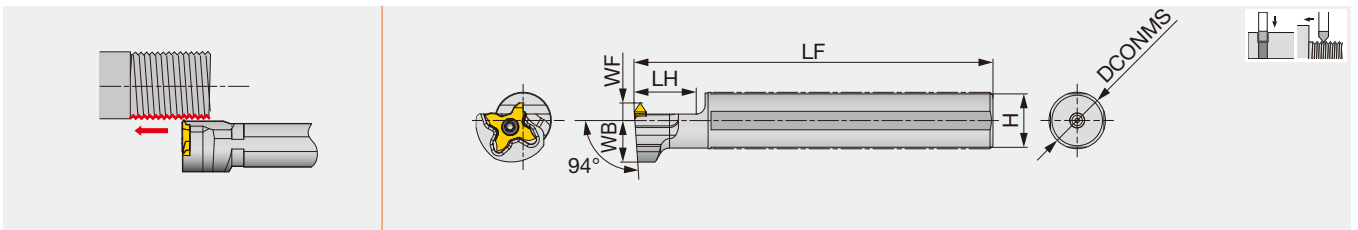
SPARE PARTS

Designation	Clamping screw	Wrench
STCL**18-CHP	CSTC-4L100DR	T-1008/5
STCR**18-CHP	CSTC-4L100DL	T-1008/5

TETRAMCUT

JS-STCL18

External grooving and threading toolholder with round shank



Designation	DCONMS	LF	LH	H	WB	WF	Insert	Torque*
JS14H-STCL18	14	100	20	13	14	6	TCT18R...	1.2
JS159F-STCL18	15.875	85	20	15	14	6	TCT18R...	1.2
JS16F-STCL18	16	85	20	15	14	6	TCT18R...	1.2
JS19G-STCL18	19.05	90	20	18	14	6	TCT18R...	1.2
JS19X-STCL18	19.05	120	20	18	14	6	TCT18R...	1.2
JS20G-STCL18	20	90	20	19	14	6	TCT18R...	1.2
JS20X-STCL18	20	120	20	19	14	6	TCT18R...	1.2
JS22X-STCL18	22	120	20	21	12.25	10	TCT18R...	1.2
JS25H-STCL18	25	100	20	24	12.25	10	TCT18R...	1.2
JS254X-STCL18	25.4	120	20	24	12.25	10	TCT18R...	1.2

Torque* : Recommended clamping torque (N·m)

Note: Use the right-hand insert (TC*18R...) for a left-hand holder (STCL...).

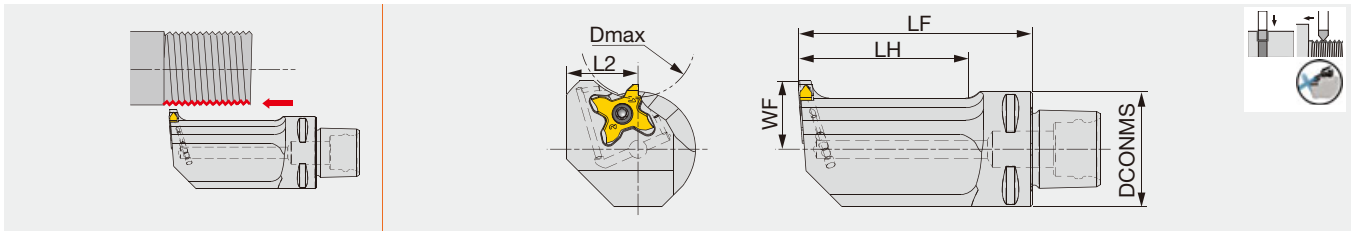
SPARE PARTS

Designation	Clamping screw	Wrench
JS**STCL18	CSTC-4L100DL	T-1008/5

TETRAMCUTTM

C-STCFL-18-CHP

External grooving and threading toolholder, with high pressure coolant capability



Designation	DCONMS	LF	LH	L2	WF	Dmax	Insert	Torque*
C3STCFL18040-18-CHP	32	40	21.5	20	18	32	TC*18R...	1.2
C3STCFL18065-18-CHP	32	65	46.5	20	18	32	TC*18R...	1.2

Torque* : Recommended clamping torque (N-m)

Applicable for 14 MPa coolant

Note: Use the right-hand insert (TC*18R...) for a left-hand holder (STCFL...).

SPARE PARTS

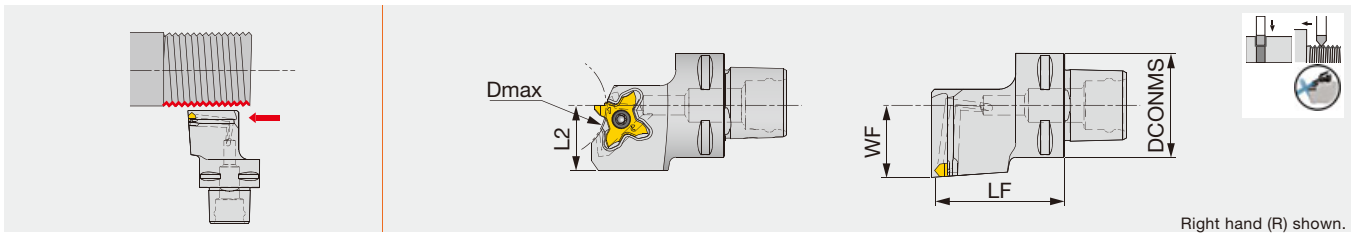
Designation	Clamping screw	Wrench
C3STCFL*-18-CHP	CSTC-4L100DL	T-1008/5

TETRAMCUTTM

C-STCR/L-18-CHP

TUNG T^{URN}JET

External grooving and threading toolholder, with high pressure coolant capability



Designation	DCONMS	LF	L2	WF	Dmax	Insert	Torque*
C3STCR/L22040-18-CHP	32	40	20	22	32	TC*18...	1.2
C4STCR/L27050-18-CHP	40	50	25	27	75 (1)	TC*18...	1.2

Torque* : Recommended clamping torque (N-m)

Applicable for 14 MPa coolant

(1) The value for 3.5 mm groove depth, Dmax varies according to the grooving depth required. For further information, see Tungaloy Report #416 TetraMini-Cut/TetraForce-Cut.

Note: Use the right-hand insert (TC*18R...) for a right-hand holder (STCR...); the left-hand insert (TC*18L...) for a left-hand holder (STCL...).

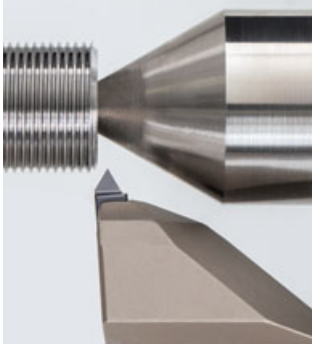
SPARE PARTS

Designation	Clamping screw	Wrench
C*STCL*-18-CHP	CSTC-4L100DR	T-1008/5
C*STCR*-18-CHP	CSTC-4L100DL	T-1008/5

Reference pages: Inserts → 12

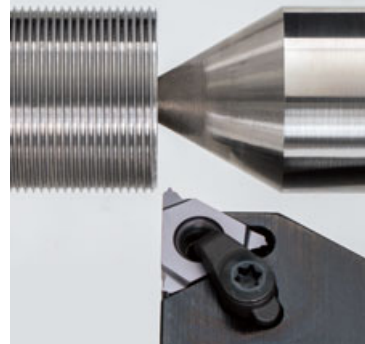
- No tool interference with the lathe center when machining small parts

TETRAMCUT
M16x1



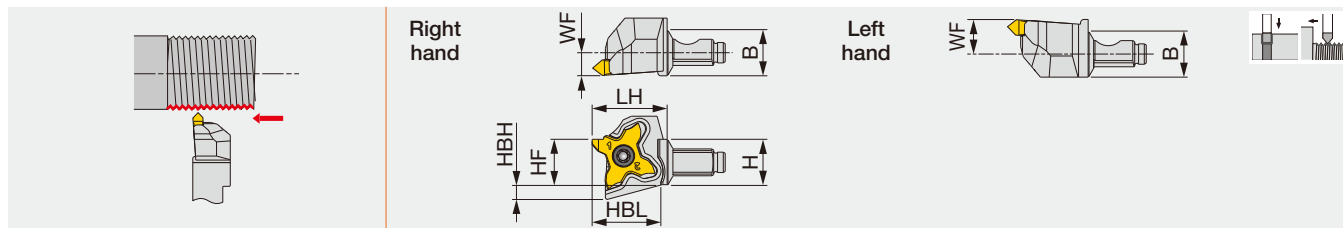
Insert: TCT18R-60N-020

Conventional
M24x1



Insert: 16ER10ISO

External grooving and threading head



Designation	H	B	LH	HF	HBH	HBL	WF	Insert	Torque*
QC12-STCR18	12	12	19.5	12	3.9	17.9	6	TC*18R...	1.2
QC12-STCL18	12	12	21	12	3.9	18.3	9	TC*18L...	1.2

Torque* : Recommended clamping torque (N·m)

Note: Use the right-hand insert (TC*18R...) for a right-hand holder (QC12-STCR...); the left-hand insert (TC*18L...) for a left-hand holder (QC12-STCL...).

SPARE PARTS

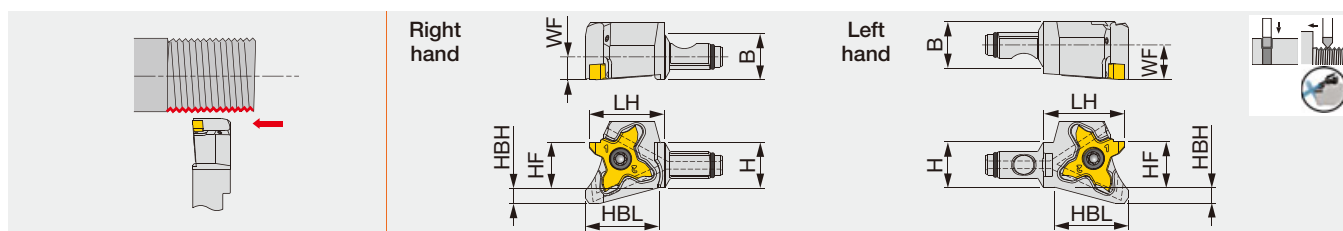
Designation	Clamping screw	Wrench
QC12-STCR18	CSTC-4L100DL	T-1008/5
QC12-STCL18	CSTC-4L100DR	T-1008/5

MODUM^{INI}TURN

QC12-STCR/L-CHP

TETRAM^{CUT}

External grooving and threading head, with high pressure coolant capability



Designation	H	B	LH	HF	HBH	HBL	WF	Insert	Torque*
QC12-STCR18-CHP	12	12	19.5	12	4.2	19.3	6	TC*18R...	1.2
QC12-STCL18-CHP	12	12	21	12	4.2	19.3	9	TC*18L...	1.2

Torque* : Recommended clamping torque (N·m)

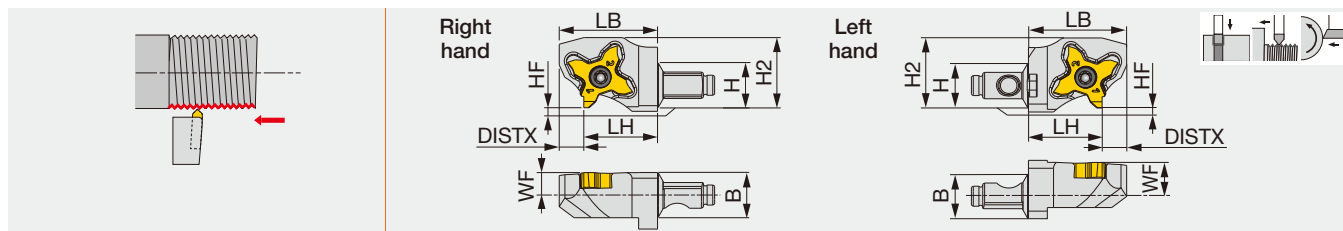
Through-coolant head

Note: Use the right-hand insert (TC*18R...) for a right-hand holder (QC12-STCR...); the left-hand insert (TC*18L...) for a left-hand holder (QC12-STCL...).

