

Threading Tool



Threading Tool - Content structure

- Products are listed by product series and thread to be consistent with wording throughout.
- Inserts and toolholders in the catalog are our standard items.

Select the Thread form

Method ① Select the screw shape described at the left end of each page, jump to the page on the left index, and choose a designation you need (⑤) in the dimension table (⑥). Applicable toolholders are shown in (⑦).

Method ② Select the series name on **E003** and check the details on the product page.

Method ③ Select an item from Quick Guide on E004 - E007.

[illegible]

- | | |
|---|--|
| ① : Screw shape | ⑤ : Designation (for external, for internal) |
| ② : Series name | ⑥ : Dimension table (conforming to ISO13399) |
| ③ : Drawing of thread, threading insert, threading toolholder | ⑦ : Applicable toolholder |
| ④ : Applicable pitch and the number of threads | ⑧ : Spare parts |
| | ⑨ : Reference page |

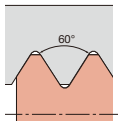
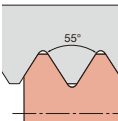
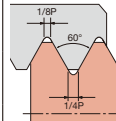
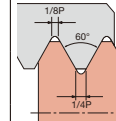
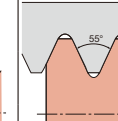
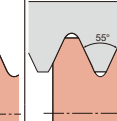
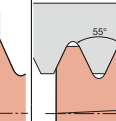
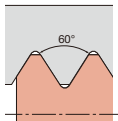
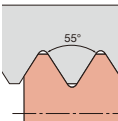
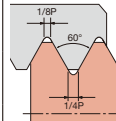
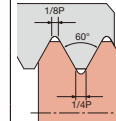
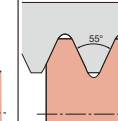
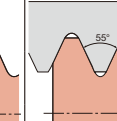
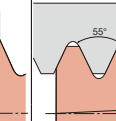
When ordering

- Please specify the designation and quantity for threading toolholders.
e.g. **TSNR0020R22 ... 1** (one threading toolholder per package)
- Please specify the designation, grade, and quantity for threading inserts.
e.g. **16IR175ISO AH725 ... 5** (five threading inserts per package)

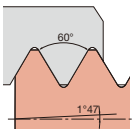
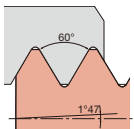
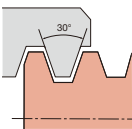
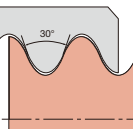
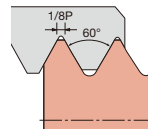
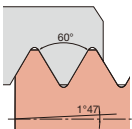
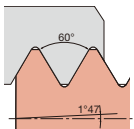
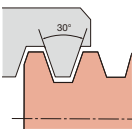
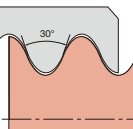
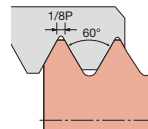
Main products

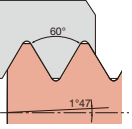
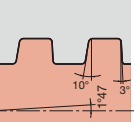
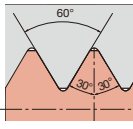
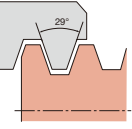
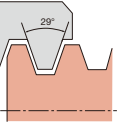
Thread form						Inch	Metric
						✓	✓
			TUNGTHREAD Lay down insert, toolholder Standard items cover a wide variety of threading inserts. Standard tool series with double-clamp system for excellent insert stability in machining API-standard threads.	E004 -, E010 - E065		✓	✓
60°	E010		TETRAMCUT Standard tool with 4 corners for threading on Swiss lathes. In small diameter threading it is less likely that interference will occur with the center on general NC lathes.	E004 -, E008		✓	✓
55°	E015						
M	(Metric) E017		DUOJUST Standard tool suitable for all types of threading on Swiss lathes. The incomplete thread part from the workpiece face to the thread groove can be the shortest thanks to the excellent accessibility to the workpiece face.	E004 -, E009		✓	
UN	(Unified) E021						
W	(Whitworth) E023						
BSPT	(R, PT) E024		J-SERIES Tool series with 3-cornered inserts. Subselection for threading on Swiss lathes. Standard tool also suitable for radial Swiss lathes.	E004, E013 E016, E048		✓	✓
NPT	E025						
NPTF	E026		TUNGT-CLAMP Tool with high clamp rigidity that firmly holds the insert. Grooving insert and threading insert can be used with the same toolholder.	E004 -, E014 E064 -, E069		✓	
TR	(Metric, 30° Trapezoidal) E027						
Round	(DIN405) E027		On edge insert, toolholder ACME and STUB ACME inserts can be used for the range of 16 to 3TPI with 2 types of toolholders. The special full-profile insert realizes both the fine adjustment of thread height and the minimum burr on the crest.	E004 -, E029 - E052, E066		✓	✓
UNJ	E028						
MJ	E028						
ACME	(29° Trapezoidal) E029		Chaser Threading tool with multiple cutting edges for highly efficient machining of API-standard round, buttress, and NPT.	E005 -, E026 E031 -, E053 E067		✓	✓
STUB ACME	(29° Trapezoidal) E030						
API Round	E030		BOREMEISTER Boring heads for deep hole threading. All 16-size inserts of TungThread Internal series are applicable, allowing for a large variety of threads type.	E056 -		✓	✓
API Buttress	E032						
API Rotary Shoulder Connection	E035		TINYMTURN Internal threading tool suitable for a minimum machining diameter ø4. All tools have oil holes that can supply coolant to the cutting edge.	E060 -, E069			✓
			Other tool TT type	E004 -, E014 E016, E053, E067		✓	✓

Applicable tool for each external thread type

Applicable tool for each external thread type			General purpose, Machine parts for machine and automotive parts				For valve and pump parts; pneumatic, hydraulic, oil and gas pipes		
Thread types			60°	55°	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	Full profile								
	With	Without							
ST type 	○		—	—	0.5 ~ 6 mm E017	32 ~ 5TPI E021	28 ~ 5TPI E023	28 ~ 5TPI E023	28 ~ 11TPI E024
	○		0.5 ~ 6 mm E010	0.5 ~ 5 mm E015	—	—	—	—	—
TETRAMCUT 	○		—	—	0.5 ~ 1.5 mm E020	—	—	—	—
	○		0.4 ~ 3 mm E012	—	—	—	—	—	—
DUOJCUT 	○		0.2 ~ 1.5 mm E012	—	—	—	—	—	—
	○		—	—	—	—	—	—	—
J-SERIES 	○		0.5 ~ 1 mm E013	0.5 ~ 1 mm E016	—	—	—	—	—
	○		—	—	—	—	—	—	—
TUNG-CLAMP 	○		1.27 ~ 4.23 mm E014	—	—	—	—	—	—
	○		—	—	—	—	—	—	—
TT type 	○		~ 3 mm ~ 8TPI E014	~ 3 mm ~ 8TPI E016	—	—	—	—	—

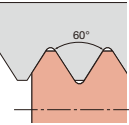
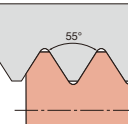
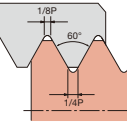
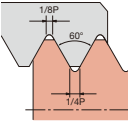
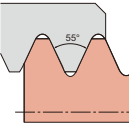
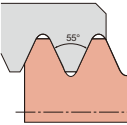
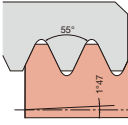
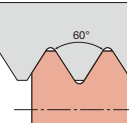
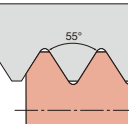
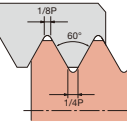
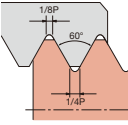
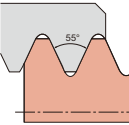
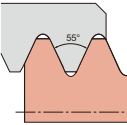
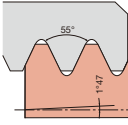
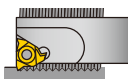
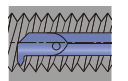
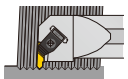
Please see page **E***** for the product details.

Applicable tool for each external thread type			For valve and pump parts; pneumatic, hydraulic, oil and gas pipes		Machine parts		Aerospace threads
Thread types			National pipe taper thread	National pipe taper fuel 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	Full profile						
	With	Without					
ST type 			27 ~ 8TPI E025	27 ~ 8TPI E026	1.5 ~ 6 mm (0.059" - 0.236") E027	8TPI, 6TPI E027	32 ~ 8TPI E028
Chaser 			11.5TPI, 8TPI E026	—	—	—	—

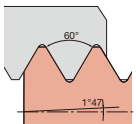
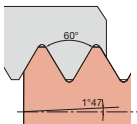
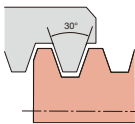
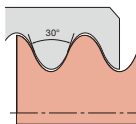
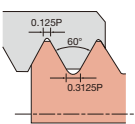
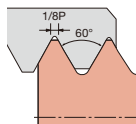
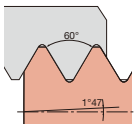
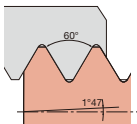
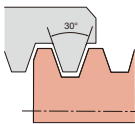
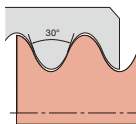
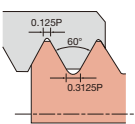
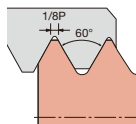
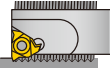
Applicable tool for each external thread type			Oil and gas fields and OCTG drill pipes						Machine parts, Pipe		
Thread types			- API round - API casing - Short casing - API tubing	API buttress casing	- API rotary shoulder connection for drill pipe and collar connections					- ACME - 29° trapezoidal 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	Full profile										
	With	Without									
ST type  E036	○		10TPI, 8TPI E030	5TPI (0.75TPF) E032	—	—	—	—	—	12 ~ 5TPI E029	—
Chaser  E053	○		10TPI, 8TPI E031	5TPI (0.75TPF) E033	—	—	—	—	—	—	—
Other  E051	○		10TPI, 8TPI E031	5TPI (0.75TPF) 5TPI (1TPF) E032	4TPI (2TPF) 4TPI (3TPF) 5TPI (3TPF) E035				16 ~ 3TPI E029	16 ~ 3TPI E030	

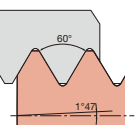
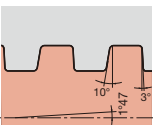
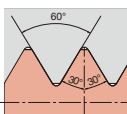
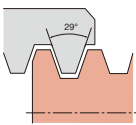
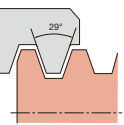
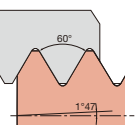
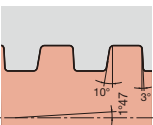
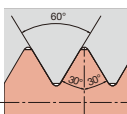
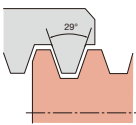
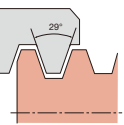
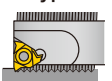
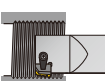
Please see page E*** for the product details.

Applicable tool for each internal thread type

Applicable tool for each external thread type			General purpose, Machine parts for machine and automotive parts				For valve and pump parts; pneumatic, hydraulic, oil and gas pipes		
Thread types			60°	55°	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	Full profile								
	With	Without							
ST type  E054			—	—	0.5 ~ 6 mm E017	32 ~ 5TPI E021	28 ~ 5TPI E023	28 ~ 5TPI E023	19 ~ 11TPI E024
			0.5 ~ 6 mm (0.020" - 0.250") 48 ~ 4TPI E010	0.020" - 0.200" 48 ~ 5TPI E015	—	—	—	—	—
TINYTURN  E060			0.5 ~ 1.5 mm (0.021" - 0.0625") 48 ~ 16TPI E060	—	—	—	—	—	—
TUNG-CLAMP  E064			1.27 ~ 4.23 mm 12 ~ 5TPI E014	—	—	—	—	—	—
TT type  E066			~ 3 mm (~ 0.125") ~ 8TPI E014	~ 0.125" ~ 8TPI E016	—	—	—	—	—

Please see page **E***** for the product details.

Applicable tool for each external thread type			For valve and pump parts; pneumatic, hydraulic, oil and gas pipes		Machine parts		Aerospace threads	
Thread types			National pipe taper thread	National pipe taper fuel 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	Full profile							
	With	Without						
ST type  E054	○		27 ~ 8TPI E025	14 ~ 8TPI E026	1.5 ~ 5 mm (0.059" - 0.197") E027	6TPI E027	0.039" E028	—
Chaser  E066	○		11.5TPI, 8TPI E026	—	—	—	—	—

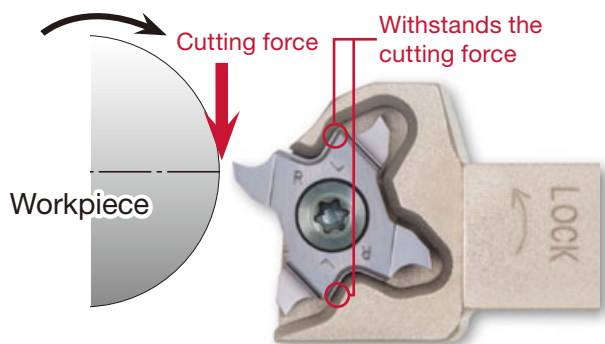
Applicable tool for each external thread type			Oil and gas fields and OCTG drill pipes							Machine parts, Pipe	
Thread types			- API round - API casing - API tubing - Short casing	API buttress casing	- API rotary shoulder connection for drill pipe and collar connections					ACME 29° trapezoidal thread	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	Full profile										
	With	Without									
ST type  E054	☐		10TPI, 8TPI E030	5TPI (0.75TPF) E032	—	—	—	—	—	12 ~ 5TPI E029	—
Chaser  E066	☐		10TPI, 8TPI E031	5TPI (0.75TPF) E033	—	—	—	—	—	—	—
Other  E065	☐		10TPI, 8TPI E031	5TPI (0.75TPF) 5TPI (1TPF) E032	4TPI (2TPF) 4TPI (3TPF) 5TPI (3TPF) E035				—	—	

Please see page E*** for the product details.



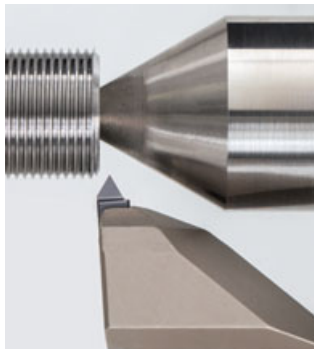
Unique clamping system

The unique pocket design provides accurate indexing repeatability of the cutting edge height.



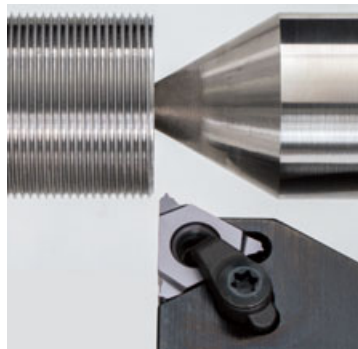
No tool interference with the lathe center when machining small parts

TETRAMCUT M16x1



Insert: TCT18R-60N-020

Conventional M24x1



Insert: 16ER10ISO



Unique highly rigid clamping system

The unused cutting edge is always protected due to the innovative clamping system. Even if the first cutting edge is chipped, the other unused cutting edge can be used because the insert is clamped in the center.

Insert is secured at 3 points



Excellent accessibility to the workpiece face

Utilizing various tools minimizes the incomplete thread part.



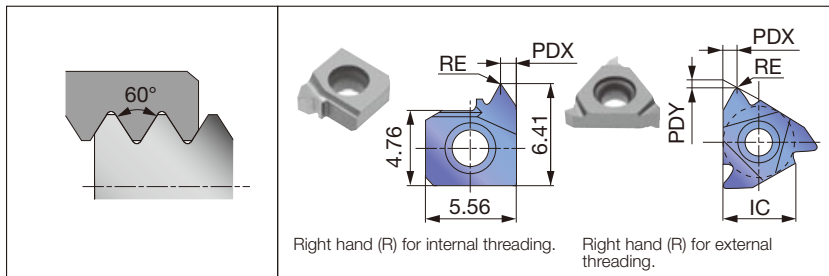
	Type A	Type B	Type N
Right hand			
Left hand			



Insert designation	Cutting edge geometry (mm)	PDX mm (in)	Pitch: mm (in)										
			0.2 (0.008)	0.25 (0.010)	0.35 (0.014)	0.4 (0.016)	0.5 (0.020)	0.6 (0.024)	0.8 (0.031)	1 (0.039)	1.25 (0.049)	1.5 (0.059)	
JXTG12FR-60A-000	0.05 (flat)	0.25 (0.010)	Applicable area										
JXTG12FL-60A-000													
JXTG12FR-60B-000	0.05 (flat)	2.25 (0.089)	Applicable area										
JXTG12FL-60B-000													
JXTG12FR-60A-005	R0.05	0.6 (0.024)	Applicable area										
JXTG12FL-60A-005													
JXTG12FR-60B-005	R0.05	1.9 (0.075)	Applicable area										
JXTG12FL-60B-005													
JXTG12FR-60N-010	R0.1	1.25 (0.049)	Applicable area										
JXTG12FL-60N-010													
			127	72	52	32							
			Threads per inch (TPI)										

Reference pages: Inserts → **E012**, External toolholders → **E047 - E048**,
Standard cutting conditions → **E068**

60° 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...
27	CER/L**27...	CNR/L**27...