SPARE PARTS

Designation	Clamping screw	Wrench	O-ring
QC12-STCR18-CHP	CSTC-4L100DL	T-1008/5	ORSS-0454.5X1.0NBR70
QC12-STCL18-CHP	CSTC-4L100DR	T-1008/5	ORSS-0454.5X1.0NBR70

Y-axis turning modular head for external grooving and threading



Designation	H	B	LH	HF	WF**	LB	H2	DISTX	Insert	Torque*
QC12-STCR/L18-Y	12	12	19.5	0	6/9	26	18.6	6.5	TC*18...	1.2

Torque* : Recommended clamping torque (N-m)

WF** : The first value before "/" indicates the WF for the right-hand holder and the second value after "/" for the left-hand holder.

Note: Use the right-hand insert (TC*18R...) for a right-hand holder (QC12-STCR...); the left-hand insert (TC*18L...) for a left-hand holder (QC12-STCL...).

SPARE PARTS

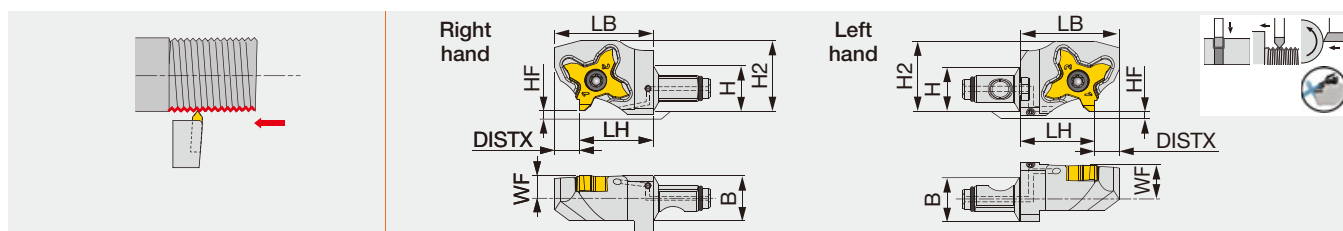


Designation	Clamping screw	Wrench
QC12-STCR...	CSTC-4L100DL	T-1008/5
QC12-STCL...	CSTC-4L100DR	T-1008/5

MODUM^{INI}TURN

QC12-STCR/L-Y-CHP

Y-axis turning modular head for external grooving and threading, with high pressure coolant capability



Designation	H	B	LH	HF	WF**	LB	H2	DISTX	Insert	Torque*
QC12-STCR/L18-Y-CHP	12	12	19.5	0	6/9	26	18.6	6.5	TC*18...	1.2

Torque* : Recommended clamping torque (N-m)

WF** : The first value before "/" indicates the WF for the right-hand holder and the second value after "/" for the left-hand holder.

Through-coolant head

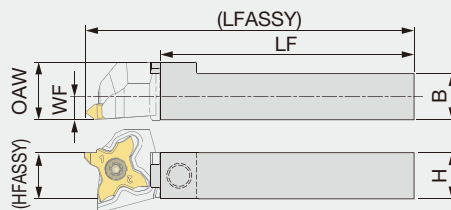
Note: Use the right-hand insert (TC*18R...) for a right-hand holder (QC12-STCR...); the left-hand insert (TC*18L...) for a left-hand holder (QC12-STCL...).

SPARE PARTS



Designation	Clamping screw	Wrench	O-ring
QC12-STCR...	CSTC-4L100DL	T-1008/5	ORSS-0454.5X1.0NBR70
QC12-STCL...	CSTC-4L100DR	T-1008/5	ORSS-0454.5X1.0NBR70

Shank for modular heads



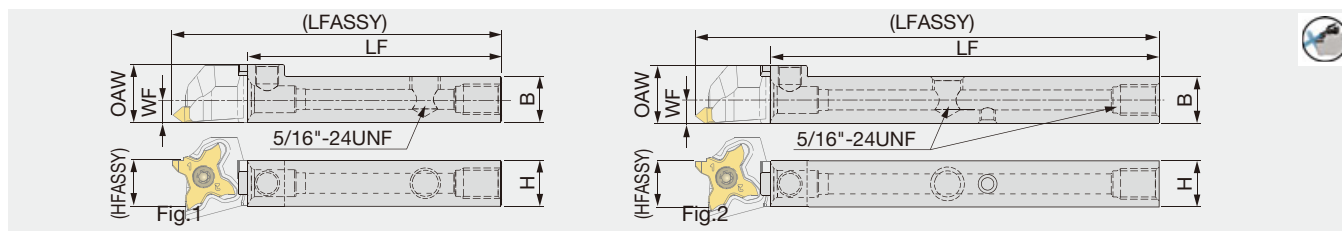
Designation	H	B	LF	OAW	Torque*
QC-1212F	12	12	65	15	3
QC-1212X	12	12	100	15	3

Torque* : Recommended clamping torque (N-m)

SPARE PARTS

Designation	Clamping screw	Wrench
QC-1212*	SRM6X0.5-26977	P-3

Shank for modular heads, with high pressure coolant capability



Designation	H	B	LF	OAW	Torque*	Fig.
QC-1212F-CHP	12	12	65	15	3	1
QC-1212X-CHP (1)	12	12	100	15	3	2

Torque* : Recommended clamping torque (N-m)

Through-coolant shank

(1) Compatible to the direct internal coolant supply system without the use of external coolant hose.

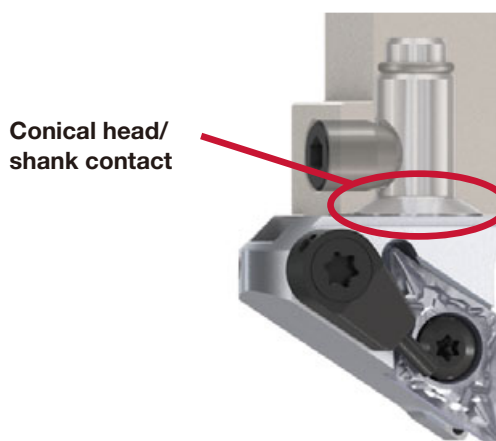
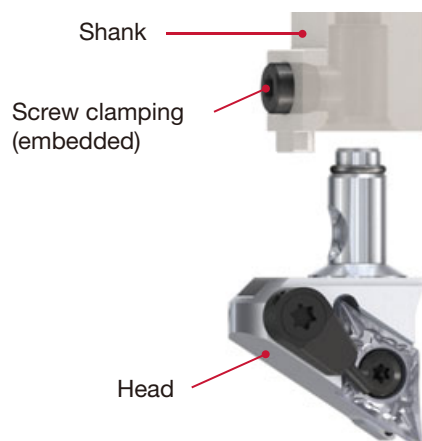
SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
QC-1212F-CHP	SRM6X0.5-26977	P-3	SR5/16UNFTL360	P-4	-	-
QC-1212X-CHP	SRM6X0.5-26977	P-3	SR5/16UNFTL360	P-4	SSH4-6-TB	P-2

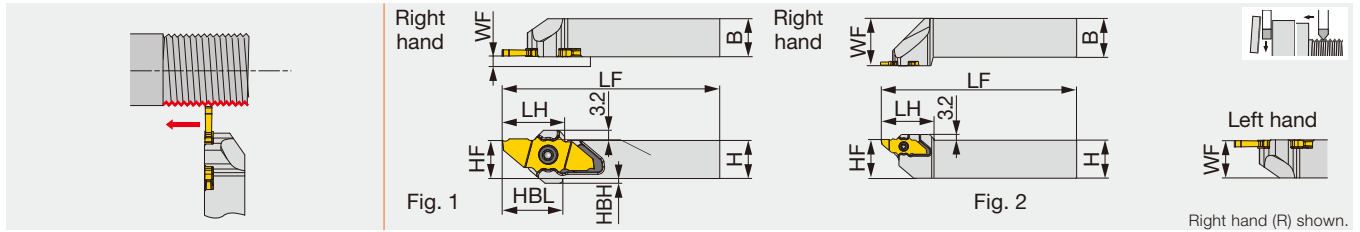
Unique coupling design

Simply loosen the clamping screw for easy tool exchanges.

Unique coupling design allows extremely high repeatability.



Threading and parting toolholder, for Swiss lathes



Designation	H	B	LF	LH	HF	WF ⁽¹⁾	HBL	HBH	Insert	Torque*	Fig.
JSXXR/L1010X09	10	10	118	17.65	10	0.2/9.8	17	3	JX**12...	1.2	1
JSXXR/L1212F09	12	12	83	17.65	12	0.2/11.8	17	1.5	JX**12...	1.2	1
JSXXR/L1212X09	12	12	118	17.65	12	0.2/11.8	17	1.5	JX**12...	1.2	1
JSXXR/L1616X09	16	16	118	17.65	16	0.2/15.8	-	-	JX**12...	1.2	1
JSXXR/L2020H09	20	20	98	20.5	20	0.2/19.8	-	-	JX**12...	1.2	1
JSXXR/L2525Z09	25	25	133	32	25	30	-	-	JX**12...	1.2	2

Torque* : Recommended clamping torque (N·m)

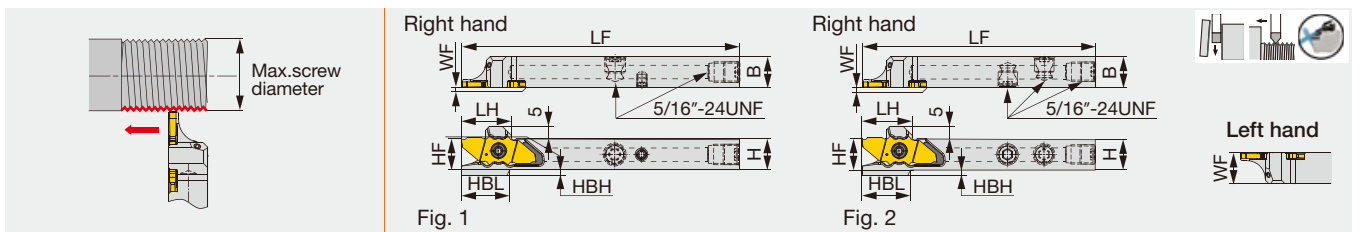
(1) The first value before "/" indicates the WF for the right-hand holder and the second value after "/" for the left-hand holder.