Partial-profile insert

Insert size	Pitch (Reference) (mm)	TPI	Hand of cut	External insert (in)								Internal insert (in)											
				Designation	Grade				IC	PDX	PDY	RE	Designation	Grade					IC	PDX	PDY	RE	
					AH8015	AH725	T313V	Uncoated						TH10	AH8015	AH725	GH330	T313V					Uncoated
6	0.5 - 1.5	48 - 16	R									6IRA60	●	●		●	-	0.035	-	0.0016			
06	0.5 - 1.25	48 - 20	R									06IRA60			●**		0.157	0.024	0.024	0.0020			
08	0.5 - 1.5	48 - 16	R									08IRA60		●**			0.197	0.028	0.024	0.0020			
11	0.5 - 1.5	48 - 16	R	11ERA60		●			0.250	0.035	0.031	0.0024	11IRA60	●	●		●	0.250	0.035	0.028	0.0016		
11	0.5 - 1.5	48 - 16	L									11ILA60		●		●	●	0.250	0.035	0.028	0.0016		
16	0.5 - 1.5	48 - 16	R	16ERA60	●	●	●	●	0.375	0.035	0.028	0.0024	16IRA60	●	●		●	●	0.375	0.035	0.028	0.0016	
16	0.5 - 1.5	48 - 16	L	16ELA60		●	●	●	0.375	0.035	0.028	0.0024	16ILA60		●		●	●	0.375	0.035	0.028	0.0016	
16	0.5 - 3	48 - 8	R	16ERAG60	●	●	●		0.375	0.063	0.047	0.0024	16IRAG60	●	●		●		0.375	0.063	0.047	0.0016	
16	1.75 - 3	14 - 8	R	16ERG60	●	●	●	●	0.375	0.063	0.047	0.009	16IRG60	●	●		●	●	0.375	0.063	0.047	0.005	
16	1.75 - 3	14 - 8	L	16ELG60		●	●		0.375	0.063	0.047	0.009	16ILG60		●		●	●	0.375	0.063	0.047	0.005	
22	3.5 - 5	7 - 5	R	22ERN60	●	●	●	●	0.500	0.098	0.067	0.017	22IRN60	●	●		●	●	0.500	0.098	0.067	0.010	
22	3.5 - 5	7 - 5	L	22ELN60		●	●		0.500	0.098	0.067	0.017	22ILN60		●		●		0.500	0.098	0.067	0.010	
27	4 - 6	6 - 4	R	27ERZ60		●	●		0.625	0.126	0.087	0.020	27IRZ60		●		●		0.625	0.126	0.087	0.011	

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

● : Line up / 5 pieces per package

Partial-profile insert

Insert size	Pitch (mm)	TPI	Hand of cut	External insert (in)						
				Designation	Grade	IC	PDX	PDY	RE	
					CBN					
					BX330					
16	1 - 2	20 - 13	R	1QP-16ER60-014-SP	●	0.375	0.037	0.028	0.006	
16	1.5 - 3	16 - 8	R	1QP-16ER60-020-SP	●	0.375	0.061	0.047	0.008	

● : Line up / 1 piece per package

Reference pages: External toolholders → **E036 - E040**
Internal toolholders → **E054 - E056**

Partial-profile insert with chipbreaker

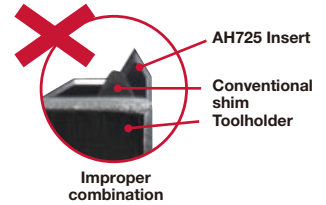
Insert size	Pitch (Reference) (mm)	TPI	Hand of cut	External insert (in)								Internal insert (in)											
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE				
					Coated	Cermet	AH8015						AH725	NS9530	Coated					Cermet	AH8015	AH725	NS9530
11	0.5 - 1.5	48 - 16	R									11IRA60-B	●			0.250	0.035	0.028	0.0016				
11	0.5 - 1.5	48 - 16	R									11IRA60-M	●		●	0.250	0.035	0.028	0.0016				
16	0.5 - 1.5	48 - 16	R	16ERA60-B		●*		0.375	0.035	0.031	0.0020	16IRA60-B		●*		0.375	0.035	0.031	0.0020				
16	0.5 - 1.5	48 - 16	R	16ERA60-M	●		●	0.375	0.035	0.028	0.0024	16IRA60-M	●		●	0.375	0.035	0.028	0.0016				
16	0.5 - 3	48 - 8	R	16ERAG60-B		●*		0.375	0.067	0.047	0.0031	16IRAG60-B		●*		0.375	0.067	0.047	0.0020				
16	0.5 - 3	48 - 8	R	16ERAG60-M	●	●	●	0.375	0.063	0.047	0.0024	16IRAG60-M	●	●	●	0.375	0.063	0.047	0.0016				
16	1.75 - 3	14 - 8	R	16ERG60-B		●*		0.375	0.067	0.047	0.010	16IRG60-B		●*		0.375	0.067	0.047	0.004				
16	1.75 - 3	14 - 8	R	16ERG60-M	●		●	0.375	0.063	0.047	0.009	16IRG60-M	●		●	0.375	0.063	0.047	0.006				
22	3.5 - 5	7 - 5	R	22ERN60-B		●		0.500	0.098	0.067	0.013	22IRN60-B		●		0.500	0.098	0.067	0.007				

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

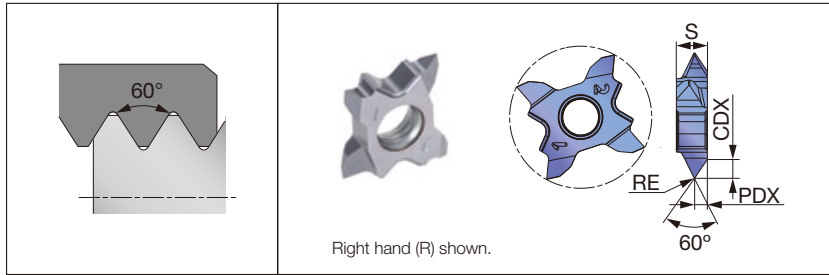
● requires the use of dedicated shim.

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 [E070](#).

● : Line up / 5 pieces per package



60° thread angle (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

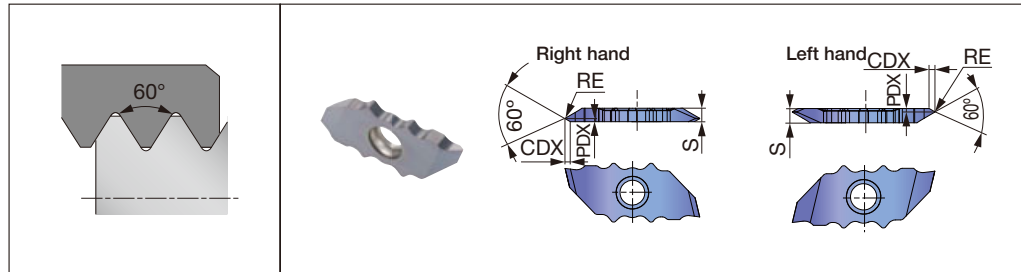
Pitch (mm)	TPI	Hand of cut	External insert (in)						
			Designation	Grade		PDX	CDX	RE	S
				Coated					
				SH725	AH725				
0.4 - 1	25 - 64	R	TCT18FR-60A-005	●		0.024	0.039	0.0020	0.157
1 - 2	25 - 12	R	TCT18FR-60A-010	●		0.039	0.064	0.004	0.157
0.8 - 3	8 - 32	R/L	TCT18R/L-60N-010		●	0.063	0.105	0.004	0.157
1.5 - 3	8 - 16	R/L	TCT18R/L-60N-020		●	0.063	0.101	0.008	0.157

● : Line up / 5 pieces per package

DUOJUST

INSERT

60° thread angle (General purpose)



Applicable toolholder

External

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

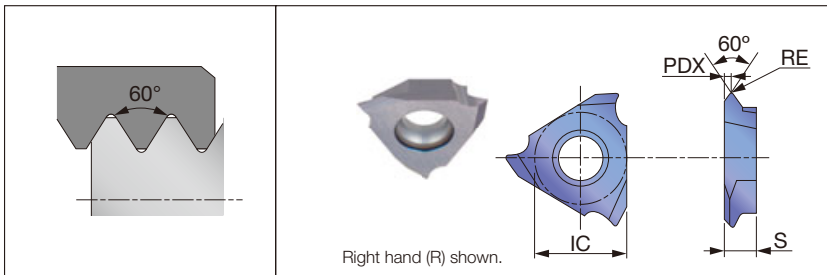
Partial-profile insert

Insert size	Pitch (mm)	TPI	Hand of cut	External insert (in)						
				Designation	Grade		PDX	CDX	RE	S
					Coated					
					SH725					
					R	L				
12	0.2 - 0.4	64 - 127	R/L	JXTG12FR/L-60A-000	●	●	0.010	0.016	0.0020 max flat	0.098
12	0.2 - 0.4	64 - 127	R/L	JXTG12FR/L-60B-000	●	●	0.089	0.016	0.0020 max flat	0.098
12	0.4 - 1	25 - 64	R/L	JXTG12FR/L-60A-005	●	●	0.024	0.039	0.0020	0.098
12	0.4 - 1	25 - 64	R/L	JXTG12FR/L-60B-005	●	●	0.075	0.039	0.0020	0.098
12	1 - 1.5	16 - 25	R/L	JXTG12FR/L-60N-010	●	●	0.049	0.081	0.004	0.098

● : Line up / 5 pieces per package

	Type A	Type B	Type N
Right hand			
Left hand			

60° thread angle (General purpose)



Applicable toolholder

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

Partial-profile insert

Pitch (mm)	TPI	Hand of cut	External insert (in)												
			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	JTTR3005F	●	●	●		●		●		0.375	0.024	0.125	0.0020
0.5 - 1	25 - 48	R/L	JTTL3010F	●	●	●		●		●		0.375	0.043	0.125	0.004

● : Line up / 10 pieces per package

60° thread angle (General purpose)



Applicable toolholder

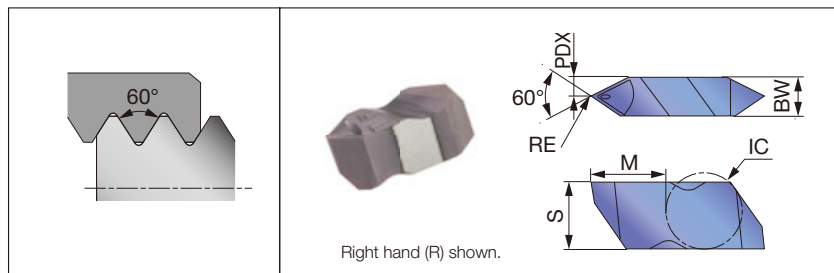
External
JSXBR**K8
JSXBR**K8-C

Partial-profile insert

Pitch (mm)	TPI	Hand of cut	Designation	External insert (in)				
				Grade		IC	S	RE
				Coated	Uncoated			
				J740	TH10			
0.5 - 1	25 - 48	R	JXT1R6000F	●	●	0.315	0.156	0.0012
0.5 - 1	25 - 48	R	JXT2R6000F	●	●	0.315	0.156	0.0012

● : Line up / 10 pieces per package

60° thread angle (General purpose)



Applicable toolholder

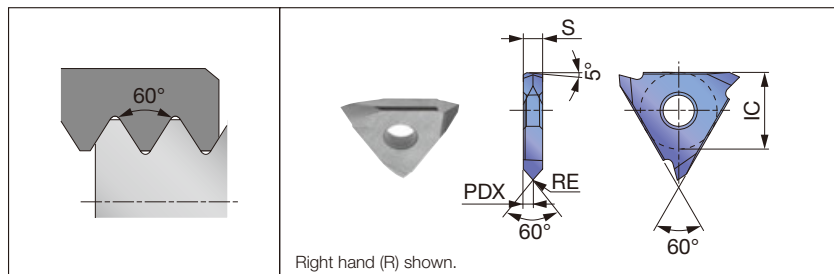
External	Internal
FLASR/L-1616M3	A**M-FLER/L3
FLSR/L-**M3	HS**-FLER3W

Partial-profile insert for external and internal threads

TPI	Hand of cut	External Pitch (mm)	Internal Pitch (mm)	Designation	Grade	IC (in)	PDX (in)	BW (in)	RE (in)	S (in)	M (in)
					Coated						
					AH725						
6 - 20	R/L	1.27 - 4.23	2.11 - 5.08	FLT-3R/L-HCB	●	0.375	0.098	0.195	0.007	0.344	0.400
11 - 20	R/L	2.31 - 4.23	3.175 - 5.08	FLT-3R/LC-HCB	●	0.375	0.098	0.195	0.014	0.344	0.400
6 - 20	R/L	1.27 - 4.23	2.11 - 5.08	FLT-3R/L-CB	●	0.375	0.098	0.195	0.007	0.344	0.400

● : Line up / 10 pieces per package

TT type / 60° thread angle (General purpose)



Applicable toolholder

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

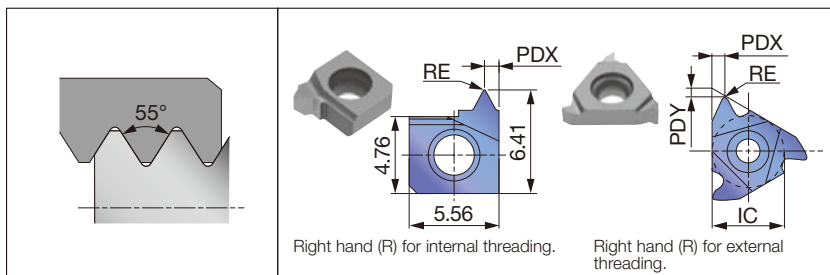
Partial-profile insert for external and internal threads

Pitch (mm)	TPI	Hand of cut	Designation	Grade		IC (in)	PDX (in)	S (in)	RE (in)
				Cermet	Uncoated				
				NS9530	TH10				
≤ 3	≥ 8	R	TTR42M-005	●	●	0.500	0.063	0.126	0.0020
≤ 3	≥ 8	L	TTL42M-005	●	●	0.500	0.063	0.126	0.0020

● : Line up / 5 pieces per package

Reference pages: TungT-Clamp : External toolholders → **E050**,
Internal toolholders → **E064 - E065**
TT type : External toolholders → **E053**
Internal toolholders → **E067**

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) (in)	TPI	Hand of cut	External insert (in)								Internal insert (in)												
				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	0.020 - 0.059	48 - 16	R									6IRA55	●			●	-	0.035	-	0.0028				
06	0.020 - 0.049	48 - 20	R									06IRA55			●**			0.157	0.020	0.020	0.0031			
08	0.020 - 0.059	48 - 16	R									08IRA55		●**				0.197	0.028	0.024	0.0031			
11	0.020 - 0.059	48 - 16	R	11ERA55	●				0.250	0.035	0.031	0.0020	11IRA55	●	●		●	●	0.250	0.035	0.028	0.0028		
16	0.020 - 0.059	48 - 16	R	16ERA55	●	●	●		0.375	0.035	0.028	0.0028	16IRA55	●		●	●	●	0.375	0.035	0.028	0.0028		
16	0.020 - 0.118	48 - 8	R	16ERAG55	●				0.375	0.067	0.047	0.0028	16IRAG55	●					0.375	0.067	0.047	0.0028		
16	0.069 - 0.118	14 - 8	R	16ERG55	●	●	●	●	0.375	0.063	0.047	0.010	16IRG55	●	●		●	●	0.375	0.067	0.047	0.010		
22	0.138 - 0.197	7 - 5	R	22ERN55	●	●	●		0.500	0.098	0.067	0.020	22IRN55	●		●	●	●	0.500	0.098	0.067	0.020		

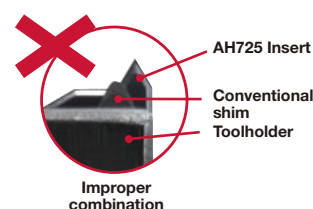
● : Line up / 5 pieces per package

Partial-profile insert with chipbreaker

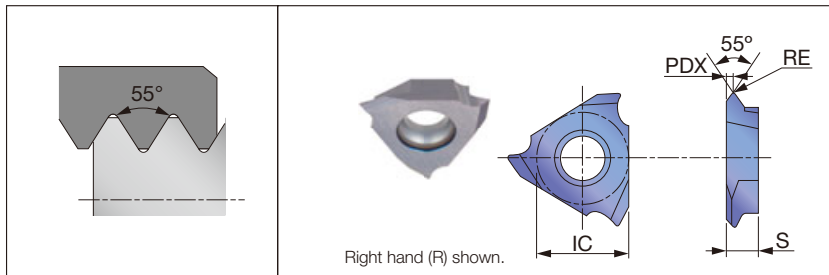
Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)						Internal insert (in)					
				Designation	Grade	IC	PDX	PDY	RE	Designation	Grade	IC	PDX	PDY	RE
					Coated						Coated				
					AH725						AH725				
16	0.020 - 0.118	48 - 16	R	16ERAG55-B	●*	0.375	0.067	0.047	0.0028	16IRAG55-B	●*	0.375	0.067	0.047	0.0020
16	0.069 - 0.118	14 - 8	R	16ERG55-B	●*	0.375	0.067	0.047	0.009	16IRG55-B	●*	0.375	0.067	0.047	0.008

● : Line up / 5 pieces per package

- * : 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 **E070**.