Note: Use the right-hand insert (JX****R...) for a right-hand holder (JSXXR...); the left-hand insert (JX****L...) for a left-hand holder (JSXXL...).

SPARE PARTS

Designation	Clamping screw	Wrench
JSXXR...	CSTC-4L100DL	T-1008/5
JSXXL...	CSTC-4L100DR	T-1008/5

Parting and threading toolholder, with high pressure coolant capability



Designation	H	B	LF	LH	HF	WF ⁽¹⁾	HBL	HBH	Insert	Torque*	Fig.
JSXXR/L1012H09-CHP ⁽²⁾	10	12	100	17.2	10	0.2/11.8	16.7	3	JX**12...	1.2	1
JSXXR/L1212F09-CHP	12	12	83	17.4	12	0.2/11.8	16.8	2	JX**12...	1.2	2
JSXXR/L1212X09-CHP ⁽²⁾	12	12	118	17.4	12	0.2/11.8	16.8	2	JX**12...	1.2	1
JSXXR/L1616X09-CHP ^{(2),(3)}	16	16	118	17.4	16	0.2	16.7	2.5	JX**12...	1.2	1
JSXXR/L1616X09B-CHP ⁽²⁾	16	16	118	17.4	16	0.2/15.8	16.7	-	JX**12...	1.2	1

Torque* : Recommended clamping torque (N·m)

(1) The first value before "/" indicates the WF for the right-hand holder and the second value after "/" for the left-hand holder.

(2) Compatible to the direct internal coolant supply system without the use of external coolant hose.

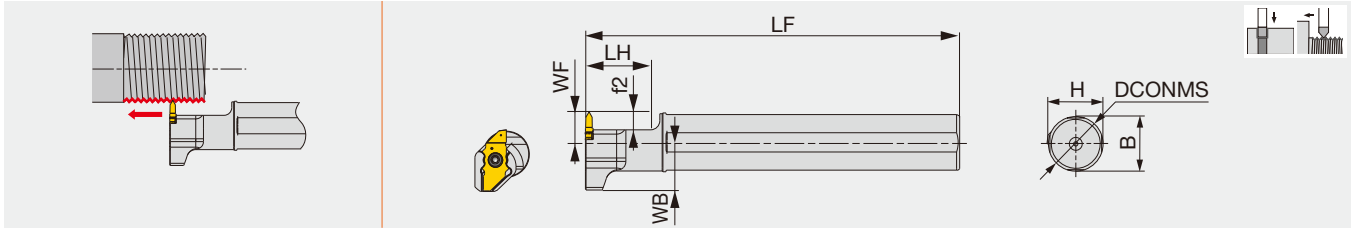
(3) To be replaced with the new design

Note: Use the right-hand insert (JX****R...) for a right-hand holder (JSXXR...); the left-hand insert (JX****L...) for a left-hand holder (JSXXL...).

SPARE PARTS

Designation	Clamping screw	Wrench 1	Coolant plug	Wrench 2	DirectJet plug	Wrench 3
JSXXR**F...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4	-	-
JSXXL**F...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4	-	-
JSXXR**H/X...	CSTC-4L100DL	T-1008/5	SR5/16UNFTL360	P-4	SSH4-6-TB	P-2
JSXXL**H/X...	CSTC-4L100DR	T-1008/5	SR5/16UNFTL360	P-4	SSH4-6-TB	P-2

External threading toolholder, for 2 corner inserts



Designation	DCONMS	H	B	LF	LH	WB	WF	f2	Insert	Torque*
JS19G-SXXL09	19.05	18	18	90	21	15.43	8	4	JX**12...	1.2
JS19X-SXXL09	19.05	18	18	120	21	15.43	8	4	JX**12...	1.2
JS20G-SXXL09	20	19	19	90	21	15.4	8	4	JX**12...	1.2
JS20X-SXXL09	20	19	19	120	21	15.4	8	4	JX**12...	1.2
JS22X-SXXL09	22	21	21	120	21	15.4	8	4	JX**12...	1.2
JS25H-SXXL09	25	24	24	100	21	15.4	8	4	JX**12...	1.2
JS254X-SXXL09	25.4	24	24	120	21	15.4	8	4	JX**12...	1.2

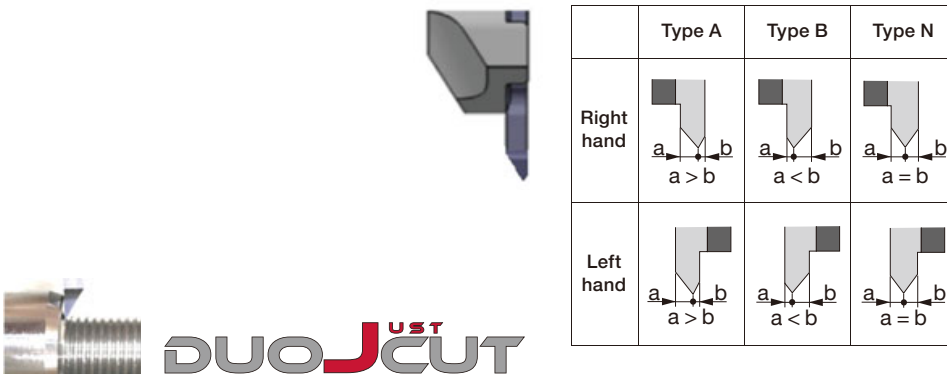
Torque* : Recommended clamping torque (N·m)

SPARE PARTS

Designation	Clamping screw	Wrench
JS***-SXXL09	CSTC-4L055L	T-1008/5

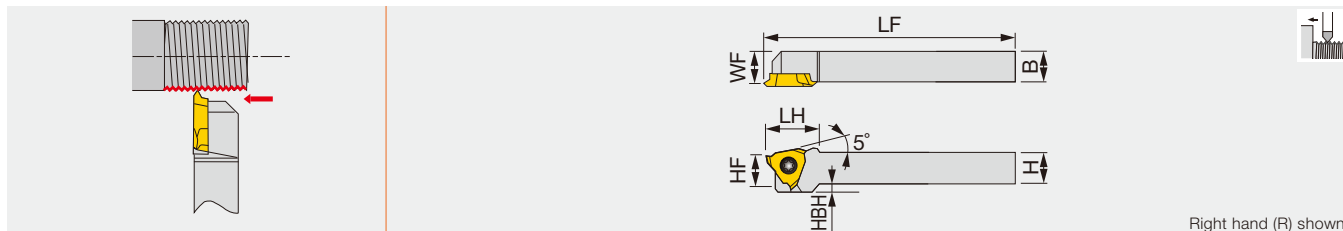
Excellent accessibility to the workpiece face

Utilizing various tools minimizes the incomplete thread part.



Insert designation	Cutting edge geometry (mm)	PDX (mm)	Pitch (mm)									
			0.2	0.25	0.35	0.4	0.5	0.6	0.8	1	1.25	1.5
JXTG12FR-60A-000	0.05 (flat)	0.25	Applicable area									
JXTG12FL-60A-000												
JXTG12FR-60B-000	0.05 (flat)	2.25	Applicable area									
JXTG12FL-60B-000												
JXTG12FR-60A-005	R0.05	0.6	Applicable area									
JXTG12FL-60A-005												
JXTG12FR-60B-005	R0.05	1.9	Applicable area									
JXTG12FL-60B-005												
JXTG12FR-60N-010	R0.1	1.25	Applicable area									
JXTG12FL-60N-010												
			127	72	52	32	16					
			Threads per inch (TPI)									

Reference pages: Inserts → 12



Right hand (R) shown.

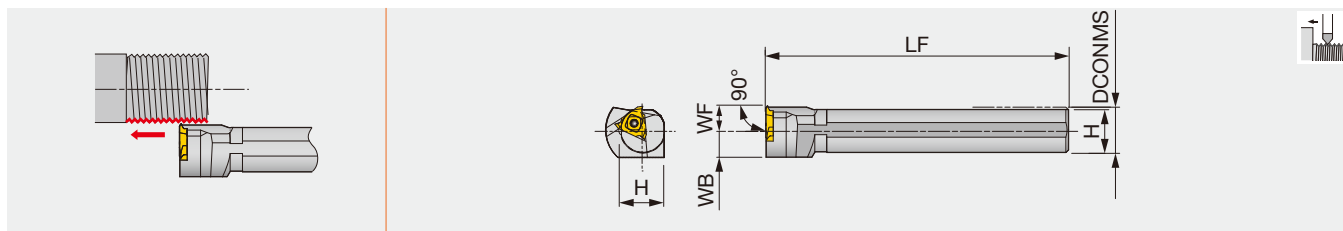
Designation	H	B	LF	LH	HF	WF	HBH	Insert
JSTTR/L1010X3	10	10	120	18.5	10	9.5	2	JTTR/L30...
JSTTR/L1212F3	12	12	85	18.5	12	11.5	-	JTTR/L30...
JSTTR/L1212X3	12	12	120	18.5	12	11.5	-	JTTR/L30...
JSTTR/L1616X3	16	16	120	16.5	16	15.5	-	JTTR/L30...

Recommended clamping torque: 1.2 N·m

SPARE PARTS



Designation	Clamping screw	Wrench 1	Wrench 2 (Optional)
JSTTR/L...	CSTB-4SD	T-8F	(T-8L)



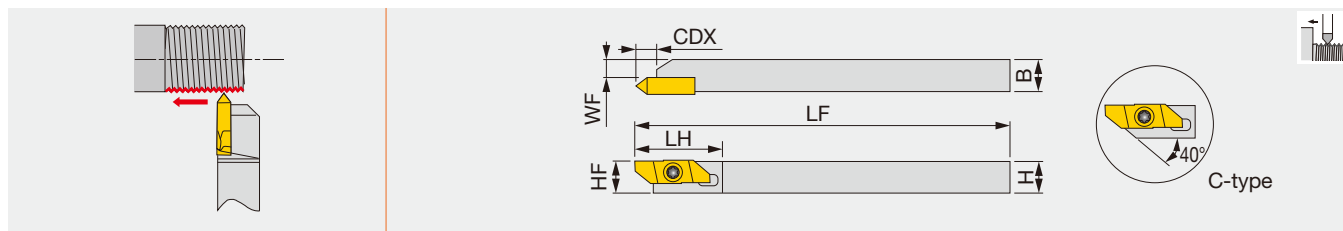
Designation	DCONMS	WF	LF	H	WB	Insert
JS19K-TTL3	19.05	10	125	18	11.5	JTTR30...
JS20K-TTL3	20	10	125	19	11.5	JTTR30...
JS22K-TTL3	22	10	125	21	11.5	JTTR30...
JS25K-TTL3	25.4	10	125	24	12.7	JTTR30...

Recommended clamping torque: 3.5 N·m

SPARE PARTS



Designation	Clamping screw	Wrench
JS**-TTL3	CSTB-4S	T-15F



Designation	H	B	LF	LH	CDX	HF	WF	Insert
JSXBR1010K8-C	10	10	125	29	6.4	10	5.7	JXT*R...
JSXBR1212K8-C	12	12	125	29	6.4	12	7.7	JXT*R...
JSXBR1616K8	16	16	125	29	6.4	16	11.7	JXT*R...
JSXBR2020K8	20	20	125	29	6.4	20	15.7	JXT*R...
JSXBR2525K8	25	25	125	29	6.4	25	20.7	JXT*R...