55° thread angle (General purpose)



Applicable toolholder

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

Partial-profile insert

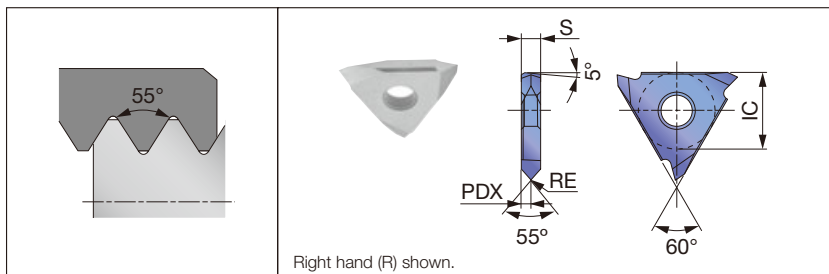
Pitch (in)	TPI	Hand of cut	External insert (in)								
			Designation	Grade				IC	PDX	S	RE
				Coated							
				SH725		J740					
R	L	R	L								
0.020 - 0.039	25 - 48	R/L	JTTR/L3005F-55	●		●		0.375	0.024	0.125	0.0020

● : Line up / 5 pieces per package

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 (mm)	TPI	Hand of cut	Designation	Grade		IC (in)	PDX (in)	S (in)	RE (in)
				Cermet	Uncoated				
				NS9530	TH10				
≤ 3	≥ 8	R	TTR42W-005	●	●	0.500	0.063	0.126	0.0020
≤ 3	≥ 8	L	TTL42W-005	●	●	0.500	0.063	0.126	0.0020

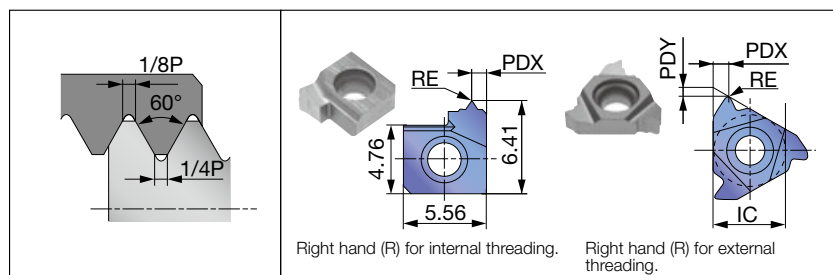
● : Line up / 5 pieces per package

Reference pages: J-Series: External toolholders → **E048 - E049**

TT type: External toolholders → **E053**

Internal toolholders → **E067**

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...

Full-profile insert

Insert size	Pitch (Reference) (mm)	Hand of cut	External insert (in)								Internal insert (in)									
			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	●		●	-	0.020	-	0.0020		
6	1	R									6IR10ISO	●	●		●	-	0.035	-	0.0028	
6	1.25	R									6IR125ISO	●	●		●	-	0.035	-	0.0035	
6	1.5	R									6IR15ISO	●	●		●	-	0.035	-	0.004	
6	1.75	R									6IR175ISO	●	●		●	-	0.035	-	0.005	
6	2	R									6IR20ISO	●	●		●	-	0.035	-	0.006	
06	0.5	R									06IR05ISO		●**			0.157	0.016	0.024	0.0016	
06	0.75	R									06IR075ISO		●**			0.157	0.020	0.024	0.0024	
06	1	R									06IR10ISO		●**			0.157	0.024	0.024	0.0020	
06	1.25	R									06IR125ISO		●**			0.157	0.024	0.024	0.0028	
08	1	R									08IR10ISO		●**			0.197	0.024	0.024	0.0028	
08	1.25	R									08IR125ISO		●**			0.197	0.028	0.028	0.0035	
08	1.5	R									08IR15ISO		●**			0.197	0.028	0.028	0.004	
08	1.75	R									08IR175ISO		●**			0.197	0.031	0.024	0.006	
11	0.35	R	11ER035ISO		●			0.250	0.016	0.024	0.0016									
11	0.5	R	11ER05ISO		●			0.250	0.024	0.024	0.0028	11IR05ISO		●		●	0.250	0.020	0.047	0.0016
11	0.7	R	11ER07ISO		●			0.250	0.024	0.024	0.004									
11	0.75	R	11ER075ISO		●			0.250	0.024	0.024	0.004	11IR075ISO	●	●			0.250	0.020	0.047	0.0020
11	0.8	R	11ER080ISO		●			0.250	0.024	0.024	0.005									
11	1	R	11ER10ISO		●			0.250	0.028	0.028	0.006	11IR10ISO	●	●	●	●	0.250	0.035	0.028	0.0028
11	1	L									11IL10ISO	●	●			0.250	0.035	0.028	0.0028	
11	1.25	R	11ER125ISO		●			0.250	0.035	0.031	0.006	11IR125ISO		●			0.250	0.035	0.028	0.0035
11	1.25	L									11IL125ISO		●			0.250	0.035	0.028	0.0035	
11	1.5	R	11ER15ISO		●			0.250	0.031	0.039	0.007	11IR15ISO	●	●	●	●	0.250	0.035	0.028	0.004
11	1.5	L									11IL15ISO	●	●			0.250	0.035	0.028	0.004	
11	1.75	R									11IR175ISO		●	●		0.250	0.035	0.028	0.005	
11	1.75	L									11IL175ISO		●			0.250	0.035	0.028	0.005	
11	2	R									11IR20ISO	●	●	●		0.250	0.035	0.028	0.006	
11	2	L									11IL20ISO	●	●			0.250	0.035	0.028	0.006	

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

● : Line up / 5 pieces per package

Reference pages: External toolholders → **E036 - E040**
Internal toolholders → **E054 - E056**

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

Insert size	Pitch (Reference) (mm)	Hand of cut	External insert (in)								Internal insert (in)									
			Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE
				Coated			Uncoated						Coated			Uncoated				
				AH8015	AH725	T313V							TH10	AH8015	AH725					
16	0.5	R	16ER05ISO	●	●		●	0.375	0.020	0.047	0.0024	16IR05ISO		●			0.375	0.020	0.047	0.0016
16	0.75	R	16ER075ISO	●	●	●	●	0.375	0.020	0.047	0.0035	16IR075ISO		●			0.375	0.020	0.047	0.0020
16	1	R	16ER10ISO	●	●	●	●	0.375	0.035	0.028	0.005	16IR10ISO	●	●	●	●	0.375	0.035	0.028	0.0028
16	1	L						0.000	0.000	0.000	0.000	16IL10ISO	●	●			0.375	0.035	0.028	0.0028
16	1.25	R	16ER125ISO	●	●	●		0.375	0.035	0.028	0.006	16IR125ISO		●			0.375	0.035	0.028	0.0035
16	1.25	L						0.000	0.000	0.000	0.000	16IL125ISO		●			0.375	0.035	0.028	0.0035
16	1.5	R	16ER15ISO	●	●	●	●	0.375	0.035	0.028	0.007	16IR15ISO	●	●	●	●	0.375	0.035	0.028	0.004
16	1.5	L	16EL15ISO	●				0.375	0.035	0.028	0.007	16IL15ISO	●	●			0.375	0.035	0.028	0.004
16	1.75	R	16ER175ISO	●	●	●		0.375	0.063	0.047	0.009	16IR175ISO		●	●		0.375	0.063	0.047	0.005
16	2	R	16ER20ISO	●	●	●	●	0.375	0.063	0.047	0.010	16IR20ISO	●	●	●	●	0.375	0.063	0.047	0.006
16	2	L	16EL20ISO	●	●			0.375	0.063	0.047	0.010	16IL20ISO		●			0.375	0.063	0.047	0.006
16	2.5	R	16ER25ISO	●	●	●	●	0.375	0.063	0.047	0.012	16IR25ISO	●	●	●	●	0.375	0.063	0.047	0.007
16	3	R	16ER30ISO	●	●	●	●	0.375	0.063	0.047	0.015	16IR30ISO	●	●	●	●	0.375	0.063	0.047	0.008
16	3	L						0.000	0.000	0.000	0.000	16IL30ISO		●			0.375	0.063	0.047	0.008
22	3.5	R	22ER35ISO	●	●	●		0.500	0.098	0.067	0.017	22IR35ISO	●	●	●		0.500	0.098	0.067	0.010
22	4	R	22ER40ISO	●	●	●		0.500	0.098	0.067	0.020	22IR40ISO	●	●	●		0.500	0.098	0.067	0.011
22	4.5	R	22ER45ISO	●	●			0.500	0.098	0.067	0.022	22IR45ISO	●	●			0.500	0.098	0.067	0.013
22	5	R	22ER50ISO		●	●		0.500	0.098	0.067	0.025	22IR50ISO		●	●		0.500	0.098	0.067	0.014
27	6	R	27ER60ISO		●	●		0.625	0.126	0.087	0.030	27IR60ISO		●	●		0.625	0.126	0.087	0.017

● : Line up / 5 pieces per package

Full-profile insert with chipbreaker

Insert size	Pitch (Reference) (mm)	Hand of cut	External insert (in)								Internal insert (in)							
			Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
				Coated		Cermet						Coated		Cermet				
				AH8015	AH725							NS9530	AH8015					
11	0.5	R									11IR05ISO-B	●		0.250	0.020	0.047	0.0016	
11	0.5	R									11IR05ISO-M		●	0.250	0.020	0.047	0.0016	
11	0.75	R									11IR075ISO-B	●		0.250	0.020	0.047	0.0020	
11	0.75	R									11IR075ISO-M		●	0.250	0.020	0.047	0.0020	
11	1	R									11IR10ISO-B	●		0.250	0.035	0.028	0.0031	
11	1	R									11IR10ISO-M	●		●	0.250	0.035	0.028	0.0031
11	1.25	R									11IR125ISO-B	●		0.250	0.035	0.028	0.004	
11	1.25	R									11IR125ISO-M	●		●	0.250	0.035	0.028	0.004
11	1.5	R									11IR15ISO-B	●		0.250	0.035	0.028	0.005	
11	1.5	R									11IR15ISO-M	●		●	0.250	0.035	0.028	0.005
11	1.75	R									11IR175ISO-B	●		0.250	0.035	0.028	0.005	
11	1.75	R									11IR175ISO-M		●	0.250	0.035	0.028	0.005	
11	2	R									11IR20ISO-B	●		0.250	0.035	0.028	0.006	
11	2	R									11IR20ISO-M	●		●	0.250	0.035	0.028	0.006
16	0.5	R	16ER05ISO-M		●	0.375	0.020	0.047	0.0024									
16	0.75	R	16ER075ISO-B		●*	0.375	0.024	0.024	0.0031									
16	0.75	R	16ER075ISO-M	●		●	0.375	0.020	0.047	0.0035								
16	1	R	16ER10ISO-B		●*	0.375	0.028	0.028	0.004	16IR10ISO-B		●*	0.375	0.028	0.024	0.0020		
16	1	R	16ER10ISO-M	●	●	●	0.375	0.035	0.028	0.005	16IR10ISO-M	●		●	0.375	0.035	0.028	0.0031
16	1.25	R	16ER125ISO-B		●*	0.375	0.035	0.031	0.006	16IR125ISO-B		●*	0.375	0.035	0.031	0.0024		
16	1.25	R	16ER125ISO-M	●		●	0.375	0.035	0.028	0.006	16IR125ISO-M		●	0.375	0.035	0.028	0.004	
16	1.5	R	16ER15ISO-B		●*	0.375	0.039	0.031	0.007	16IR15ISO-B		●*	0.375	0.039	0.031	0.0031		
16	1.5	R	16ER15ISO-M	●	●	●	0.375	0.035	0.028	0.007	16IR15ISO-M	●	●	●	0.375	0.035	0.028	0.005
16	1.75	R	16ER175ISO-B		●*	0.375	0.047	0.035	0.010	16IR175ISO-B		●*	0.375	0.047	0.035	0.004		
16	1.75	R	16ER175ISO-M	●		●	0.375	0.063	0.047	0.009	16IR175ISO-M		●	0.375	0.063	0.047	0.006	
16	2	R	16ER20ISO-B		●*	0.375	0.051	0.039	0.011	16IR20ISO-B		●*	0.375	0.051	0.039	0.004		
16	2	R	16ER20ISO-M	●	●	●	0.375	0.063	0.047	0.010	16IR20ISO-M	●		●	0.375	0.063	0.047	0.006
16	2.5	R	16ER25ISO-B		●*	0.375	0.059	0.043	0.012	16IR25ISO-B		●*	0.375	0.059	0.043	0.006		
16	2.5	R	16ER25ISO-M	●		●	0.375	0.063	0.047	0.012	16IR25ISO-M		●	0.375	0.063	0.047	0.007	
16	3	R	16ER30ISO-B		●*	0.375	0.063	0.047	0.015	16IR30ISO-B		●*	0.375	0.059	0.043	0.009		
16	3	R	16ER30ISO-M	●		●	0.375	0.063	0.047	0.015	16IR30ISO-M	●		●	0.375	0.063	0.047	0.008
22	3.5	R	22ER35ISO-B		●	0.500	0.091	0.063	0.019									
22	4	R	22ER40ISO-B		●	0.500	0.091	0.063	0.020									

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

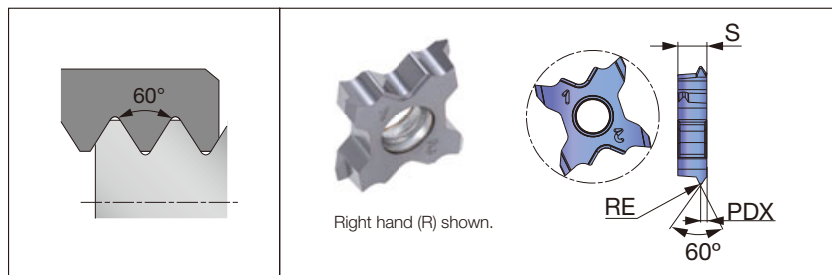
- requires the use of dedicated shim.

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 [E070](#).

● : Line up / 5 pieces per package



ISO metric (General purpose)



Applicable toolholder

External

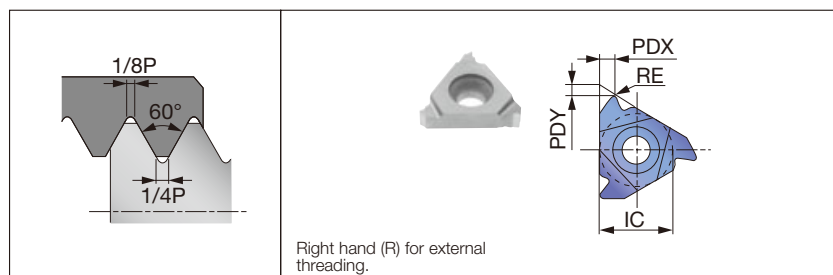
STCR/L**-18
STCR/L**18-CHP
JS**-STCL18
C*STCFL**18-CHP
C*STCR/L**18-CHP
QC**STCR/L18 (-Y)
QC**STCR/L18 (-Y)-CHP

Partial-profile insert

Pitch (mm)	Hand of cut	External insert (in)					
		Designation	Grade		PDX	RE	S
			Coated				
			SH725	AH725			
0.5	R	TCT18FR-05ISO	●		0.014	0.0024	0.157
0.7	R	TCT18FR-07ISO	●		0.018	0.0035	0.157
0.75	R	TCT18FR-075ISO	●		0.020	0.0035	0.157
0.8	R	TCT18FR-08ISO	●		0.020	0.004	0.157
1	R	TCT18R-10ISO		●	0.024	0.005	0.157
1.25	R	TCT18R-125ISO		●	0.028	0.007	0.157
1.5	R	TCT18R-15ISO		●	0.031	0.008	0.157

● : Line up / 5 pieces per package

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) (in)	TPI	Hand of cut	External insert (in)								Internal insert (in)							
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					AH8015	AH725	T313V						Coated						
													AH8015	AH725	T313V				
11	(0.031)	32	R									11IR32UN	●			0.250	0.020	0.047	0.0024
11	(0.036)	28	R									11IR28UN	●			0.250	0.020	0.047	0.0024
11	(0.042)	24	R									11IR24UN	●			0.250	0.035	0.028	0.0028
11	(0.050)	20	R									11IR20UN	●			0.250	0.035	0.028	0.0035
11	(0.056)	18	R									11IR18UN	●			0.250	0.035	0.028	0.004
11	(0.063)	16	R									11IR16UN	●	●		0.250	0.035	0.028	0.004
11	(0.071)	14	R									11IR14UN	●			0.250	0.035	0.028	0.005
16	(0.031)	32	R	16ER32UN	●	●		0.375	0.020	0.047	0.004	16IR32UN	●			0.375	0.020	0.047	0.0024
16	(0.036)	28	R	16ER28UN	●	●		0.375	0.020	0.047	0.004	16IR28UN	●			0.375	0.020	0.047	0.0024
16	(0.042)	24	R	16ER24UN	●	●		0.375	0.035	0.028	0.005	16IR24UN	●			0.375	0.035	0.028	0.0028
16	(0.050)	20	R	16ER20UN	●	●		0.375	0.035	0.028	0.006	16IR20UN	●			0.375	0.035	0.028	0.0035
16	(0.056)	18	R	16ER18UN	●	●		0.375	0.035	0.028	0.007	16IR18UN	●			0.375	0.035	0.028	0.004
16	(0.063)	16	R	16ER16UN	●	●	●	0.375	0.035	0.028	0.008	16IR16UN	●	●		0.375	0.035	0.028	0.004
16	(0.071)	14	R	16ER14UN	●	●	●	0.375	0.063	0.047	0.009	16IR14UN	●	●		0.375	0.063	0.047	0.005
16	(0.077)	13	R	16ER13UN		●		0.375	0.063	0.047	0.009	16IR13UN	●			0.375	0.063	0.047	0.006
16	(0.083)	12	R	16ER12UN	●	●	●	0.375	0.063	0.047	0.011	16IR12UN	●	●		0.375	0.063	0.047	0.006
16	(0.091)	11	R	16ER11UN		●		0.375	0.063	0.047	0.011	16IR11UN	●			0.375	0.063	0.047	0.006
16	(0.100)	10	R	16ER10UN	●	●		0.375	0.063	0.047	0.013	16IR10UN	●			0.375	0.063	0.047	0.007
16	(0.111)	9	R	16ER9UN		●		0.375	0.063	0.047	0.014	16IR9UN	●			0.375	0.063	0.047	0.008
16	(0.125)	8	R	16ER8UN	●	●	●	0.375	0.063	0.047	0.016	16IR8UN	●	●		0.375	0.063	0.047	0.009
22	(0.143)	7	R	22ER7UN		●		0.500	0.098	0.067	0.018	22IR7UN	●			0.500	0.098	0.067	0.010
22	(0.167)	6	R	22ER6UN		●		0.500	0.098	0.067	0.021	22IR6UN	●			0.500	0.098	0.067	0.012
22	(0.200)	5	R	22ER5UN		●		0.500	0.098	0.067	0.025	22IR5UN	●			0.500	0.098	0.067	0.014

● : Line up / 5 pieces per package

Full-profile insert with chipbreaker

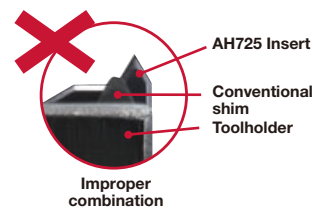
Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)								Internal insert (in)							
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					Coated		Cermet						Coated		Cermet				
					AH8015	AH725							NS9530	AH8015					
16	(0.042)	24	R	16ER24UN-B	●*			0.375	0.031	0.028	0.004								
16	(0.042)	24	R	16ER24UN-M			●	0.375	0.035	0.028	0.005								
16	(0.050)	20	R	16ER20UN-B	●*			0.375	0.035	0.031	0.006	16IR20UN-B	●*			0.375	0.035	0.031	0.0024
16	(0.050)	20	R	16ER20UN-M	●		●	0.375	0.035	0.028	0.006	16IR20UN-M			●	0.375	0.035	0.028	0.0035
16	(0.056)	18	R	16ER18UN-B	●*			0.375	0.039	0.031	0.006	16IR18UN-B	●*			0.375	0.039	0.031	0.0031
16	(0.056)	18	R	16ER18UN-M	●		●	0.375	0.035	0.028	0.007	16IR18UN-M	●		●	0.375	0.035	0.028	0.004
16	(0.063)	16	R	16ER16UN-B	●*			0.375	0.043	0.035	0.007	16IR16UN-B	●*			0.375	0.043	0.035	0.0035
16	(0.063)	16	R	16ER16UN-M	●		●	0.375	0.035	0.028	0.008	16IR16UN-M			●	0.375	0.035	0.028	0.004
16	(0.071)	14	R	16ER14UN-B	●*			0.375	0.047	0.039	0.009	16IR14UN-B	●*			0.375	0.047	0.035	0.004
16	(0.071)	14	R	16ER14UN-M	●		●	0.375	0.063	0.047	0.009	16IR14UN-M			●	0.375	0.063	0.047	0.005
16	(0.077)	13	R	16ER13UN-B	●*			0.375	0.051	0.039	0.009								
16	(0.083)	12	R	16ER12UN-B	●*			0.375	0.055	0.043	0.010	16IR12UN-B	●*			0.375	0.055	0.043	0.005
16	(0.083)	12	R	16ER12UN-M	●		●	0.375	0.063	0.047	0.011	16IR12UN-M	●		●	0.375	0.063	0.047	0.006
16	(0.125)	8	R	16ER8UN-B	●*			0.375	0.063	0.047	0.016	16IR8UN-B	●*			0.375	0.059	0.043	0.008
16	(0.125)	8	R	16ER8UN-M			●	0.375	0.063	0.047	0.016	16IR8UN-M			●	0.375	0.063	0.047	0.009

● : Line up / 5 pieces per package

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

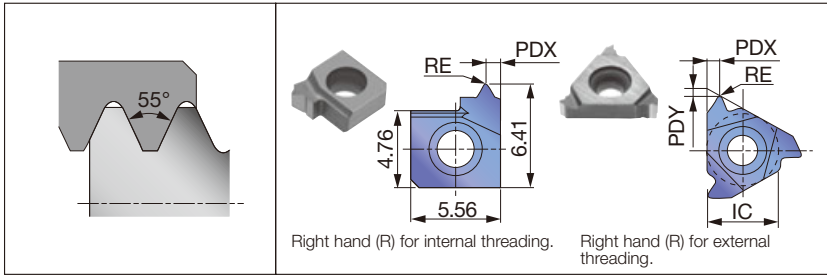
- requires the use of dedicated shim.

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 [E070](#).



Reference pages: External toolholders → [E036 - E040](#), Internal toolholders → [E054 - E056](#)

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) (in)	TPI	Hand of cut	External insert (in)								Internal insert (in)									
				Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE
					Coated			Uncoated						Coated			Uncoated				
					AH8015	AH725	T313V							TH10	AH8015	AH725					
6	(0.053)	19	R									6IR19W	●	●		●	-	0.035	-	0.007	
11	(0.053)	19	R									11IR19W	●	●	●	●	0.250	0.035	0.028	0.007	
11	(0.071)	14	R									11IR14W	●	●	●	●	0.250	0.035	0.028	0.009	
16	(0.036)	28	R	16ER28W		●	●		0.375	0.035	0.028	0.004	16IR28W		●			0.375	0.035	0.028	0.004
16	(0.038)	26	R	16ER26W		●			0.375	0.035	0.028	0.005	16IR26W		●			0.375	0.035	0.028	0.005
16	(0.050)	20	R	16ER20W		●			0.375	0.035	0.028	0.006	16IR20W		●			0.375	0.035	0.028	0.006
16	(0.053)	19	R	16ER19W	●	●	●		0.375	0.035	0.028	0.007	16IR19W		●			0.375	0.035	0.028	0.007
16	(0.056)	18	R	16ER18W		●			0.375	0.035	0.028	0.007	16IR18W		●			0.375	0.035	0.028	0.007
16	(0.063)	16	R	16ER16W		●	●		0.375	0.035	0.028	0.008	16IR16W		●	●		0.375	0.035	0.028	0.008
16	(0.071)	14	R	16ER14W	●	●	●	●	0.375	0.063	0.047	0.009	16IR14W	●	●	●	●	0.375	0.063	0.047	0.009
16	(0.071)	14	L	16EL14W		●			0.375	0.063	0.047	0.009									
16	(0.083)	12	R	16ER12W		●	●		0.375	0.063	0.047	0.011	16IR12W		●	●		0.375	0.063	0.047	0.011
16	(0.091)	11	R	16ER11W	●	●	●	●	0.375	0.063	0.047	0.011	16IR11W	●	●	●	●	0.375	0.063	0.047	0.011
16	(0.100)	10	R	16ER10W		●	●		0.375	0.063	0.047	0.013	16IR10W		●	●		0.375	0.063	0.047	0.013
16	(0.111)	9	R	16ER9W		●			0.375	0.063	0.047	0.014	16IR9W		●			0.375	0.063	0.047	0.014
16	(0.125)	8	R	16ER8W		●	●		0.375	0.063	0.047	0.016	16IR8W		●	●		0.375	0.063	0.047	0.016
22	(0.143)	7	R	22ER7W		●			0.500	0.098	0.067	0.018	22IR7W		●			0.500	0.098	0.067	0.018
22	(0.167)	6	R	22ER6W		●			0.500	0.098	0.067	0.021	22IR6W		●			0.500	0.098	0.067	0.021
22	(0.200)	5	R	22ER5W		●			0.500	0.098	0.067	0.025	22IR5W		●			0.500	0.098	0.067	0.025

Full-profile insert with chipbreaker

Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)								Internal insert (in)							
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					Coated	Cermet							Coated	Cermet					
					AH8015	AH725	NS9530						AH8015	AH725	NS9530				
16	(0.053)	19	R	16ER19W-B		●*		0.375	0.039	0.031	0.006								
16	(0.053)	19	R	16ER19W-M	●		●	0.375	0.035	0.028	0.007	16IR19W-M			●	0.375	0.035	0.028	0.007
16	(0.063)	16	R	16ER16W-B		●*		0.375	0.043	0.035	0.008	16IR16W-B			●*	0.375	0.043	0.035	0.007
16	(0.071)	14	R	16ER14W-B		●*		0.375	0.047	0.039	0.009	16IR14W-B			●*	0.375	0.047	0.039	0.008
16	(0.071)	14	R	16ER14W-M	●		●	0.375	0.063	0.047	0.009	16IR14W-M	●		●	0.375	0.063	0.047	0.009
16	(0.091)	11	R	16ER11W-B		●*		0.375	0.059	0.043	0.011	16IR11W-B			●*	0.375	0.059	0.043	0.011
16	(0.091)	11	R	16ER11W-M	●		●	0.375	0.063	0.047	0.011	16IR11W-M	●		●	0.375	0.063	0.047	0.011

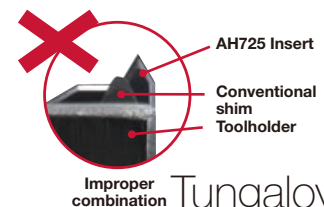
- ●* : The cutting edge position needs re-adjusting for these inserts have different PDY and PDX dimensions (Note: for size 16 inserts only).

- requires the use of dedicated shim.

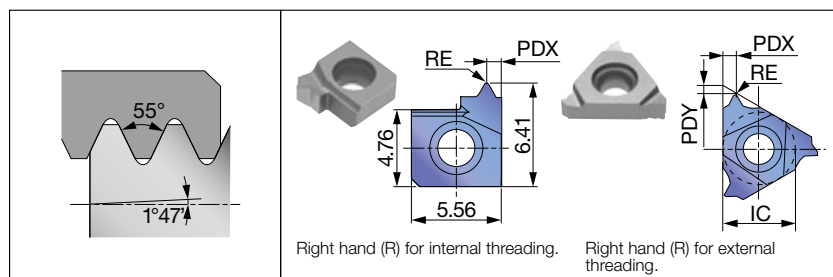
When using a new AH725 with chipbreaker, the conventional shim may need to be replaced with a new standard shim. Please refer to the page E070.

Reference pages: External toolholders → E036 - E040

Internal toolholders → E054 - E056



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) (in)	TPI	Hand of cut	External insert (in)								Internal insert (in)									
				Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE
					Coated			Uncoated						Coated			Uncoated				
					AH8015	AH725	T313V							TH10	AH8015	AH725					
6	(0.053)	19	R									6IR19PT	●	●		●	-	0.035	-	0.006	
11	(0.053)	19	R									11IR19PT	●	●	●	●	0.250	0.035	0.028	0.006	
11	(0.071)	14	R									11IR14PT	●	●	●	●	0.250	0.035	0.028	0.006	
16	(0.036)	28	R	16ER28PT		●	●		0.375	0.035	0.028	0.0035									
16	(0.053)	19	R	16ER19PT	●	●	●		0.375	0.035	0.028	0.006	16IR19PT		●			0.375	0.035	0.028	0.006
16	(0.071)	14	R	16ER14PT	●	●	●		0.375	0.063	0.047	0.006	16IR14PT	●	●	●	●	0.375	0.063	0.047	0.006
16	(0.091)	11	R	16ER11PT	●	●	●		0.375	0.063	0.047	0.010	16IR11PT	●	●	●	●	0.375	0.063	0.047	0.010

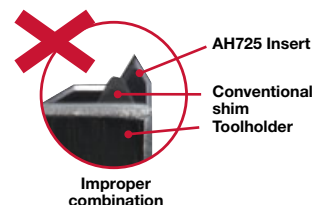
● : Line up / 5 pieces per package

Full-profile insert with chipbreaker

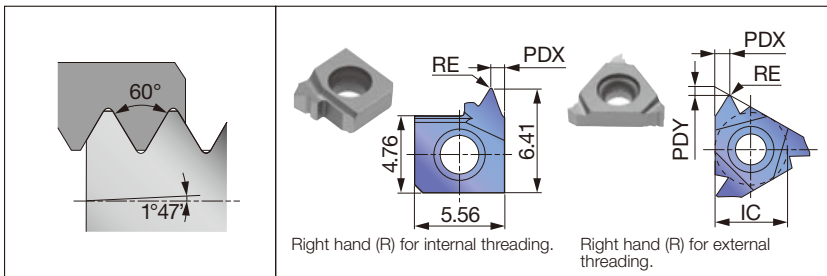
Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)								Internal insert (in)							
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					Coated		Cermet						Coated		Cermet				
					AH8015	AH725	NS9530						AH8015	AH725	NS9530				
16	(0.053)	19	R	16ER19PT-M			●	0.375	0.035	0.028	0.007	16IR19PT-M			●	0.375	0.035	0.028	0.007
16	(0.071)	14	R	16ER14PT-B		●*		0.375	0.047	0.039	0.009	16IR14PT-B		●*		0.375	0.047	0.039	0.008
16	(0.071)	14	R	16ER14PT-M	●		●	0.375	0.063	0.047	0.010	16IR14PT-M	●		●	0.375	0.063	0.047	0.010
16	(0.091)	11	R	16ER11PT-B		●*		0.375	0.059	0.043	0.012	16IR11PT-B		●*		0.375	0.059	0.043	0.012
16	(0.091)	11	R	16ER11PT-M	●		●	0.375	0.063	0.047	0.013	16IR11PT-M	●		●	0.375	0.063	0.047	0.013

- * : 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 [E070](#).

● : Line up / 5 pieces per package



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...