Note: Can be wrenched also from the back with a double-head screw.
This toolholder can be used for JXB back-turning insert and JXT threading insert.

SPARE PARTS

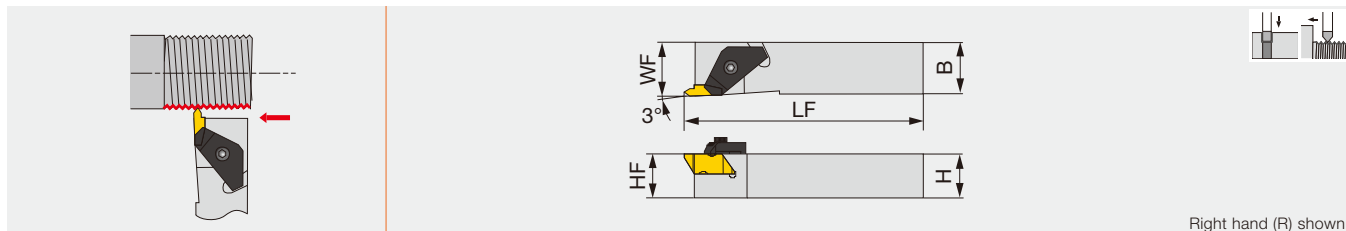


Designation	Clamping screw	Wrench 1	Wrench 2 (Optional)
JSXBR...	CSTB-4SD	T-8F	(T-8L)

TUNGST-CLAMP

FLASR/L

External grooving and threading toolholder, for Swiss lathes



Right hand (R) shown.

Designation	H	B	LF	HF	WF	Insert	Torque*
FLASR/L-1616M3	16	16	125	16	16	FLT-3...	3

Torque* : Recommended clamping torque (N·m)

Note: Use the right-hand insert (FLT-3R...) for a right-hand holder (FLASR...); the left-hand insert (FLT-3L...) for a left-hand holder (FLASL...).

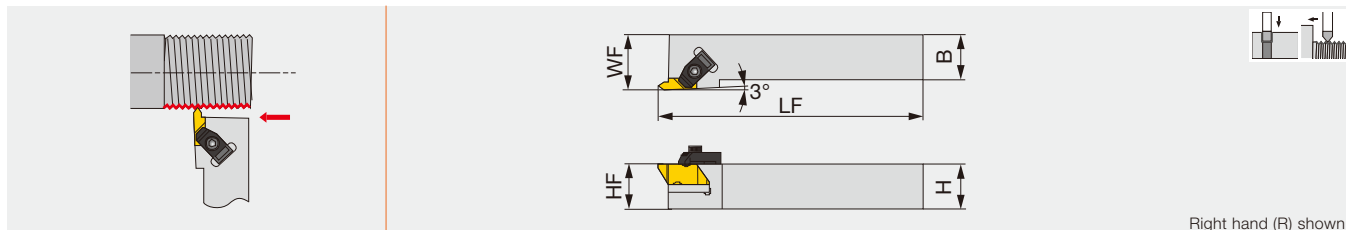
SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
FLASR-1616M3	TF-184	S-412	5/32HEX
FLASL-1616M3	TF-185	S-412	5/32HEX

TUNGST-CLAMP

FLSR/L

External grooving and threading toolholder



Right hand (R) shown.

Designation	H	B	LF	HF	WF	Insert	Torque*
FLSR/L-2020M3	20	20	125	20	32	FLT-3...	3
FLSR/L-2525M3	25	25	150	25	32	FLT-3...	3

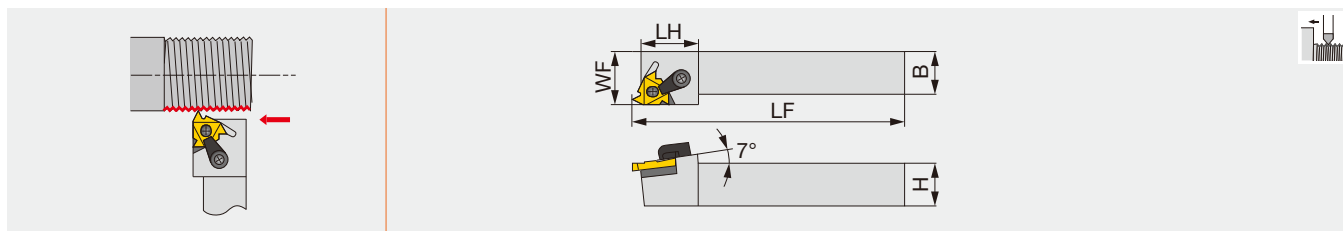
Torque* : Recommended clamping torque (N·m)

Note: Use the right-hand insert (FLT-3R...) for a right-hand holder (FLSR...); the left-hand insert (FLT-3L...) for a left-hand holder (FLSL...).

SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
FLSR-****M3	TF-72	S-412	5/32HEX
FLSL-****M3	TF-73	S-412	5/32HEX

External threading toolholder, for single-sided lay down inserts

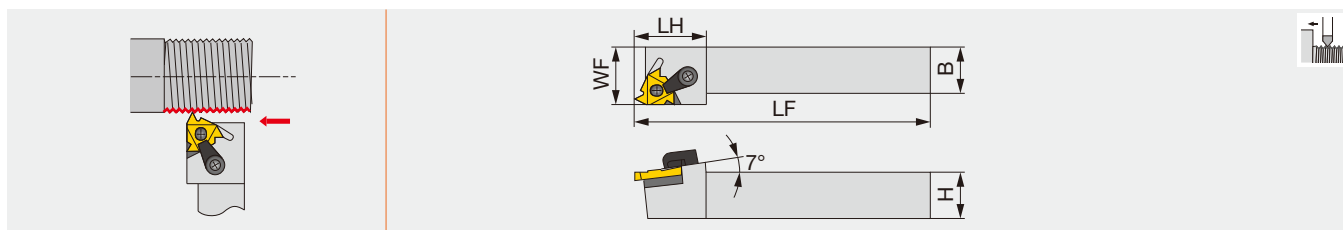


Designation	H	B	LF	LH	WF	Insert
MTVNR-2525M5	25	25	152	39	31.8	L535B**EXT-FC
MTVNR-3232M5	32	32	178	39	38.1	L535B**EXT-FC

SPARE PARTS

Designation	Shim	Lock pin	Clamp	Clamping screw	Wrench
MTVNR...	LS53NOFORMEXT	NL-58	TC-250	STC-11	1/8HEX

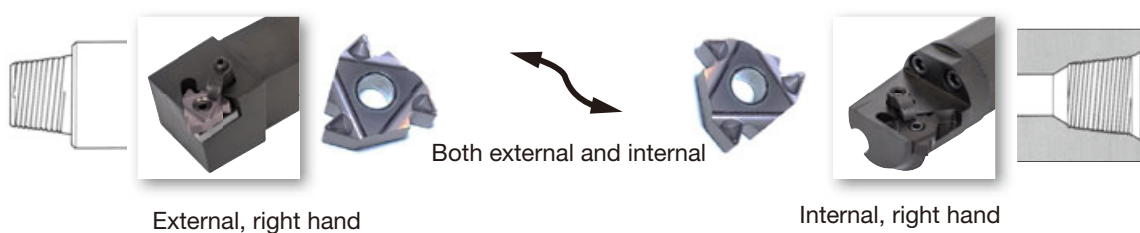
External threading toolholder, for double-sided lay down inserts



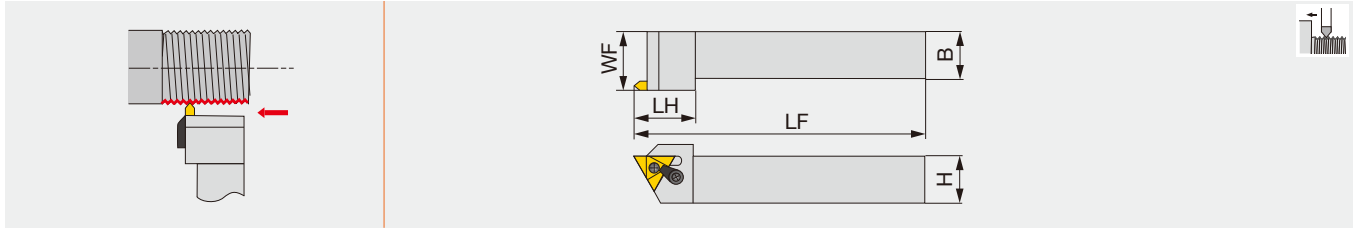
Designation	H	B	LF	LH	WF	Insert
MTVNR-3232M54	32	32	178	39	38.1	LDS54**FT-CB#...

SPARE PARTS

Designation	Shim	Lock pin	Clamp	Clamping screw	Wrench
MTVNR-3232M54	LS53NOFORMEXT	NL-58	TC-250	STC-11	1/8HEX



Multi-clamp external threading toolholder, for on edge inserts



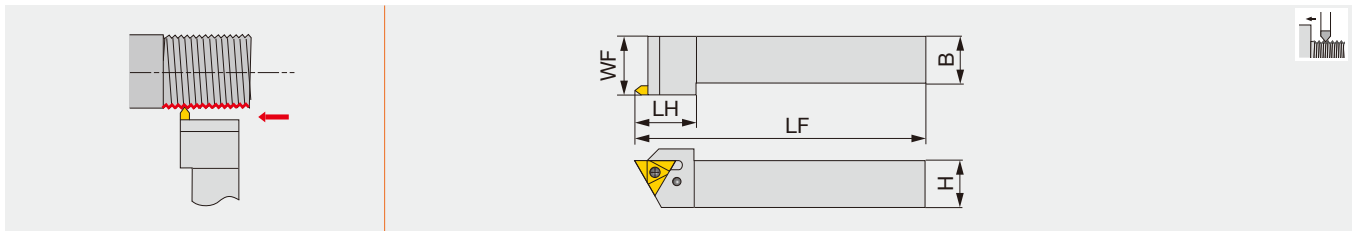
Designation	H	B	LF	LH	WF	Insert
MTVOR-2525M4	25	25	150	31	31.7	TNM*43...
MTVOR-3232M4	32	32	170	32	38.1	TNM*43...
MTVOR-2525M5	25	25	150	36	31.7	TNM*54...
MTVOR-3232M5	32	32	178	36	38.1	TNM*54...

Note: STVOR is recommended for TNMC insert although the insert can be used on multi-clamp (M type) toolholder.