Full-profile insert

Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)								Internal insert (in)									
				Designation	Grade				IC	PDX	PDY	RE	Designation	Grade				IC	PDX	PDY	RE
					Coated			Uncoated						Coated			Uncoated				
					AH8015	AH725	T313V							TH10	AH8015	AH725					
6	(0.056)	18	R									6IR18NPT	●	●	-	0.035	-	0.0012			
16	(0.037)	27	R	16ER27NPT	●				0.375	0.020	0.047	0.0008	16IR27NPT	●				0.375	0.020	0.047	0.0008
16	(0.056)	18	R	16ER18NPT	●	●		0.375	0.035	0.028	0.0012	16IR18NPT	●				0.375	0.035	0.028	0.0012	
16	(0.071)	14	R	16ER14NPT	●				0.375	0.063	0.047	0.0016	16IR14NPT	●	●	●	0.375	0.063	0.047	0.0016	
16	(0.087)	11.5	R	16ER115NPT	●				0.375	0.063	0.047	0.0020	16IR115NPT	●			●	0.375	0.063	0.047	0.0020
16	(0.125)	8	R	16ER8NPT	●				0.375	0.063	0.047	0.0028	16IR8NPT	●			●	0.375	0.063	0.047	0.0028

● : Line up / 5 pieces per package

Full-profile insert with chipbreaker

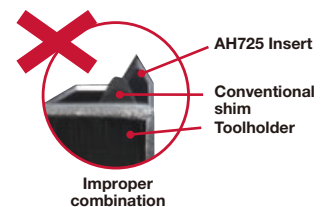
Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)								Internal insert (in)							
				Designation	Grade			IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					Coated		Cermet						Coated		Cermet				
					AH8015	AH725							NS9530	AH8015					
16	(0.056)	18	R	16ER18NPT-B	●*			0.375	0.039	0.031	0.0020								
16	(0.056)	18	R	16ER18NPT-M	●		●	0.375	0.035	0.028	0.0028	16IR18NPT-M		●		0.375	0.035	0.028	0.0028
16	(0.071)	14	R	16ER14NPT-B	●*			0.375	0.047	0.035	0.0020	16IR14NPT-B	●*			0.375	0.047	0.035	0.0020
16	(0.071)	14	R	16ER14NPT-M	●		●	0.375	0.063	0.047	0.0031	16IR14NPT-M	●		●	0.375	0.063	0.047	0.0031
16	(0.087)	11.5	R	16ER115NPT-B	●*			0.375	0.059	0.043	0.0035	16IR115NPT-B	●*			0.375	0.059	0.043	0.0035
16	(0.087)	11.5	R	16ER115NPT-M			●	0.375	0.063	0.047	0.0035	16IR115NPT-M	●		●	0.375	0.063	0.047	0.0035
16	(0.125)	8	R	16ER8NPT-B	●*			0.375	0.071	0.051	0.005	16IR8NPT-B	●*			0.375	0.071	0.051	0.005

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

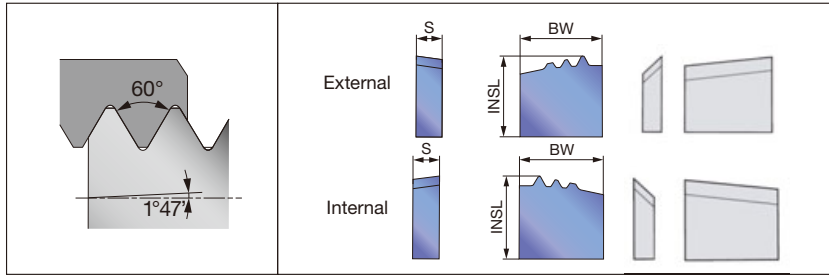
- ● requires the use of dedicated shim.

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 E070.

● : Line up / 5 pieces per package



NPT (for Pipe)



Applicable toolholder

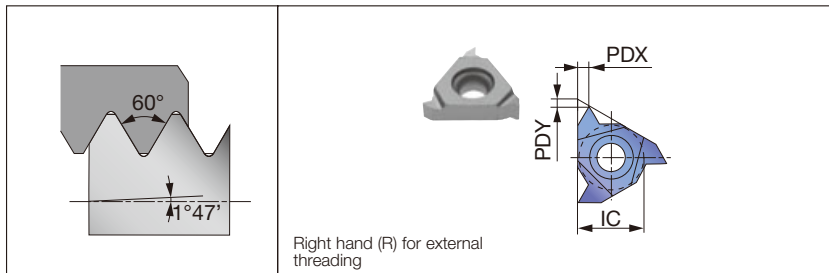
External	Internal
CLVOR-**M...	SI-CLHOR...

Full-profile insert (chaser)

Pitch (Reference) (mm)	TPI	Taper		External insert (in)							Internal insert (in)						
				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	●	0.630	0.618	0.205	CR-8R / 10R-3E / 4E-CB	CR-11.5NPT-4I	●	0.630	0.618	0.205	CR-8R / 10R-3I / 4I-CB		
(3.175)	8	1/16	0.75	CR-8NPT-4E	●	0.630	0.618	0.205	CR-8R / 10R-3E / 4E-CB	CR-8NPT-4I	●	0.630	0.618	0.205	CR-8R / 10R-3I / 4I-CB		

● : Line up / 5 pieces per package

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

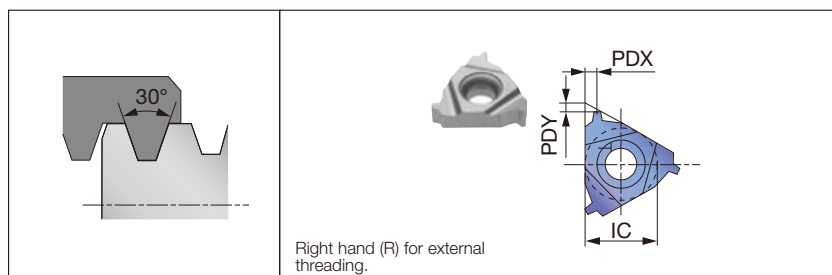
Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)						Internal insert (in)						
				Designation	Grade	IC	PDX	PDY	RE	Designation	Grade	IC	PDX	PDY	RE	
					Coated						Coated					
					AH725						AH725					
16	(0.037)	27	R	16ER27NPTF	●	0.375	0.020	0.047	-							
16	(0.056)	18	R	16ER18NPTF	●	0.375	0.035	0.028	-							
16	(0.071)	14	R	16ER14NPTF	●	0.375	0.063	0.047	-	16IR14NPTF	●	0.375	0.063	0.047	-	
16	(0.087)	11.5	R	16ER115NPTF	●	0.375	0.063	0.047	-	16IR115NPTF	●	0.375	0.063	0.047	-	
16	(0.125)	8	R	16ER8NPTF	●	0.375	0.063	0.047	-	16IR8NPTF	●	0.375	0.063	0.047	-	

● : Line up / 5 pieces per package

Reference pages: NPT: External toolholders → **E053**, Internal toolholders → **E067**

NPTF: External toolholders → **E036 - E040**, Internal toolholders → **E055 - E056**

30° Trapezoidal / DIN103 (for Machine parts)



Applicable toolholder

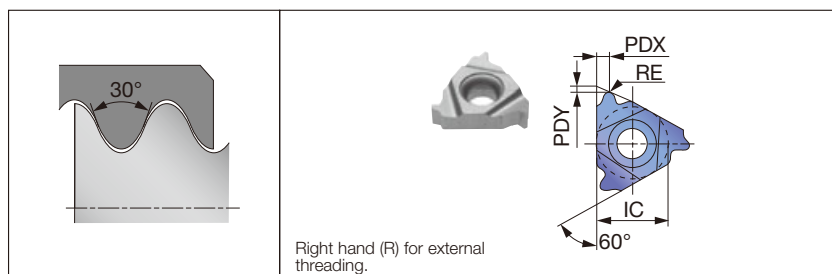
Insert size	External	Internal
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...
27	CER/L**27...	CNR/L**27...

With the special full-profile insert

Insert size	Pitch (Reference) (mm)	Hand of cut	External insert (in)						Internal insert (in)					
			Designation	Grade		IC	PDX	PDY	Designation	Grade		IC	PDX	PDY
				Coated						Coated				
				AH725	T313V					AH725	T313V			
16	1.5	R	16ER15TR	●		0.375	0.035	0.028	16IR15TR	●		0.375	0.035	0.028
16	2	R	16ER20TR	●	●	0.375	0.063	0.051	16IR20TR	●	●	0.375	0.063	0.051
16	3	R	16ER30TR	●	●	0.375	0.063	0.051	16IR30TR	●	●	0.375	0.063	0.051
22	4	R	22ER40TR	●	●	0.500	0.098	0.079	22IR40TR	●	●	0.500	0.098	0.079
22	5	R	22ER50TR	●	●	0.500	0.098	0.079	22IR50TR	●	●	0.500	0.098	0.079
27	6	R	27ER60TR	●	●	0.625	0.126	0.098						

● : Line up / 5 pieces per package

Round / DIN405 (for Machine parts)



Applicable toolholder

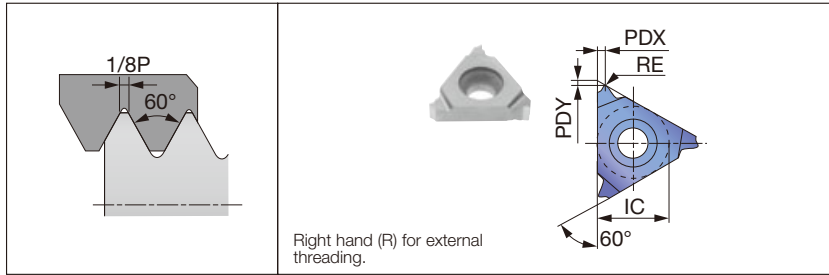
Insert size	External	Internal
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...

Full-profile insert

Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)						Internal insert (in)					
				Designation	Grade	IC	PDX	PDY	RE	Designation	Grade	IC	PDX	PDY	RE
					Coated						Coated				
					AH725						AH725				
16	(.125)	8	R	16ER8RD-B	●	0.375	0.051	0.055	0.030						
16	(.167)	6	R	16ER6RD-B	●	0.375	0.067	0.059	0.040	16IR6RD-B	●	0.375	0.059	0.055	0.037

● : Line up / 5 pieces per package

UNJ (for Aerospace industry)



Applicable toolholder

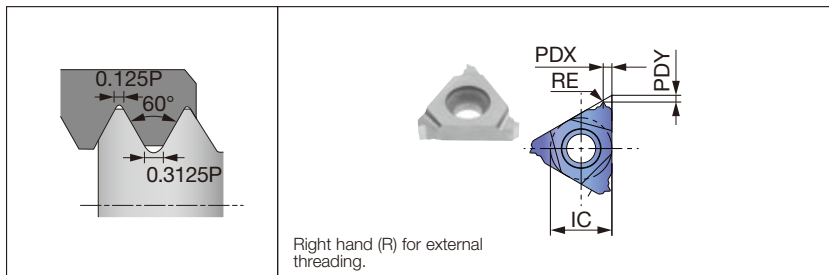
Insert size	External
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16

Full-profile insert

Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)						
				Designation	Grade		IC	PDX	PDY	RE
					Coated					
					AH8015	AH725				
16	(0.031)	32	R	16ER32UNJ	●	●	0.375	0.020	0.047	0.005
16	(0.036)	28	R	16ER28UNJ	●	●	0.375	0.020	0.047	0.006
16	(0.042)	24	R	16ER24UNJ	●	●	0.375	0.035	0.028	0.007
16	(0.050)	20	R	16ER20UNJ	●	●	0.375	0.035	0.028	0.008
16	(0.056)	18	R	16ER18UNJ	●	●	0.375	0.035	0.028	0.009
16	(0.063)	16	R	16ER16UNJ	●	●	0.375	0.035	0.028	0.010
16	(0.071)	14	R	16ER14UNJ	●	●	0.375	0.063	0.047	0.012
16	(0.083)	12	R	16ER12UNJ	●	●	0.375	0.063	0.047	0.014
16	(0.100)	10	R	16ER10UNJ	●	●	0.375	0.063	0.047	0.017
16	(0.125)	8	R	16ER8UNJ	●	●	0.375	0.063	0.047	0.021

● : Line up / 5 pieces per package

MJ (for Aerospace industry)



Applicable toolholder

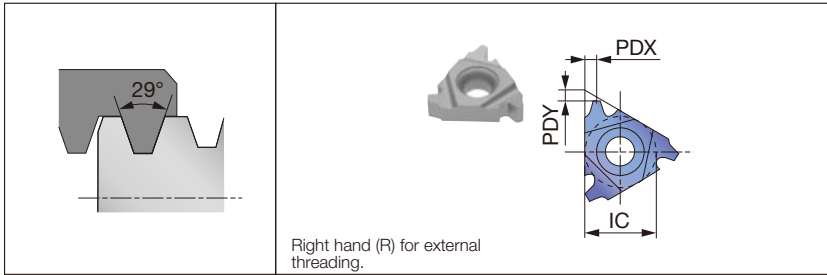
Insert size	Internal
11	SNR/L**11...

Insert size	Pitch (Reference) (in)	Hand of cut	Internal insert (in)						
			Designation	Grade		IC	PDX	PDY	RE
				Coated					
				AH8015					
11	0.039	R	11IR10MJ	●		0.250	0.035	0.028	0.0020

● : Line up / 5 pieces per package

Reference pages: UNJ : External toolholders → **E036 - E040**
MJ : Internal toolholders → **E055**

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



Applicable toolholder

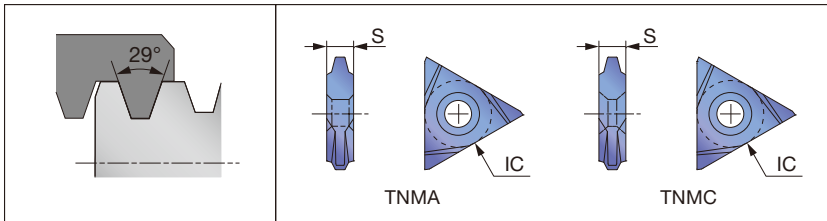
Insert size	External	Internal
16	CER/L**16... (C*CER/L...) JSER**16... JS**SEL16 SER**16-CHP B-SER/L**16 B-CER/L**16 BC-SER/L**16	TSNR/L**16 SNR/L**16... TCNR/L**16... CNR/L**16...
22	CER/L**22... SER**22-CHP	TSNR/L**22 SNR/L**22... TCNR/L**22... CNR/L**22...

With the special full-profile insert

Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)						Internal insert (in)					
				Designation	Grade		IC	PDX	PDY	Designation	Grade		IC	PDX	PDY
					Coated						Coated				
					AH725	T313V					AH725	T313V			
16	(0.083)	12	R	16ER12ACME	●		0.375	0.063	0.051	16IR12ACME	●		0.375	0.063	0.051
16	(0.100)	10	R	16ER10ACME	●		0.375	0.063	0.051	16IR10ACME	●		0.375	0.063	0.051
16	(0.125)	8	R	16ER8ACME	●	●	0.375	0.063	0.051	16IR8ACME	●	●	0.375	0.063	0.051
22	(0.167)	6	R	22ER6ACME	●	●	0.500	0.098	0.079	22IR6ACME	●	●	0.500	0.098	0.079
22	(0.200)	5	R	22ER5ACME	●	●	0.500	0.098	0.079	22IR5ACME	●	●	0.500	0.098	0.079

● : Line up / 5 pieces per package

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



Applicable toolholder

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

On edge

Pitch	TPI	Taper		External insert (in)			
		mm/mm	TPF	Designation	Grade	IC	S
					Coated		
(1.588)	16	-	-	TNMA43NT16PEXT-PT	●	0.500	0.189
(1.814)	14	-	-	TNMA43NT14PEXT-PT	●	0.500	0.189
(2.117)	12	-	-	TNMA43NT12PEXT-PT	●	0.500	0.189
(2.54)	10	-	-	TNMA43NT10PEXT-PT	●	0.500	0.189
(3.175)	8	-	-	TNMA43NT8PEXT-PT	●	0.500	0.189
(4.233)	6	-	-	TNMA43NT6PEXT-PT	●	0.500	0.189
(5.08)	5	-	-	TNMA54NT5PEXT-PT	●	0.625	0.252
(6.35)	4	-	-	TNMA54NT4PEXT-PT	●	0.625	0.252
(8.47)	3	-	-	TNMA54NT3PEXT-PT	●	0.625	0.252
(1.588)	16	-	-	TNMC43NT16PEXT-PT	●	0.500	0.189
(1.814)	14	-	-	TNMC43NT14PEXT-PT	●	0.500	0.189
(2.117)	12	-	-	TNMC43NT12PEXT-PT	●	0.500	0.189
(2.54)	10	-	-	TNMC43NT10PEXT-PT	●	0.500	0.189
(3.175)	8	-	-	TNMC43NT8PEXT-PT	●	0.500	0.189
(4.233)	6	-	-	TNMC43NT6PEXT-PT	●	0.500	0.189
(5.08)	5	-	-	TNMC54NT5PEXT-PT	●	0.625	0.252
(6.35)	4	-	-	TNMC54NT4PEXT-PT	●	0.625	0.252
(8.47)	3	-	-	TNMC54NT3PEXT-PT	●	0.625	0.252

● : Line up / 10 pieces per package

Reference pages: 29° Trapezoidal With the special full-profile insert : External toolholders → **E036 - E040**, Internal toolholders → **E055 - E056**
29° Trapezoidal On edge : External toolholders → **E052**

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

On edge

Applicable toolholder

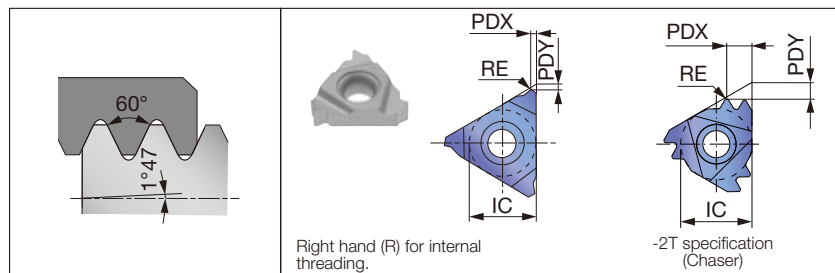
Pitch (Reference) (in)	TPI	Taper		External insert (in)			
		mm/mm	TPF	Designation	Grade	IC	S
					Coated		
					AH725		
(0.063)	16	-	-	TNMA43NT16PSTUBE-PT	●	0.500	0.189
(0.071)	14	-	-	TNMA43NT14PSTUBE-PT	●	0.500	0.189
(0.083)	12	-	-	TNMA43NT12PSTUBE-PT	●	0.500	0.189
(0.100)	10	-	-	TNMA43NT10PSTUBE-PT	●	0.500	0.189
(0.125)	8	-	-	TNMA43NT8PSTUBE-PT	●	0.500	0.189
(0.167)	6	-	-	TNMA43NT6PSTUBE-PT	●	0.500	0.189
(0.200)	5	-	-	TNMA54NT5PSTUBE-PT	●	0.625	0.252
(0.250)	4	-	-	TNMA54NT4PSTUBE-PT	●	0.625	0.252
(0.333)	3	-	-	TNMA54NT3PSTUBE-PT	●	0.625	0.252
(0.063)	16	-	-	TNMC43NT16PSTUBE-PT	●	0.500	0.189
(0.071)	14	-	-	TNMC43NT14PSTUBE-PT	●	0.500	0.189
(0.083)	12	-	-	TNMC43NT12PSTUBE-PT	●	0.500	0.189
(0.100)	10	-	-	TNMC43NT10PSTUBE-PT	●	0.500	0.189
(0.125)	8	-	-	TNMC43NT8PSTUBE-PT	●	0.500	0.189
(0.167)	6	-	-	TNMC43NT6PSTUBE-PT	●	0.500	0.189
(0.200)	5	-	-	TNMC54NT5PSTUBE-PT	●	0.625	0.252
(0.250)	4	-	-	TNMC54NT4PSTUBE-PT	●	0.625	0.252
(0.333)	3	-	-	TNMC54NT3PSTUBE-PT	●	0.625	0.252

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.

● : Line up / 10 pieces per package

API Round (for Energy industry)



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) (in)	TPI	Hand of cut	External insert (in)							Internal insert (in)							
				Designation	Grade		IC	PDX	PDY	RE	Designation	Grade			IC	PDX	PDY	RE
					Coated							Coated						
					AH725	T313V						AH8015	AH725	T313V				
16	(0.100)	10	R	16ER10RAPI	●		0.375	0.063	0.047	0.014	16IR10RAPI	●	●		0.375	0.063	0.047	0.014
16	(0.125)	8	R	16ER8RAPI	●		0.375	0.063	0.047	0.017	16IR8RAPI	●	●	●	0.375	0.063	0.047	0.017
22	(0.125)	8	R								22IR8RAPI-2T	●			0.500	0.177	0.118	0.017

● : Line up / 5 pieces per package

Full-profile insert with chipbreaker

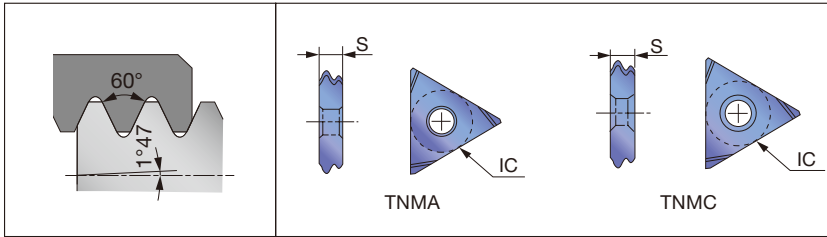
Insert size	Pitch (Reference) (in)	TPI	Hand of cut	External insert (in)							Internal insert (in)						
				Designation	Grade	IC	PDX	PDY	RE	Designation	Grade	IC	PDX	PDY	RE		
					Coated						Coated						
					AH725						AH725						
16	(.100)	10	R	16ER10RD-CB	●	0.375	0.047	0.059	0.014	16IR10RD-CB	●	0.375	0.047	0.059	0.014		
16	(.125)	8	R	16ER8RD-CB	●	0.375	0.051	0.059	0.017	16IR8RD-CB	●	0.375	0.051	0.059	0.017		

● : Line up / 10 pieces per package

Reference pages: 29° Trapezoidal : External toolholders → **E052**

API Round : External toolholders → **E036 - E040**, Internal toolholders → **E055 - E056**

API Round (for Energy)



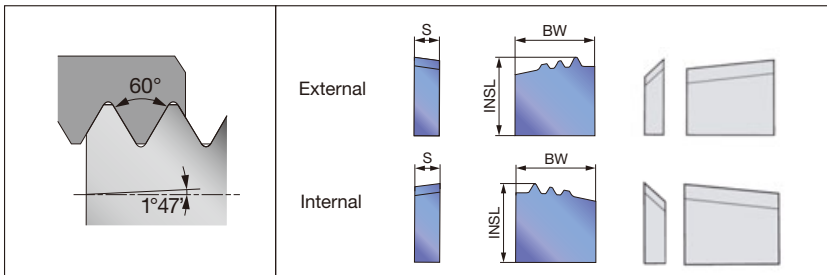
Applicable toolholder

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

On edge

Pitch (Reference) (in)	TPI	Taper		External insert (in)				Internal insert (in)			
		mm/mm	TPF	Designation	Grade	IC	S	Designation	Grade	IC	S
					Coated				Coated		
(0.100)	10	1/16	0.75	TNMA4310RDEXT	●	0.500	0.189	TNMA4310RDINT	●	0.500	0.189
(0.125)	8	1/16	0.75	TNMA438RDEXT	●	0.500	0.189	TNMA438RDINT	●	0.500	0.189
(0.100)	10	1/16	0.75	TNMC4310RDEXT	●	0.500	0.189	TNMC4310RDINT	●	0.500	0.189
(0.125)	8	1/16	0.75	TNMC438RDEXT	●	0.500	0.189	TNMC438RDINT	●	0.500	0.189

● : Line up / 10 pieces per package



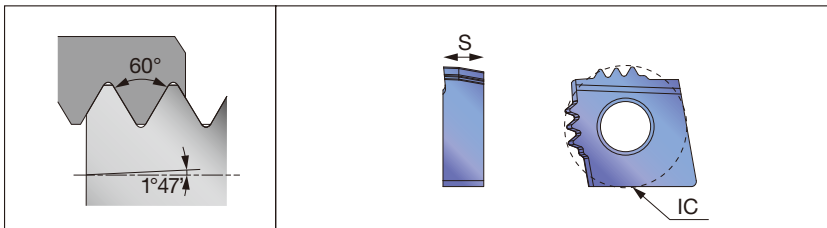
Applicable toolholder

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

Full-profile insert (chaser)

Pitch (Reference) (mm)	TPI	Taper		External insert (mm)						Internal insert (mm)					
		mm/mm	TPF	Designation	Grade	BW	INSL	S	Chip breaking attachment	Designation	Grade	BW	INSL	S	Chip breaking attachment
					Coated						Coated				
(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

● : Line up / 10 pieces per package



Full-profile insert (chaser)

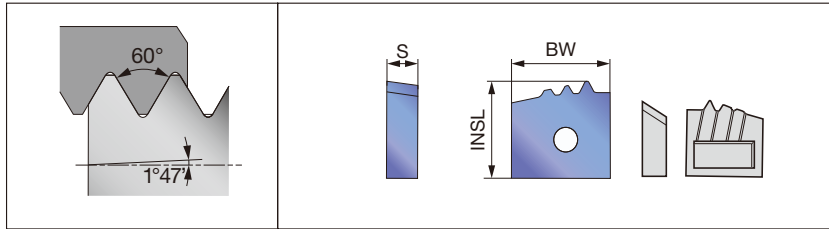
Pitch (Reference) (mm)	TPI	Taper		External insert (mm)			
		mm/mm	TPF	Designation	Grade	IC	S
					Coated		
(2.54)	10	1/16	0.75	CNGA-10R-3E	●	19.05	6.4
(3.175)	8	1/16	0.75	CNGA-8R-3E	●	19.05	6.4

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

● : Line up / 10 pieces per package

Reference pages: API Round On edge : External toolholders → **E052**, Internal toolholders → **E066**
API Round Full-profile insert : External toolholders → **E053**, Internal toolholders → **E067**

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



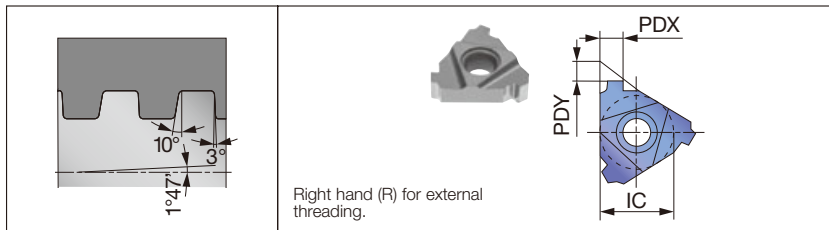
Full-profile insert (chaser)

Pitch (Reference) (mm)	TPI	Taper		External insert (mm)					
		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.

● : Line up / 10 pieces per package

API Buttress (for Energy industry)



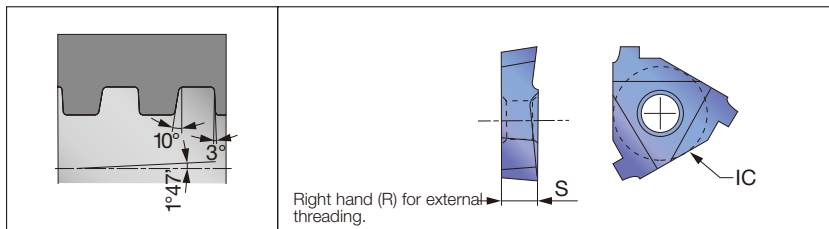
Applicable toolholder

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) (in)	TPI	Hand of cut	External insert (in)					Internal insert (in)				
				Designation	Grade	IC	PDX	PDY	Designation	Grade	IC	PDX	PDY
					Coated					Coated			
					AH725					AH725			
22	(0.200)	5	R	22ER5BAPI	●	0.500	0.146	0.087	22IR5BAPI	●	0.500	0.136	0.087

● : Line up / 5 pieces per package



Applicable toolholder

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

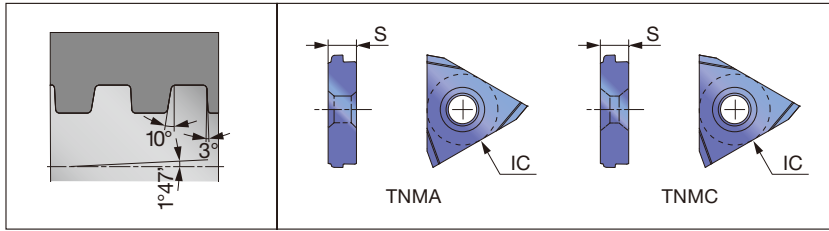
Full-profile insert (single side)

Pitch (Reference) (mm)	TPI	Taper		External insert (mm)				Internal insert (mm)			
		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

● : Line up / 10 pieces per package

Reference pages: API Buttress Full-profile insert : External toolholders → **E036, E039**, Internal toolholders → **E055 - E056**
API Buttress Full-profile insert (single side) : External toolholders → **E051**, Internal toolholders → **E065**

API Buttress (for Energy industry)



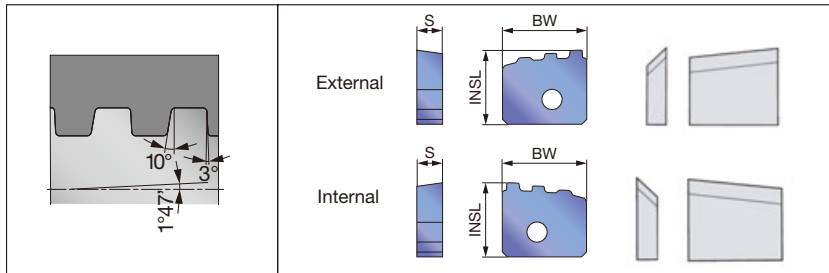
Applicable toolholder

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

On edge

Pitch (Reference) (in)	TPI	Taper		External insert (in)				Internal insert (in)			
		mm/mm	TPF	Designation	Grade	IC	S	Designation	Grade	IC	S
					Coated				Coated		
(0.200)	5	1/12	1	TNMA545B1EXT-FC	AH725	0.625	0.252	TNMA545B1INT-FC	AH725	0.625	0.252
(0.200)	5	1/16	0.75	TNMA545B75EXT-FC	AH725	0.625	0.252	TNMA545B75INT-FC	AH725	0.625	0.252
(0.200)	5	1/12	1	TNMC545B1EXT-FC	AH725	0.625	0.252	TNMC545B1INT-FC	AH725	0.625	0.252
(0.200)	5	1/16	0.75	TNMC545B75EXT-FC	AH725	0.625	0.252	TNMC545B75INT-FC	AH725	0.625	0.252

● : Line up / 10 pieces per package



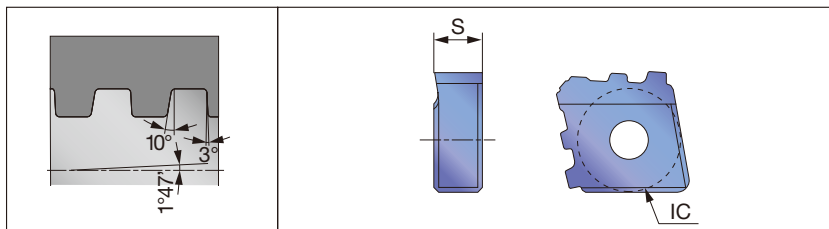
Applicable toolholder

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

Full-profile insert (chaser)

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

● : Line up / 10 pieces per package



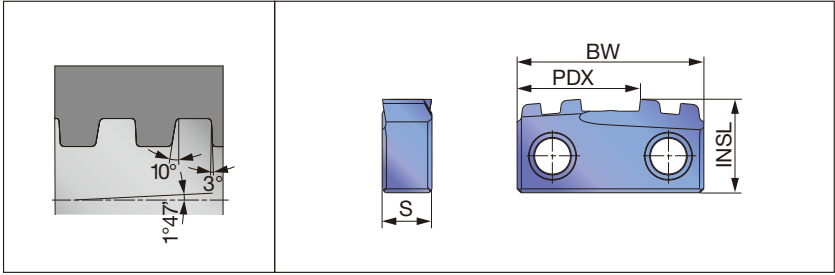
Full-profile insert (chaser)

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

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

● : Line up / 10 pieces per package

API Buttress (for Energy industry)

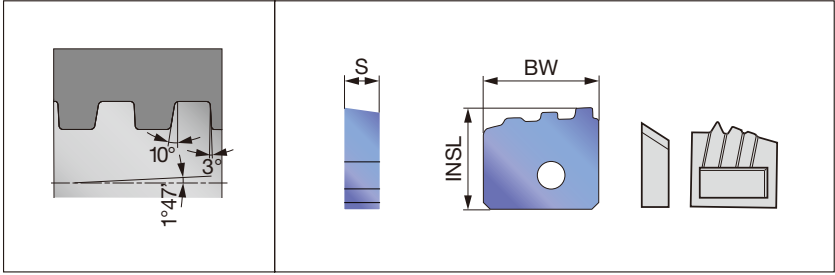


Full-profile insert

Insert size	Pitch (Reference) (mm)	TPI	Hand of cut	Internal insert (mm)					
				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. ● : Line up / 10 pieces per package