SPARE PARTS

Designation	Lock pin	Clamp	Clamping screw	Wrench
MTVOR-**M4	NL-44	TC-190	STC-5	3/32HEX
MTVOR-**M5	NL-56	TC-250	STC-11	1/8HEX

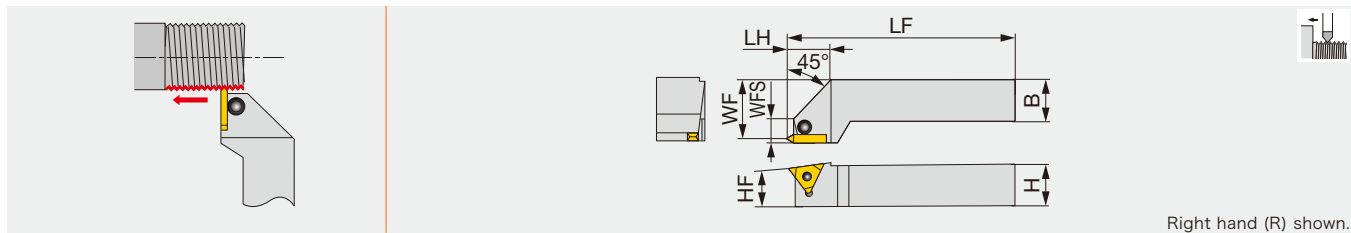
Screw-on external threading toolholder, for on edge inserts



Designation	H	B	LF	LH	WF	Insert
STVOR-2525M4	25	25	150	31	31.7	TNMC43...
STVOR-3232M4	32	32	178	31	38.1	TNMC43...
STVOR-2525M5	25	25	150	36	31.7	TNMC54...
STVOR-3232M5	32	32	178	36	38.1	TNMC54...

SPARE PARTS

Designation	Clamping screw	Clamp (Optional)	Clamping screw (Optional)	Wrench 1	Wrench 2
STVOR-**M4	SD2	TC-190	STC-9	T-20TORX	3/32HEX
STVOR-**M5	SD3	TC-250	STC-11	T-20TORX	1/8HEX

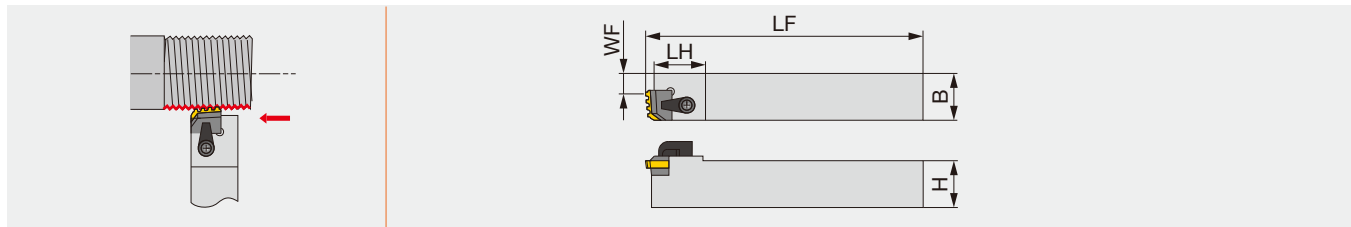


Right hand (R) shown.

Designation	H	B	LF	LH	HF	WF	WFS	Insert
TT-2525R/LE	25	25	150	25	25	32	15	TTR/L42...

SPARE PARTS

Designation	Clamp	Right-left screw	Wrench
TT-2525R/LE	CP91	DS-6	P-3

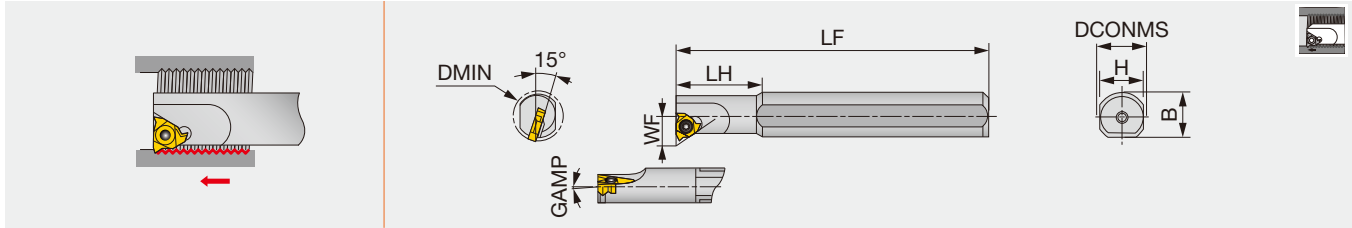


Designation	WF	LF	LH	H	B	Insert
CLVOR-25M6	16.1	177	32	25	25	CR...
CLVOR-32M6	16.1	177	32	32	32	CR...
CLVOR-40M8	21	170	38.1	40	40	CR-5B75-4E

SPARE PARTS

Designation	Shim	Shim screw	Clamp	Clamping screw	Wrench
CLVOR-25M6	TF1207	SF80	TC-311	STC-4	T-25TORX 5/32HEX
CLVOR-32M6	TF1207	SF85	TC-311	STC-4	T-25TORX 5/32HEX
CLVOR-40M8	TF8132-E	SF60	TC-311	STC-4	T-20TORX 5/32HEX

Internal threading bars, Screw-on clamp



Designation	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMP	Coolant hole	Insert
SIR0005H06	STEEL	6.4	12	4.3	100	12	11	-	1.5°	Without	06IR...
SIR0007K08	STEEL	8	16	5.3	125	18	15	-	1.5°	Without	08IR...
SIR0005H06CB	CARBIDE	6.4	6	4.3	100	25	5	-	1.5°	With	06IR...
SIR0007K08CB	CARBIDE	7.8	8	5.3	125	30	7	-	1.5°	With	08IR...

Note: Use the right-hand insert (**IR...) for a right-hand holder (SIR...).
Recommend over 1 mm clearance between internal diameter of thread and each tools DMIN.

SPARE PARTS

Designation	Clamping screw	Wrench
SIR0005H06...	SR 14-552	T-6F-S
SIR0007K08...	SR 14-558	T-6F-S

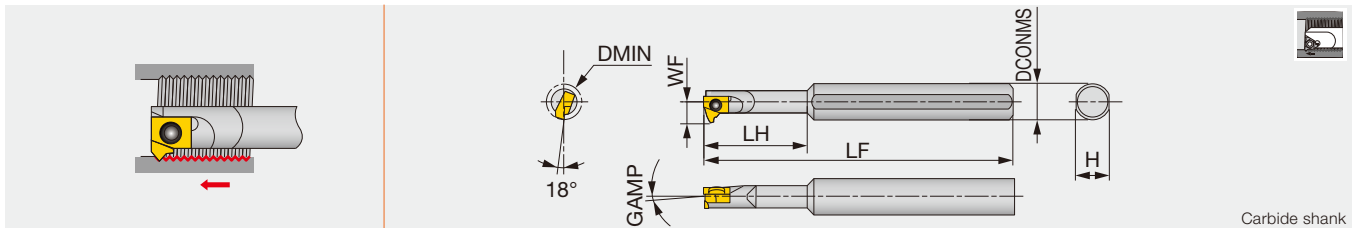
Applicable thread size

Description	ISO metric	Unified IRA60 Insert	Parallel pipe IRA55 Insert
SIR0005H06...	≥ M9	≥ 3/8-24 UNF	≥ G1/8
SIR0007K08...	≥ M11	≥ 7/16-20 UNF	≥ G1/4

TUNGTHREAD

SNR-2/3

Screw-on internal threading toolholder



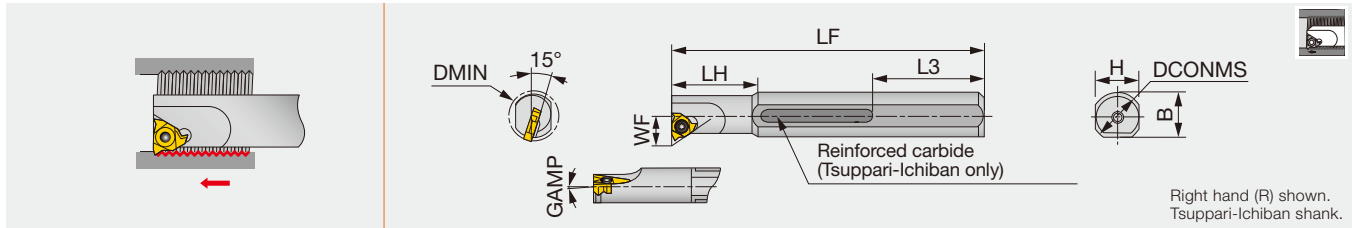
Designation	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	Insert
SNR0006H06-2	Steel	8	8	4.7	100	18	7	2°	6IR...
SNR0006H06-3	Steel	8	8	4.7	100	18	7	3°	6IR...
SNR0008H06-2	Steel	10	8	5.7	100	18	7	2°	6IR...
SNR0008H06-3	Steel	10	8	5.7	100	18	7	3°	6IR...
SNR0006K06SC-2	Carbide	8	8	4.7	125	30	7	2°	6IR...
SNR0006K06SC-3	Carbide	8	8	4.7	125	30	7	3°	6IR...
SNR0008K06SC-2	Carbide	10	8	5.7	125	18	7	2°	6IR...
SNR0008K06SC-3	Carbide	10	8	5.7	125	18	7	3°	6IR...

Note: Use the right-hand insert (6IR...) for a right-hand holder (SNR...).

SPARE PARTS

Designation	Clamping screw	Wrench
SNR0006H06...	CSTB-2L040	T-6F
SNR0008H06...	CSTB-2L	T-6F
SNR0006K06SC...	CSTB-2L040	T-6F
SNR0008K06SC...	CSTB-2L	T-6F

Screw-on internal threading toolholder



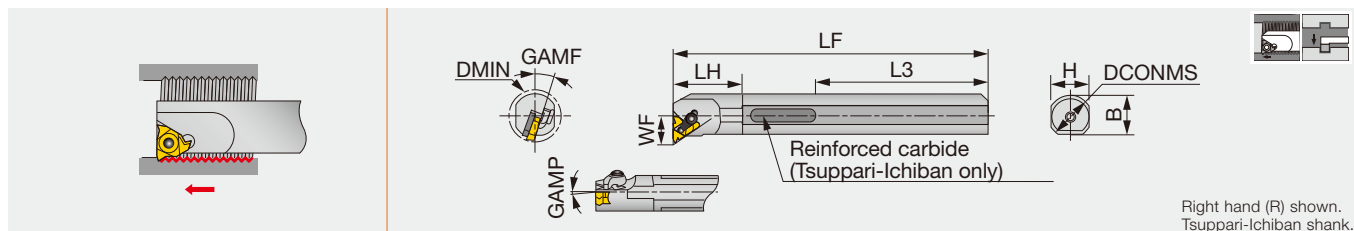
Designation	Material	DMIN	DCONMS	WF	LF	LH	L3	H	B	GAMP	Insert
TSNR0016Q16	Reinforced	19	16	10.6	180	40	59	15	-	1°	16IR...
TSNR0020R22	Reinforced	24	20	13.9	200	50	49	18	-	1°	22IR...
SNR/L0010K11	Steel	12	16	6.6	125	25	-	15	15.5	1°	11IR/L...
SNR0010K11-2	Steel	12	16	6.6	125	25	-	15	15.5	2°	11IR...
SNR0010K11-3	Steel	12	16	6.6	125	25	-	15	15.5	3°	11IR...
SNR/L0013L11	Steel	15	16	8.2	140	32.5	-	15	15.5	1°	11IR/L...
SNR0013L11-2	Steel	15	16	8.2	140	32.5	-	15	15.5	2°	11IR...
SNR0013L11-3	Steel	15	16	8.2	140	32.5	-	15	15.5	3°	11IR...
SNR/L0016M16	Steel	19	16	10.6	150	40	-	15	15.5	1°	16IR/L...
SNR0016M16-2	Steel	19	16	10.6	150	40	-	15	15.5	2°	16IR...
SNR0016M16-3	Steel	19	16	10.6	150	40	-	15	15.5	3°	16IR...
SNR/L0020Q22	Steel	24	20	13.9	180	50	-	18	19	1°	22IR/L...
SNR0020Q22-2	Steel	24	20	13.9	180	50	-	18	19	2°	22IR...
SNR0020Q22-3	Steel	24	20	13.9	180	50	-	18	19	3°	22IR...
SNR0010M11SC	Carbide	13	10	7.4	150	24	-	9	-	1°	11IR...
SNR0010M11SC-2	Carbide	13	10	7.4	150	24	-	9	-	2°	11IR...
SNR0010M11SC-3	Carbide	13	10	7.4	150	24	-	9	-	3°	11IR...
SNR0012P11SC	Carbide	15	12	8.5	170	28	-	11	-	1°	11IR...
SNR0012P11SC-2	Carbide	15	12	8.5	170	28	-	11	-	2°	11IR...
SNR0012P11SC-3	Carbide	15	12	8.5	170	28	-	11	-	3°	11IR...
SNR/L0016R16SC	Carbide	20	16	11.9	200	35	-	15	-	1°	16IR/L...
SNR0016R16SC-2	Carbide	20	16	11.9	200	35	-	15	-	2°	16IR...

Note: Use the right-hand insert (**IR...) for a right-hand holder (SNR...); the left-hand insert (**IL...) for a left-hand holder (SNL...).

SPARE PARTS

Designation	Clamping screw	Wrench
TSNR0016Q16	CSTB-3.5	T-15F
TSNR0020R22	CSTB-4	T-15F
SNR/L00**11...	CSTB-2.5	T-8F
SNR/L0016M16...	CSTB-3.5	T-15F
SNR/L0020Q22...	CSTB-4	T-15F
SNR00**11SC...	CSTB-2.5	T-8F
SNR/L0016R16SC...	CSTB-3.5	T-15F

Clamp-on internal threading toolholder (alternative clamping of screw-on or clamp-on only for DT type)



Designation	Material	DMIN	DCONMS	WF	LF	LH	L3	H	B	GAMF	GAMP	Insert
TCNR0020R16DT	Reinforced	24	20	14	200	30	49	18	-	15°	1°	16IR...
TCNR0025S16DT	Reinforced	29	25	16.5	250	38	64	23	-	15°	1°	16IR...
TCNR0025S22DT	Reinforced	30	25	18.2	250	38	64	23	-	15°	1°	22IR...
CNR/L0020P16	Steel	24	20	14	170	30	-	18	19	15°	1°	16IR/L...
CNR/L0025R16	Steel	29	25	16.5	200	38	-	23	24	15°	1°	16IR/L...
CNR/L0032S16	Steel	37	32	20.1	250	48	-	30	31	15°	1°	16IR/L...
CNR/L0025R22	Steel	30	25	18.2	200	38	-	23	24	15°	1°	22IR/L...
CNR/L0032S22	Steel	38	32	21.9	250	48	-	30	31	15°	1°	22IR/L...
CNR0040T27	Steel	46	40	26.9	300	60	-	37	38.5	10°	1°	27IR...

Note: A clamp set consists of a clamp and a clamping screw.

A shim set consists of a shim and a shim screw to secure the shim to the shank.

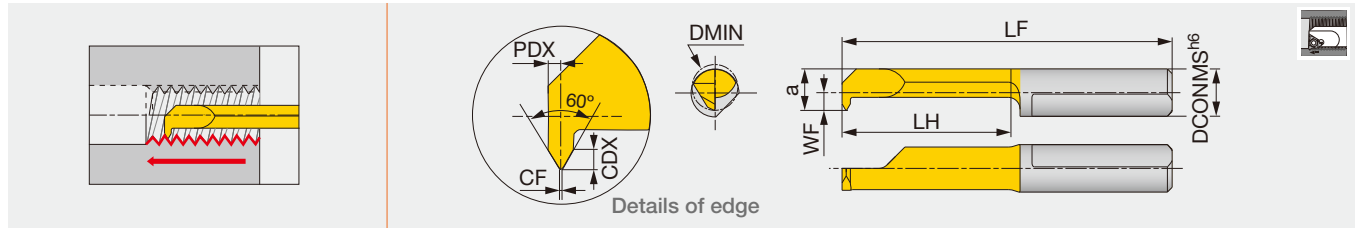
Standard shims can be used on both right- and left-hand toolholders. Please use either of the sides depending on the tool hand.

Use the right-hand insert (**IR...) for a right-hand holder (CNR...); the left-hand insert (**IL...) for a left-hand holder (CNL...).

When using DT type, please remove either the clamp set or the insert clamping screw.

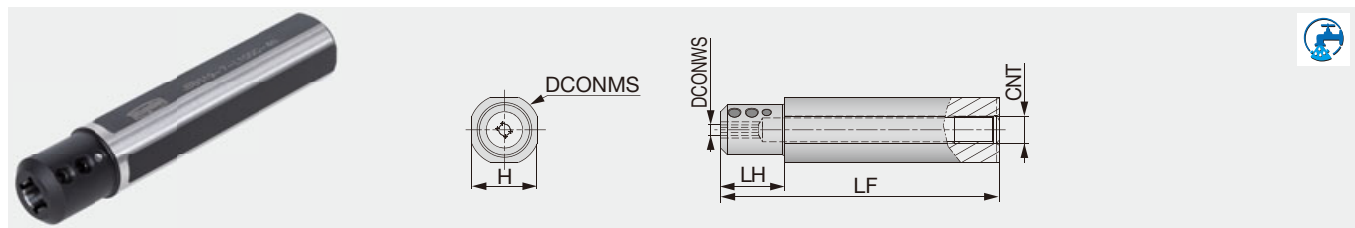
SPARE PARTS

Designation	Clamp set	Clamping screw	Shim screw	Shim	Shim set R	Shim set L	Wrench 1	Wrench 2	Wrench 3
TCNR002**16DT	CSP16	CSTB-3.5ST	DTS5-3.5	A16-1DT	-	-	P-3.5	T-15F	-
TCNR0025S22DT	CSP22	CSTB-4ST	DTS6-4	GX22-1DT	-	-	P-4	T-15F	T-20F
CNR/L**16	CSP16	-	-	-	A16-1	A16-1	-	T-15F	-
CNR/L**22	CSP22	-	-	-	NXN22-1	NXE22-1	-	T-20F	-
CNR0040T27	CSP27	-	-	-	NXN27-1	NXE27-1	P-4	-	-



Designation	SH725	Pitch	DMIN	CF-0.02	DCONMS	WF	a	LF	LH	CDX	PDX
TBIR04140050-D040	●	0.5	4	0.06	4	1.5	3.5	30	14	0.3	0.35
TBIR07140050-D050	●	0.5	5	0.06	7	0.9	4.4	30	14	0.3	0.35
TBIR07140075-D050	●	0.75	5	0.09	7	0.9	4.4	30	14	0.4	0.45
TBIR07140100-D048	●	1	4.8	0.12	7	0.9	4.4	30	14	0.6	0.55
TBIR07140100-D060	●	1	6	0.12	7	1.8	5.3	30	14	0.6	0.55
TBIR07140150-D060	●	1.5	6	0.18	7	1.8	5.3	30	14	0.8	0.75

● : Line up

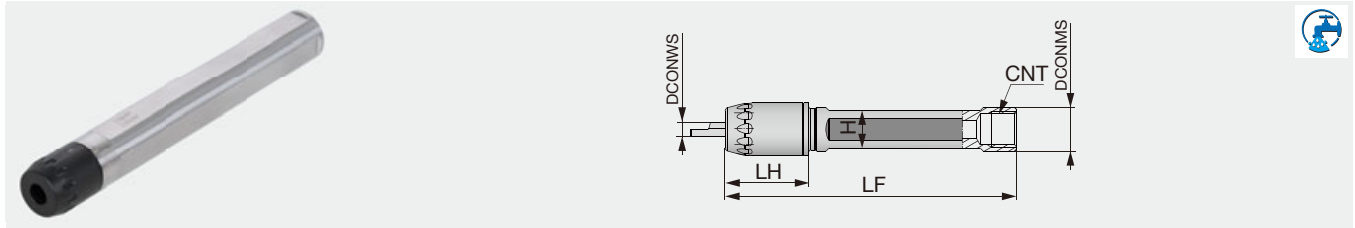


Designation	DCONMS	DCONWS	LF	LH	H	CNT
JBBS12-4-L80C-4N	12	4	80	10	10.3	Rc1/16
JBBS127-4-L80C-4N	12.7	4	80	10	11.6	Rc1/16
JBBS14-4-L80C-4N	14	4	80	10	12	Rc1/8
JBBS159-4-L100C-4N	15.875	4	100	10	14.58	Rc1/8
JBBS159-7-L100C-4N	15.875	7	100	10	14.58	Rc1/8
JBBS16-4-L100C-4N	16	4	100	10	15	Rc1/8
JBBS16-7-L100C-4N	16	7	100	10	15	Rc1/8
JBBS19-4-L100C-4N	19.05	4	100	20	17.2	Rc1/8
JBBS19-7-L100C-4N	19.05	7	100	20	17.2	Rc1/8
JBBS20-4-L100C-4N	20	4	100	20	18	Rc1/8
JBBS20-7-L100C-4N	20	7	100	20	18	Rc1/8
JBBS22-4-L100C-4N	22	4	100	20	20	Rc1/8
JBBS22-7-L100C-4N	22	7	100	20	20	Rc1/8
JBBS25-4-L100C-4N	25	4	100	23	23	Rc1/8
JBBS25-7-L100C-4N	25	7	100	23	23	Rc1/8
JBBS254-4-L100C-4N	25.4	4	100	23	23.4	Rc1/8
JBBS254-7-L100C-4N	25.4	7	100	23	23.4	Rc1/8

SPARE PARTS



Designation	Clamping screw	Wrench
JBBS**-4-L**C-4N	SSHM5-6PF-S	P-2.5
JBBS**-7-L**C-4N	SSHM5-4PF-S	P-2.5



Designation	DCONMS	DCONWS	LF	LH	H	CNT
JBBSA12-4-L80C	12	4	80	23	10.3	Rc1/8
JBBSA127-4-L80C	12.7	4	80	23	11.6	Rc1/8
JBBSA14-4-L80C	14	4	80	23	12	Rc1/8
JBBSA159-4-L100C	15.875	4	100	23	14	Rc1/8
JBBSA159-7-L100C	15.875	7	100	23	14	Rc1/8
JBBSA16-4-L100C	16	4	100	23	14	Rc1/8
JBBSA16-7-L100C	16	7	100	23	14	Rc1/8
JBBSA19-4-L120C	19.05	4	120	23	17.2	Rc1/8
JBBSA19-7-L120C	19.05	7	120	23	17.2	Rc1/8
JBBSA20-4-L120C	20	4	120	23	18	Rc1/8
JBBSA20-7-L120C	20	7	120	23	18	Rc1/8
JBBSA22-4-L135C	22	4	135	23	20	Rc1/8
JBBSA22-7-L135C	22	7	135	23	20	Rc1/8
JBBSA25-4-L135C	25	4	120	23	23	Rc1/8
JBBSA25-7-L135C	25	7	120	23	23	Rc1/8
JBBSA254-4-L120C	25.4	4	120	23	23.4	Rc1/8
JBBSA254-7-L120C	25.4	7	120	23	23.4	Rc1/8

SPARE PARTS



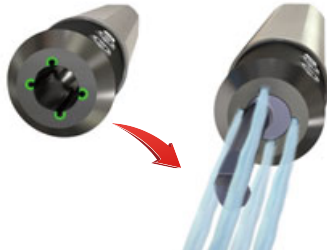
Designation	Cap	Wrench
JBBSA**-4-L...	CAP-A-4	WRENCH-A-4
JBBSA**-7-L...	CAP-A-7	WRENCH-A-7

■ New sleeve with four coolant holes for optimal performance

- Optimum sleeve option for all boring operations. Sleeves with four coolant holes can be used with all TinyMini-Turn tools
- 4 streams of coolant jets are directed to the cutting point, improving chip evacuation
- Sufficient coolant supply eliminates chip bird-nesting on the tools or workpiece, enabling trouble-free, unattended operation over an extended time
- Significantly prolongs tool life

Internal coolant sleeve

First recommendation!