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

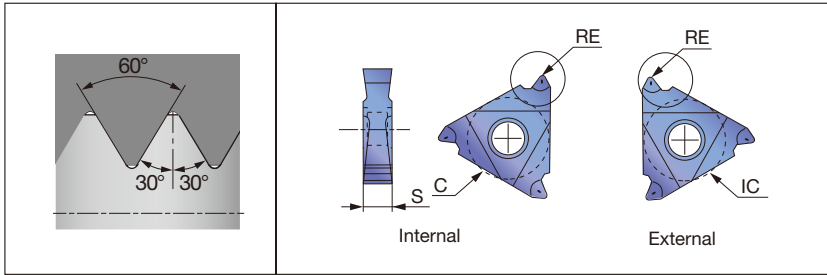


Full-profile insert (chaser)

Pitch (Reference) (mm)	TPI	Taper		Designation	Grade	BW	INSL	S	RE	Chip breaking attachment
					Coated					
					AH725					
		mm/mm	TPF							
(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. ● : Line up / 10 pieces per package

API Rotary shoulder connection (for Energy industry)



Applicable toolholder

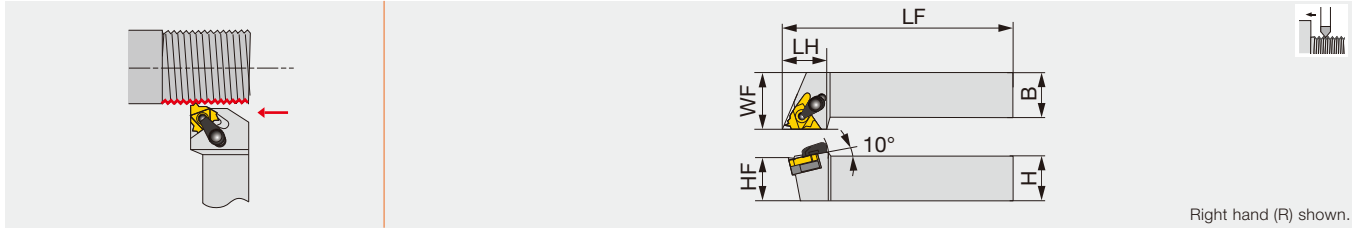
External	Internal
MTVNR-3232M54	HS**-LNFR-54API

Full-profile insert (Double side)

Pitch (Reference) (in)	TPI	Connection	Taper		Designation	Grade	IC (in)	S (in)	RE (in)
						Coated			
			mm/mm	TPF		AH725			
(0.250)	4	V-0.038R	1/6	2	LDS54428FT-CB#1	●	0.625	0.252	0.038
(0.250)	4	V-0.038R	1/4	3	LDS54438FT-CB#2	●	0.625	0.252	0.038
(0.250)	4	V-0.050	1/6	2	LDS54425FT-CB#3	●	0.625	0.252	0.025
(0.250)	4	V-0.050	1/4	3	LDS54435FT-CB#4	●	0.625	0.252	0.025
(0.200)	5	V-0.040	1/4	3	LDS54530FT-CB#5	●	0.625	0.252	0.020

● : Line up / 10 pieces per package

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



Right hand (R) shown.

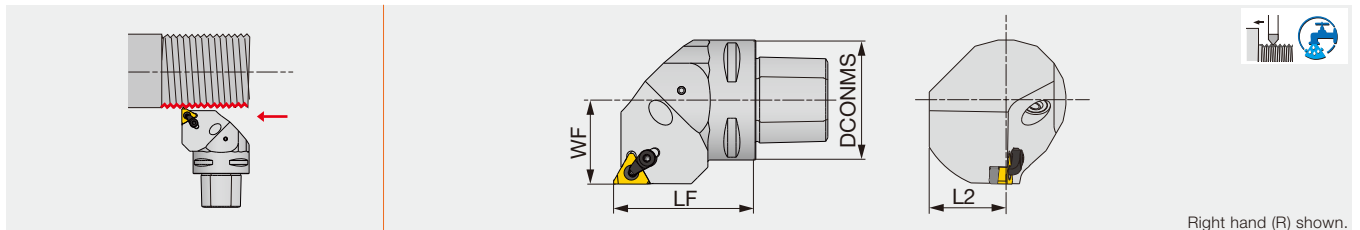
Inch	H	B	LF	LH	HF	WF	Insert
CER/L123DT	0.750	0.750	5.000	0.870	0.750	1.000	16ER/L...
CER/L163DT	1.000	1.000	6.000	1.000	1.000	1.250	16ER/L...
CER203DT	1.250	1.250	6.000	1.250	1.250	1.500	16ER...
CER164DT	1.000	1.000	6.000	1.000	1.000	1.250	22ER...
CER204DT	1.250	1.250	6.000	1.250	1.250	1.500	22ER...

Metric	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.

C-CER/L

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



Right hand (R) shown.

Metric	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/L35060-16ERN ⁽¹⁾	50	60	32	35	16ER/L...
C5CER/L35060-16ERN ⁽²⁾	50	60	32	35	16ER/L...
C6CER/L45065-16ERN ⁽¹⁾	63	65	41	45	16ER/L...
C6CER/L45065-16ERN ⁽²⁾	63	65	41	45	16ER/L...

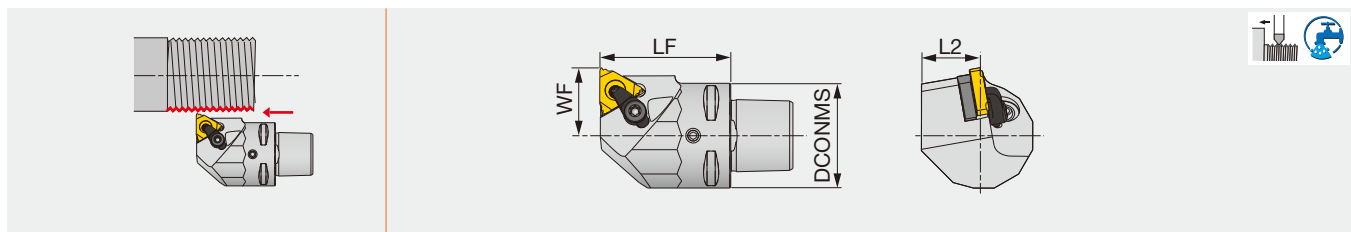
(1) Applicable for 3 MPa coolant (2) Applicable for 7 MPa coolant

SPARE PARTS									
Designation	Clamp set	Clamping screw	Coolant parts	Shim screw	Shim	Shim set	Wrench 1	Wrench 2	Wrench 3
CER/L123-DT, CER/L163-DT	CSP16	CSTB-3.5ST	DTS5 - 3.5	A16 - 1DT	-	P-3.5	T-15F	-	-
CER203-DT	CSP22	CSTB-4ST	DTS6-4	GX22-1DT	-	P-3.5	T-15F	-	-
CER164-DT, CER204-DT	CSP22	CSTB-4ST	DTS6-4	GX22-1DT	-	P-4	T-20F	-	-
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	-	-
C3CE*22040-16ERN, C4CE*27050-16ERN	CSP16	CSTB-3.5ST	SATZ-M8X1-M3	DTS5-3.5	A16-1DT	-	P-3.5	T-15F	-
C5CE*35060-16ER, C6CE*45065-16ER	CSP16	CSTB-3.5ST	EZ104	DTS5-3.5	A16-1DT	-	P-3.5	T-15F	-
C5CE*35060-16ERN, C6CE*45065-16ERN	CSP16	CSTB-3.5ST	SATZ-M10X1-M5	DTS5-3.5	A16-1DT	-	P-3.5	T-15F	-

TUNGCAP

C-CEL-ERN-B

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



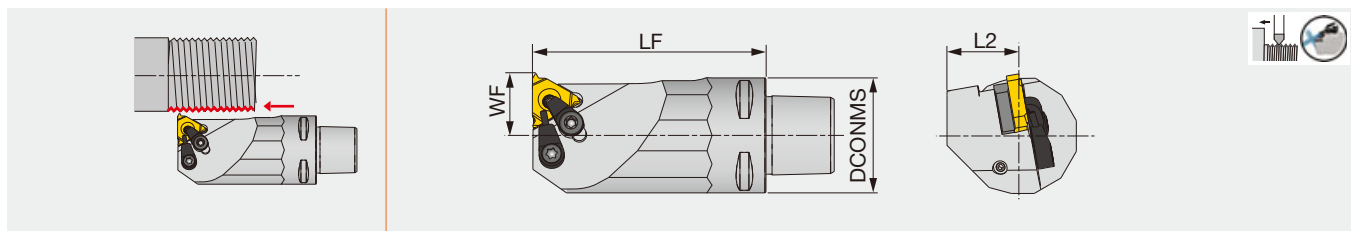
Metric	DCONMS	LF	L2	WF	Insert
C3CEL22040-16ERN-B	32	40	18	22	16ER...

Applicable for 7 MPa coolant
Cannot be used for boring

C-CEL-ERB-CHP

Tube connection

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



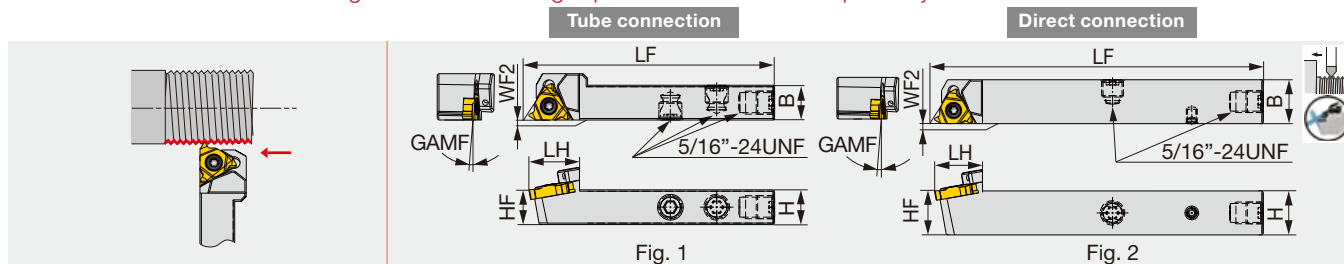
Metric	DCONMS	LF	L2	WF	Insert
C3CEL18065-16ERB-CHP	32	65	20	18	16ER...

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 parts	Coolant unit
C3CEL22040-16ERN-B	A16-1DT	DTS5-3.5	CSTB-3.5ST	CSP16	T-15F	P-3.5	SATZ-M8X1-M3	-
C3CEL18065-16ERB-CHP	A16-1DT	DTS5-3.5	CSTB-3.5ST	CSP16	T-15F	P-3.5	-	S-CU-CHP

Reference pages: Inserts → **E010 - E011, E015, E017 - E030**

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

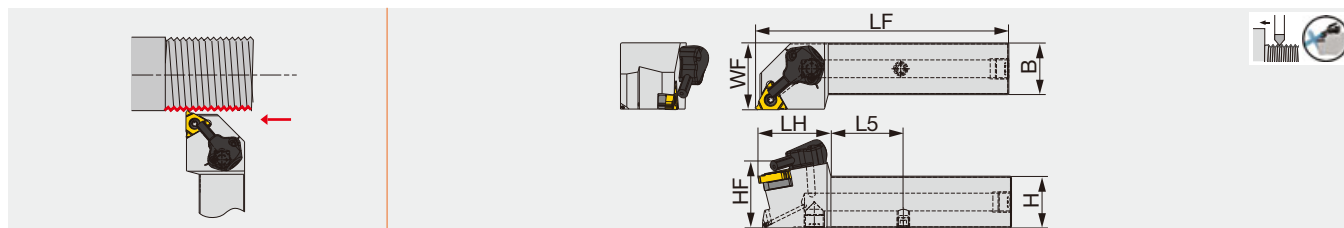


Inch	H	B	LF	LH	HF	WF	GAMF	Type	Insert
JSE2R08F16-CHP	0.500	0.500	3.344	0.748	0.500	0.000	1°	1	16ER...
JSE2R08X16-CHP	0.500	0.500	4.750	0.748	0.500	0.000	1°	2	16ER...
JSE2R10X16-CHP	0.625	0.625	4.750	0.748	0.625	0.000	1°	2	16ER...
Metric	H	B	LF	LH	HF	WF2	GAMF	Fig.	Insert
JSE2R1212F16-CHP	12	12	85	19	12	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...

SER-X-CHP-MC

Direct connection

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



Metric	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
JSE2R**16-CHP	CSTB-3.5	T-15F	-	-	-	SR5/16UNFTL360	P-4
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.

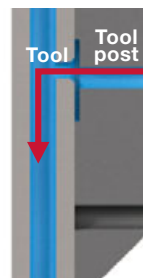
Eliminates chip entanglement on tubes and streamlines tool replacement.

Coolant is supplied from the tool post directly to the tools

Internal thread
Optional connection with
external coolant line



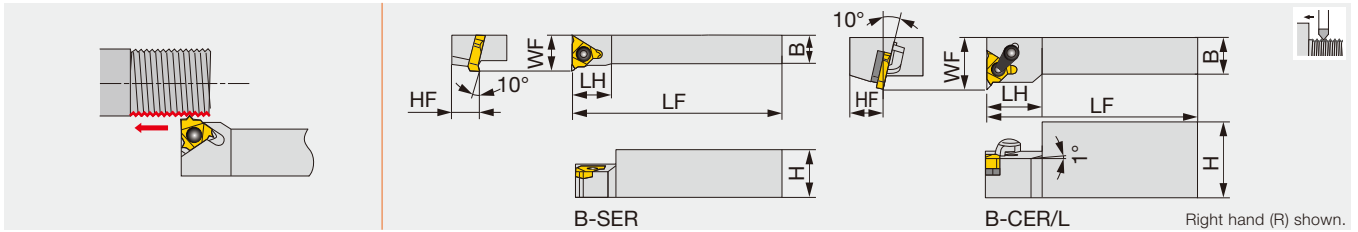
Detailed view of the coolant
flow after connection



Reference pages: Inserts → **E010 - E011, E015, E017 - E030, E032**

B-S/CER/L

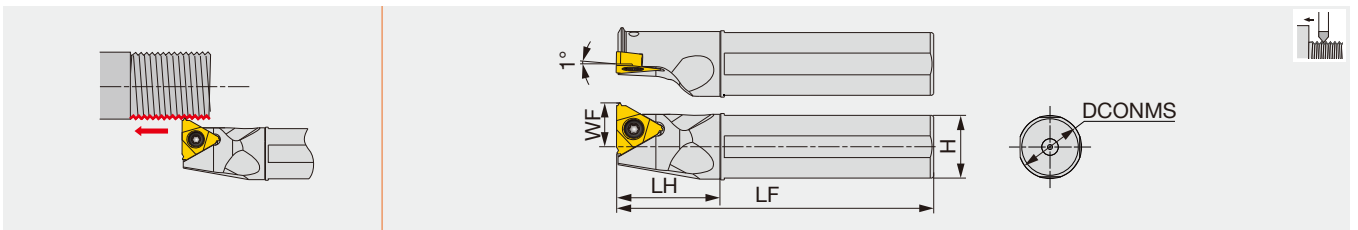
External threading toolholder for Swiss lathes



Metric	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...

JS-SEL16

External threading toolholder for Swiss lathes



Metric	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...
JS25H-SEL16	25	24	100	30	15.5	16ER...
JS254X-SEL16	25.4	24	120	30	15.7	16ER...

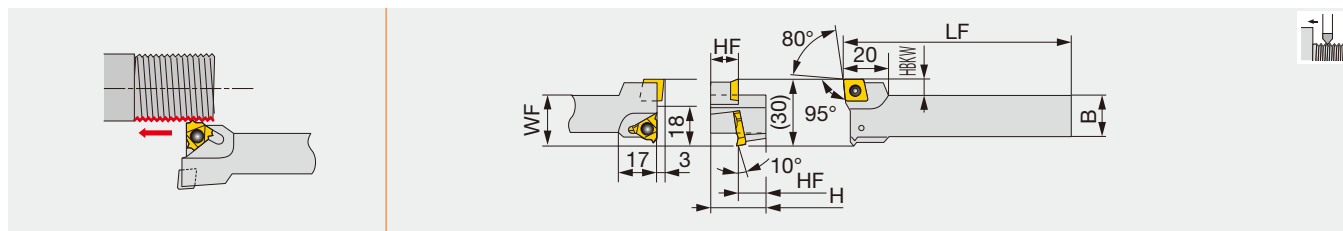
Note: Use the right-hand insert (16ER...) for a left-hand holder (JS***-SEL...).