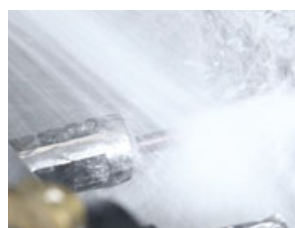


Excellent chip evacuation

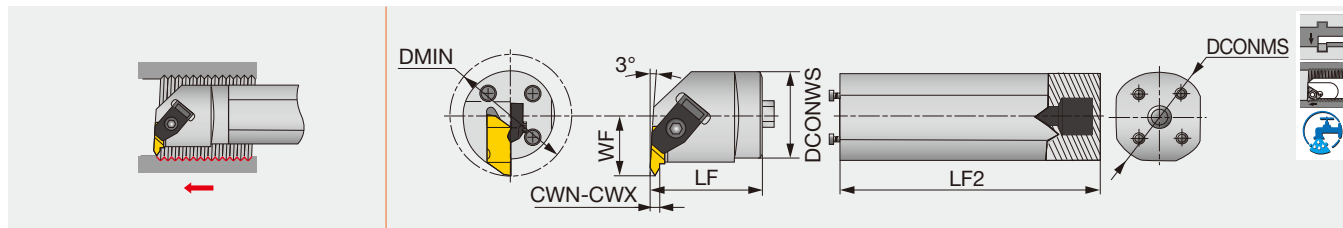


- No chip jamming
- No machine stoppage
- No downtime

Conventional (External coolant)



- Chip jamming
- Increased machine downtime



Designation	DMIN	DCONWS	LF	WF	Insert	Torque*
HS40-FLER3W	56.1	40	41.3	25.4	FLT-3L...	3
HS50-FLER3W	70.1	50	41.9	35	FLT-3L...	3

Torque* : Recommended clamping torque (N·m)

Note: Use the left-hand insert (FLT-3L...) for a right-hand holder (HS**-FLER...).

SPARE PARTS

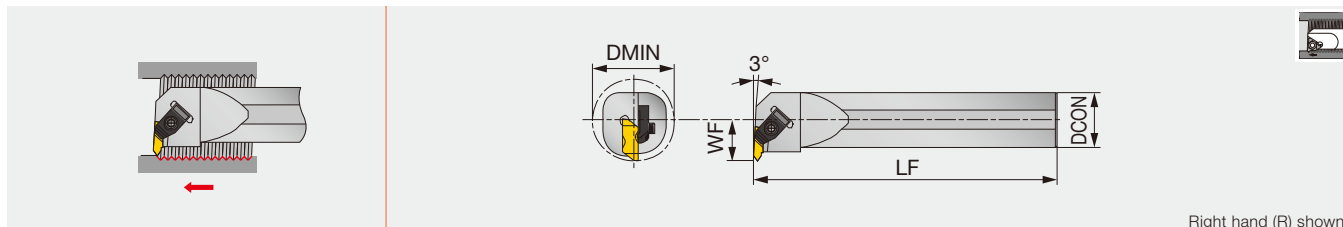
Designation	Clamp	Clamping screw	Wrench
HS40-FLER3W	TF-73	S-412	5/32HEX
HS50-FLER3W	TF-73	S-412	5/32HEX

Shank

Designation	DCONMS	LF2
S-570-40M-40	40	273
S-570-50M-50	50	366

Spare parts

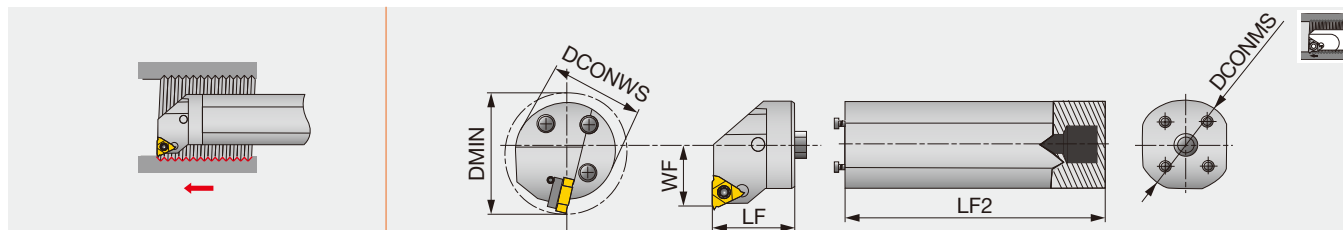
Designation	Clamping screw	Wrench
S-570-40M-40	SS100	5/32HEX
S-570-50M-50	SS94	1/4EX



Designation	Pitch	DMIN	DCON	LF	WF	Insert
A25M-FLER/L3	2.11 - 5.08	34.9	25	300	17.7	FLT-3...
A32M-FLER/L3	2.11 - 5.08	44.5	32	350	22.1	FLT-3...
A40M-FLER3	2.11 - 5.08	50.8	40	350	24.5	FLT-3L...

SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
A**M-FLER3	TF-73	S-412	5/32HEX
A**M-FLEL3	TF-72	S-412	5/32HEX



Designation	DMIN	DCONWS	WF	LF	Insert
HS40-LNFR-53	50	40	28.7	41.3	L535B**INT-FC
HS50-LNFR-53	63	50	32.7	41.3	L535B**INT-FC

SPARE PARTS

Designation	Lock pin	Clamp	Clamping screw	Wrench
HS**-LNFR-53	NL-56	TC-250	STC-11	1/8HEX

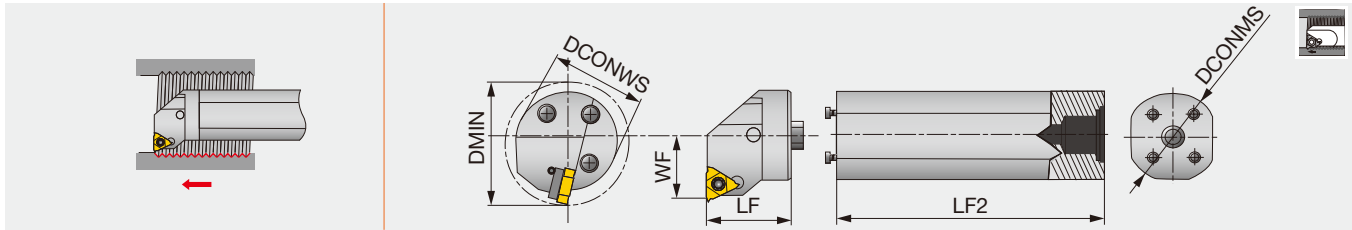
Shank

Designation	DCONMS	LF2
S-570-40M-40	40	273
S-570-50M-50	50	366

SPARE PARTS

Designation	Clamping screw	Wrench
S-570-40M-40	SS100	5/32HEX
S-570-50M-50	SS94	1/4EX

Head exchangeable internal threading toolholder, for double-sided lay down inserts



Designation	DMIN	DCONWS	WF	LF	Insert
HS40-LNFR-54API	50	40	27	32	LDS54**FT-CB#...
HS50-LNFR-54API	63	50	35	40	LDS54**FT-CB#...

SPARE PARTS

Designation	Lock pin	Clamp	Clamping screw	Wrench
HS40-LNFR-54API	H410-1	TC-250	STC-11	1/8HEX
HS50-LNFR-54API	NL-56	TC-250	STC-11	1/8HEX

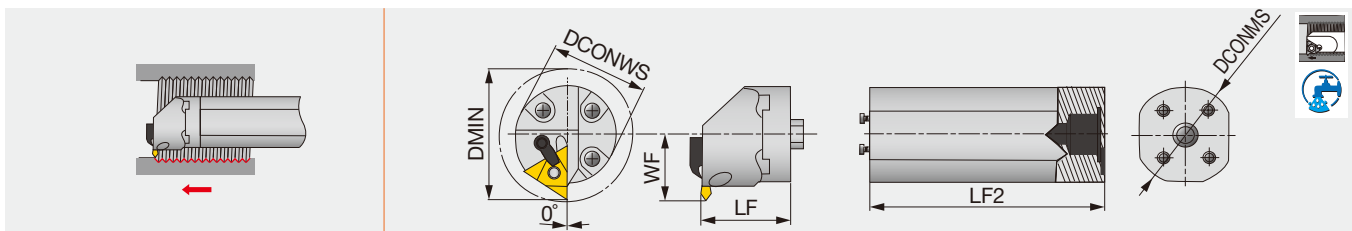
Shank

Designation	DCONMS	LF2
S-570-40M-40	40	273
S-570-50M-50	50	366

SPARE PARTS

Designation	Clamping screw	Wrench
S-570-40M-40	SS100	5/32HEX
S-570-50M-50	SS94	1/4EX

Multi-clamp internal threading toolholder, for on edge inserts



Designation	DMIN	DCONWS	WF	LF	Insert
HS40-MTHOR-4	66.7	40	25.9	32	TNM*43...
HS50-MTHOR-4	73	50	35.9	40	TNM*43...
HS40-MTHOR-5	81.3	40	30.6	32	TNM*54...
HS50-MTHOR-5	82.6	50	35.9	40	TNM*54...

SPARE PARTS

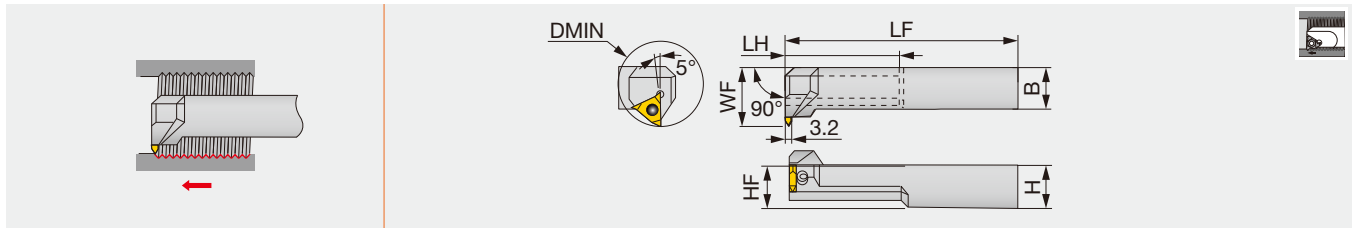
Designation	Lock pin	Clamp	Clamping screw	Wrench
HS**-MTHOR-4	NL-44	TC-190	STC-5	3/32HEX
HS**-MTHOR-5	NL-56	TC-250	STC-11	1/8HEX

Shank

Designation	DCONMS	LF2
S-570-40M-40	40	273
S-570-50M-50	50	366

SPARE PARTS

Designation	Clamping screw	Wrench
S-570-40M-40	SS100	5/32HEX
S-570-50M-50	SS94	1/4EX

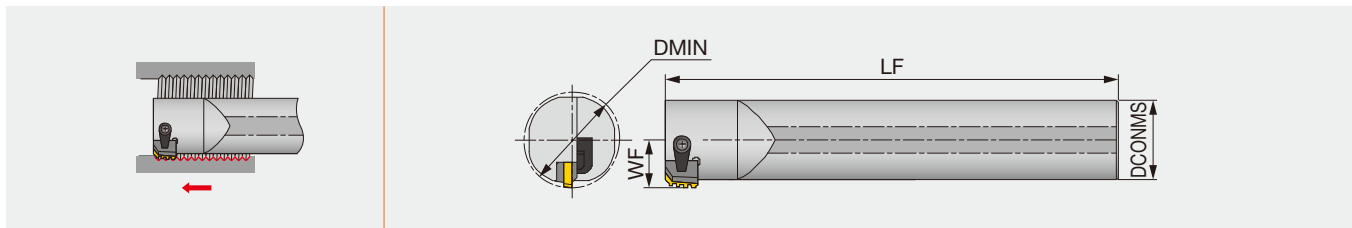


Designation	DMIN	H	B	LF	LH	HF	WF	Insert
TT-2525RI	50	25	25	200	70	25	35	TTL42...

Note: Use the left-hand insert (TTL42...) for a right-hand holder (TT-2525RI).

SPARE PARTS

Designation	Clamp	Right-left screw	Wrench
TT-2525RI	CP91	DS-6	P-3



Designation	DMIN	DCONMS	WF	LF	Insert
SI-CLHOR-40M6	50.8	40	23.16	400	CR...

SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
SI-CLHOR-40M6	TC-311	STC-8	5/32HEX

STANDARD CUTTING CONDITIONS

TUNGTHREAD

ISO	Workpiece material	Hardness	Cutting speed: Vc (m/min)							
			AH8015	T05HP	T05TP	AH725	T313V	NS9530	TH10	BX330
P	Steel / Alloy steel S45C, SCM440, etc. C45, 42CrMoS4, etc.	< 200HB	80 - 180	100 - 200	100 - 200	80 - 180	100 - 200	150 - 200	-	-
		> 200HB	60 - 160	100 - 150	100 - 150	60 - 160	100 - 150	100 - 170	-	-
M	Stainless steel SUS304, etc. X5CrNi18-9, etc.	-	50 - 130	70 - 130	70 - 130	50 - 130	70 - 130	-	-	-
K	Cast iron FC250, FC300, etc. 250, 300, etc.	-	60 - 150	70 - 150	70 - 150	50 - 100	70 - 150	-	70 - 90	-
N	Non-ferrous metal	-	-	-	-	-	-	-	100 - 500	-
S	Superalloys Ti-6Al-4V, Inconel718, etc.	-	20 - 80	-	-	-	-	-	10 - 40	-
H	Hardened steel	50 - 60HRC	-	-	-	-	-	-	10 - 30	50 - 200

TUNG-CLAMP

ISO	Workpiece material	Hardness	Grade	Application	Cutting speed Vc (m/min)	Pitch (mm)	Threads per inch (TPI)
P	Steel / Alloy steel S45C, SCM440, etc. C45, 42CrMoS4, etc.	< 200HB	AH725	Threading	80 - 180	Internal 2.11 - 5.08 External 1.27 - 4.23	Internal 5 - 12 External 6 - 20
		> 200HB	AH725	Threading	60 - 160	Internal 2.11 - 5.08 External 1.27 - 4.23	Internal 5 - 12 External 6 - 20
M	Stainless steel SUS304, etc. X5CrNi18-9, etc.	-	AH725	Threading	50 - 130	Internal 2.11 - 5.08 External 1.27 - 4.23	Internal 5 - 12 External 6 - 20

TETRAMCUT

TCT18R/L / TCT18FR

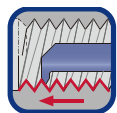
ISO	Workpiece material	Hardness	Priority	Grade	Cutting speed Vc (m/min)	Pitch (mm)	Threads per inch (TPI)
P	Steel / Alloy steel S45C, SCM440, etc. C45, 42CrMoS4, etc.	< 200HB	First choice	SH725	60 - 150	0.4 - 2.0	64 - 12
			Fracture resistance	AH725	60 - 150	0.8 - 3.0	32 - 8
		> 200HB	First choice	SH725	60 - 150	0.4 - 2.0	64 - 12
			Fracture resistance	AH725	60 - 150	0.8 - 3.0	32 - 8
M	Stainless steel SUS304, etc. X5CrNi18-9, etc.	-	First choice	SH725	50 - 80	0.4 - 2.0	64 - 12
		-	Fracture resistance	AH725	50 - 80	0.8 - 3.0	32 - 8
K	Cast iron FC250, FC300, etc. 250, 300, etc.	-	First choice	AH725	50 - 100	0.8 - 3.0	32 - 8
		-	Sharpness	SH725	50 - 100	0.4 - 2.0	64 - 12
S	Superalloys Ti-6Al-4V, Inconel718, etc.	-	First choice	SH725	30 - 100	0.4 - 2.0	64 - 12
		-	Fracture resistance	AH725	30 - 100	0.8 - 3.0	32 - 8

STANDARD CUTTING CONDITIONS

DUO^{JUST}CUT

ISO	Workpiece material	Hardness	Grade	Cutting speed Vc (m/min)	Pitch (mm)	Threads per inch (TPI)
P	Steel / Alloy steel S45C, SCM440, etc. C45, 42CrMoS4, etc.	< 200HB	SH725	50 - 200	0.2 - 1.5	127 - 16
		> 200HB	SH725	50 - 200	0.2 - 1.5	127 - 16
M	Stainless steel SUS304, etc. X5CrNi18-9, etc.	-	SH725	50 - 200	0.2 - 1.5	127 - 16
N	Aluminium alloys A5056, A6061, etc.	-	SH725	150 - 200	0.2 - 1.5	127 - 16
	Copper alloy C2600, C280C, etc.	-	SH725	100 - 200	0.2 - 1.5	127 - 16
S	Superalloys Ti-6Al-4V, Inconel718, etc.	-	SH725	30 - 80	0.2 - 1.5	127 - 16

TINY^{INI}MTURN

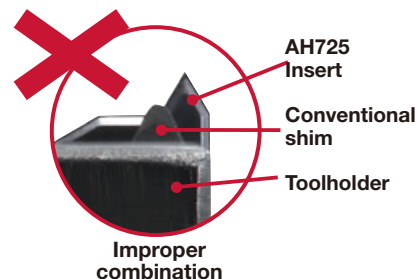


Internal threading

ISO	Workpiece material	Hardness	Grade	Cutting speed Vc (m/min)	Number of passes				
					Pitch (mm)				
					0.5	0.75	1	1.25	1.5
P	Steel / Alloy steel S45C, SCM440, etc. C45, 42CrMoS4, etc.	< 200HB	SH725	40 - 140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
		> 200HB	SH725	40 - 140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
M	Stainless steel SUS304, etc. X5CrNi18-9, etc.	-	SH725	40 - 140	8	10	12	15	18
K	Cast iron FC250, FC300, etc. 250, 300, etc.	-	SH725	30 - 100	7	9	12	14	17
N	Aluminium alloys, Copper alloy Si < 12%	-	SH725	90 - 200	6	8	10	12	15

■ IMPORTANT - Replacement of shim

AH725 insert has 2 types of shims according to the chipbreaker geometry. Please find an appropriate shim in the table below. When using a wrong shim, the insert seating may become unstable or the tool life may be shortened.



Interchangeable shim (Insert size: 16)

Toolholder screw type	Lead angle	External		Internal	
		① Conventional shim	① Standard (New)	② Conventional shim	② Standard (New)
Dual clamping methods of screw-on and clamp-on	4°	GXE16-4DT	AE16-4DT	GXN16-4DT	AN16-4DT
	3°	GXE16-3DT	AE16-3DT	GXN16-3DT	AN16-3DT
	2°	GXE16-2DT	AE16-2DT	GXN16-2DT	AN16-2DT
	1° (Standard)	GX16-1DT	A16-1DT	GX16-1DT	A16-1DT
	0°	GXE16-0DT	AE16-0DT	GXN16-0DT	AN16-0DT
	-1°	GXE16-99DT	AE16-99DT	GXN16-99DT	AN16-99DT
	-2°	GXE16-98DT	AE16-98DT	GXN16-98DT	AN16-98DT
Clamp-on	4°	GXE16-4	AE16-4	GXN16-4	AN16-4
	3°	GXE16-3	AE16-3	GXN16-3	AN16-3
	2°	GXE16-2	AE16-2	GXN16-2	AN16-2
	1° (Standard)	GXE16-1	A16-1	GXN16-1	A16-1
	0°	GXE16-0	AE16-0	GXN16-0	AN16-0
	-1°	GXE16-99	AE16-99	GXN16-99	AN16-99
	-2°	GXE16-98	AE16-98	GXN16-98	AN16-98

Shim to be replaced (Insert size: 16)

Thread	External			Internal		
	Designation	Grade	Replacement	Designation	Grade	Replacement
ISO				16IR15ISO-B	AH725	
				16IR17ISO-B	AH725	
				16IR20ISO-B	AH725	
55°	16ERAG55-B	AH725		16IRAG55-B	AH725	
				16IRG55-B	AH725	
60°	16ERA60-B	AH725		16IRAG60-B	AH725	
				16IRA60-B	AH725	
				16IRG60-B	AH725	
UN				16IR18UN-B	AH725	
				16IR16UN-B	AH725	
				16IR14UN-B	AH725	
W				16IR16W-B	AH725	
				16IR14W-B	AH725	
PT				16IR14PT-B	AH725	
NPT	16ER8NPT-B	AH725		16IR14NPT-B	AH725	
				16IR115NPT-B	AH725	

① Conventional shim
↓
① Standard (New)

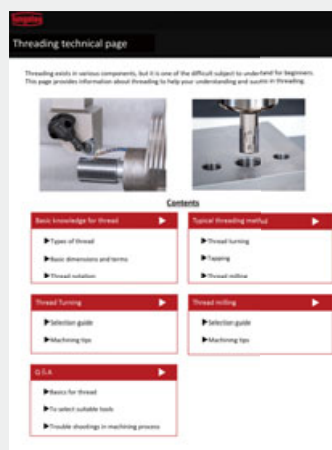
② Conventional shim
↓
② Standard (New)

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- Basic knowledge on threads and thread machining
- Threading tool selection guide and the latest machining techniques
- F.A.Q. and troubleshooting guide



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