SPARE PARTS

Designation	Clamp set	Shim set	Clamping screw	Wrench
B-SER***16	-	-	CSTB-3.5	T-15F
B-CER/L16M16	CSP16	A16-1	-	T-15F
JS***-SEL16	-	-	CSTB-3.5	T-15F

Reference pages: Inserts → [E010](#) - [E011](#), [E015](#), [E017](#) - [E030](#)

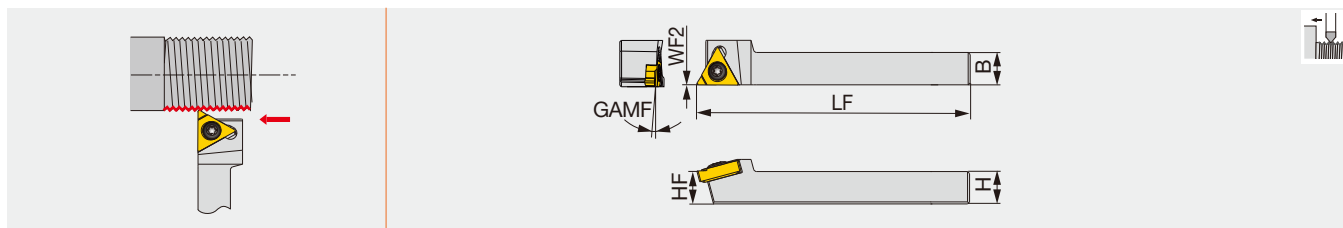
External threading toolholder for multi-functional Swiss lathes



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

SER

Screw-on external threading toolholders



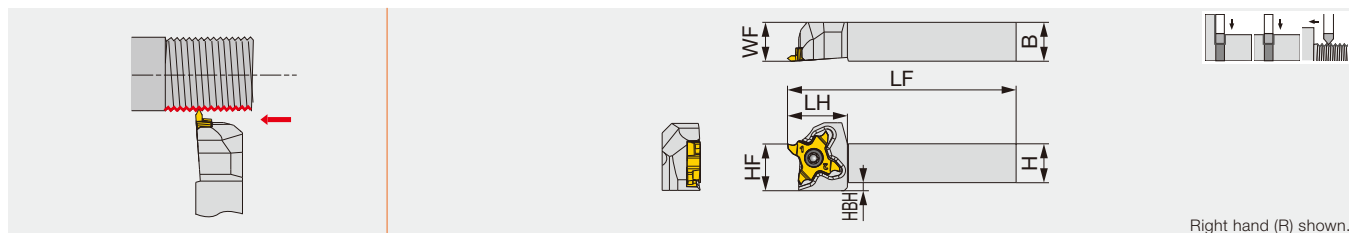
Metric	H	B	LF	HF	WF2	GAMF	Insert
SER0808H11	8	8	100	8	0	1.5°	11ER...
SER1010H11	10	10	100	10	0	1.5°	11ER...

SPARE PARTS



Designation	Clamping screw	Wrench
BC-SER12K16	CSTB-3.5	T-15F
SER**H11	SR M2.6-L6.7-S11	T-8/5

External grooving and threading toolholder



Inch	H	B	LF	LH	HF	WF	HBH	Insert	Torque
STCR/L06-18	0.375	0.375	4.750	0.730	0.375	0.375	0.177	TC*18...	0.89
STCR/L08-18	0.500	0.500	4.750	0.730	0.500	0.500	0.098	TC*18...	0.89
STCR/L10-18	0.625	0.625	4.750	0.730	0.625	0.625	-	TC*18...	0.89
STCR/L12-18	0.750	0.750	4.750	0.900	0.750	1.000	-	TC*18...	0.89
STCR/L16-18	1.000	1.000	5.500	0.900	1.000	1.250	-	TC*18...	0.89

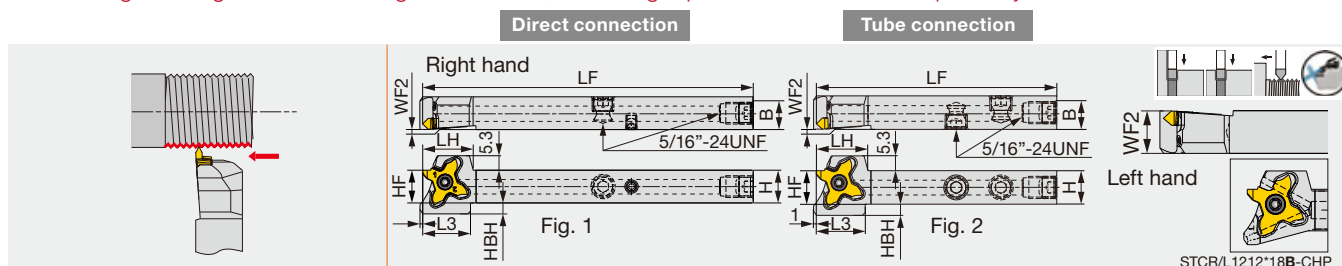
Metric	H	B	LF	LH	HF	WF	HBH	Insert	Torque*
STCR/L1010X18	10	10	120	18.5	10	10	4.5	TCT18...	1.2
STCR/L1212F18	12	12	85	18.5	12	12	2.5	TCT18...	1.2
STCR/L1212X18	12	12	120	18.5	12	12	2.5	TCT18...	1.2
STCR/L1616X18	16	16	120	18.5	16	16	-	TCT18...	1.2
STCR/L2020H18	20	20	100	18.5	20	20	-	TCT18...	1.2
STCR/L2020X18	20	20	120	23	20	25	-	TCT18...	1.2
STCR/L2525X18	25	25	135	23	25	30	-	TCT18...	1.2

Torque: Recommended clamping torque: lbs-ft (*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...).

STCR/L-18-CHP

External grooving and threading toolholder, with high pressure coolant capability



Inch	H	B	LF	LH	L3	HF	WF2**	HBH	Fig.	Insert	Torque
STCR/L08F18-CHP	0.500	0.500	3.344	0.728	0.689	0.500	0/0.500	0.130	2	TC*18...	0.89
STCR/L08X18-CHP ⁽¹⁾	0.500	0.500	4.750	0.728	0.689	0.500	0/0.500	0.130	1	TC*18...	0.89
STCR/L10X18-CHP ⁽¹⁾	0.625	0.625	4.750	0.728	-	0.625	0/0.625	-	1	TC*18...	0.89
STCR/L12-18-CHP	0.750	0.750	4.750	0.900	-	0.750	-	-	2	TC*18...	0.89
STCR/L16-18-CHP	1.000	1.000	5.500	0.900	-	1.000	-	-	2	TC*18...	0.89

Metric	H	B	LF	LH	HBL	HF	WF2**	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: lbs-ft (*N-m)

WF2** : The first value before "/" indicates the WF2 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.

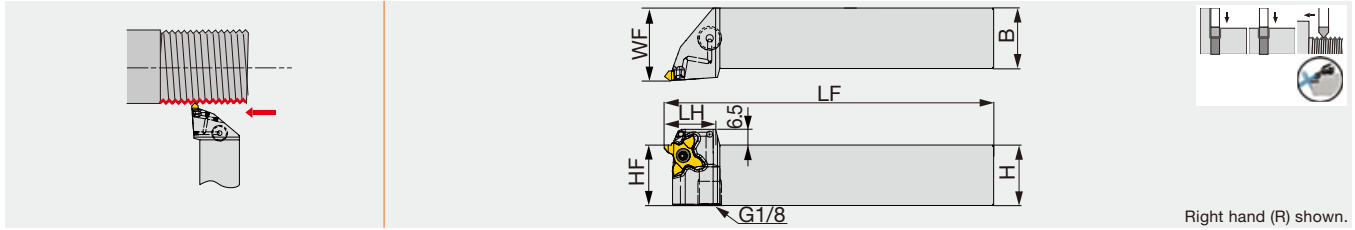
Use the right-hand insert (TC*18R...) for a right-hand holder (STCR...); the left-hand insert (TC*18L...) for a left-hand holder (STCL...).

SPARE PARTS

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

Reference pages: Inserts → **E012**

External threading with high pressure coolant capability



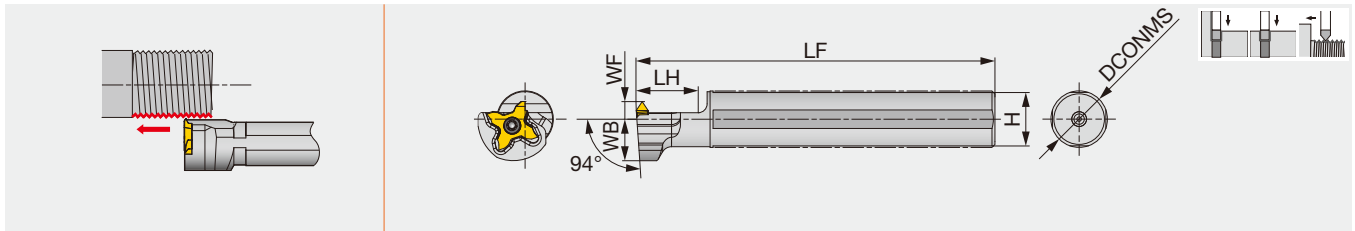
Inch	H	B	LF	LH	HBL	HF	WF	HBH	Insert	Torque
STCR/L12-18-CHP	0.750	0.750	4.750	0.900	-	0.750	1.000	-	TC*18...	0.89
STCR/L16-18-CHP	1.000	1.000	5.500	0.900	-	1.000	1.250	-	TC*18...	0.89
Metric	H	B	LF	LH	HBL	HF	WF	HBH	Insert	Torque*
STCR/L2020X18-CHP	20	20	120	23	-	20	25	-	TC*18...	1.2
STCR/L2525Z18-CHP	25	25	135	23	-	25	30	-	TC*18...	1.2

Torque: Recommended clamping torque: lbs-ft (*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...).

JS-STCL18

External grooving and threading toolholder with round shank



Metric	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)

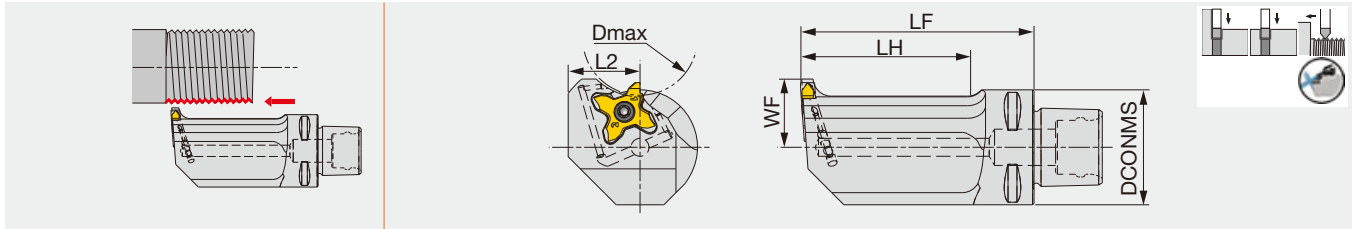
Note: Use the right-hand insert (TCT18R...) for a left-hand holder (STCL...).

SPARE PARTS

Designation	Clamping screw	Wrench
STCL**18-CHP	CSTC-4L100DR	T-1008/5
STCR**18-CHP, JS**STCL18	CSTC-4L100DL	T-1008/5

C-STCFL-18-CHP

External grooving and threading toolholder, with high pressure coolant capability



Metric	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

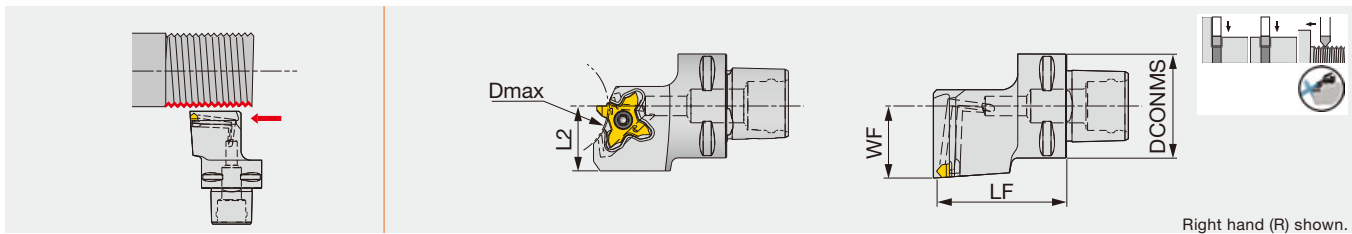
Torque* : Recommended clamping torque (N·m)

Applicable for 14 MPa coolant

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

C-STCR/L-18-CHP

External grooving and threading toolholder, with high pressure coolant capability



Metric	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.

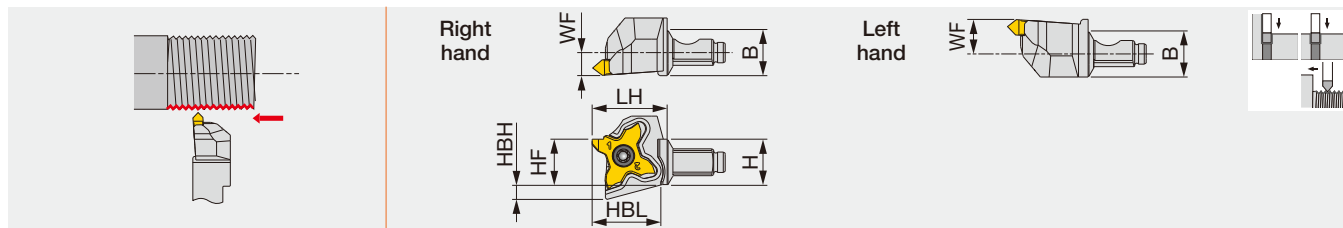
Note: Use the right-hand insert (TC*18R...) for a right-hand holder (STCR...); the left-hand insert (TC*18L...) for a left-hand holder (STCL...).

SPARE PARTS

Designation	Clamping screw	Wrench
C*STCL**-18-CHP	CSTC-4L100DR	T-1008/5
C3STCFL**-18-CHP, C*STCR**-18-CHP	CSTC-4L100DL	T-1008/5

Reference pages: Inserts → **E012**

External grooving and threading head



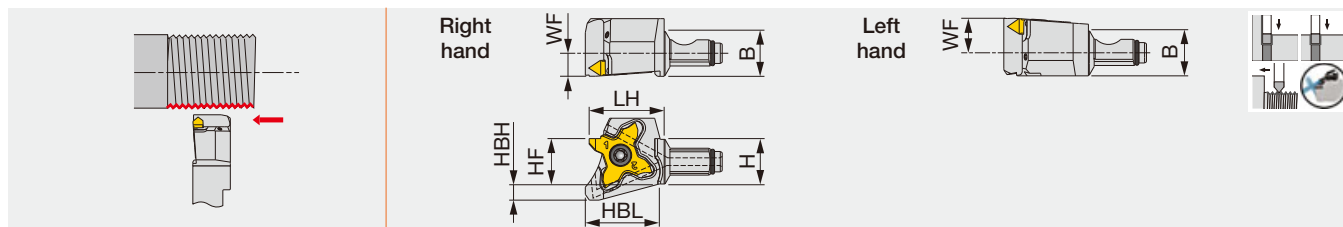
Metric	H	B	LH	HF	HBH	HBL	WF	Insert	Torque*
QC12-STCR18	12 (0.472")	12 (0.472")	19.5 (0.768")	12 (0.472")	3.9 (0.154")	17.9 (0.705")	6 (0.236")	TC*18R...	1.2 (0.89)
QC12-STCL18	12 (0.472")	12 (0.472")	21 (0.827")	12 (0.472")	3.9 (0.154")	18.3 (0.720")	9 (0.354")	TC*18L...	1.2 (0.89)

Torque* : Recommended clamping torque; N·m (lbs·ft)

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...).

QC12-STCR/L-CHP

External grooving and threading head, with high pressure coolant capability



Metric	H	B	LH	HF	HBH	HBL	WF	Insert	Torque*
QC12-STCR18-CHP	12 (0.472")	12 (0.472")	19.5 (0.768")	12 (0.472")	4.2 (0.165")	19.3 (0.760")	6 (0.236")	TC*18R...	1.2 (0.89)
QC12-STCL18-CHP	12 (0.472")	12 (0.472")	21 (0.827")	12 (0.472")	4.2 (0.165")	19.3 (0.760")	9 (0.354")	TC*18L...	1.2 (0.89)

Torque* : Recommended clamping torque; N·m (lbs·ft)

Through-coolant head

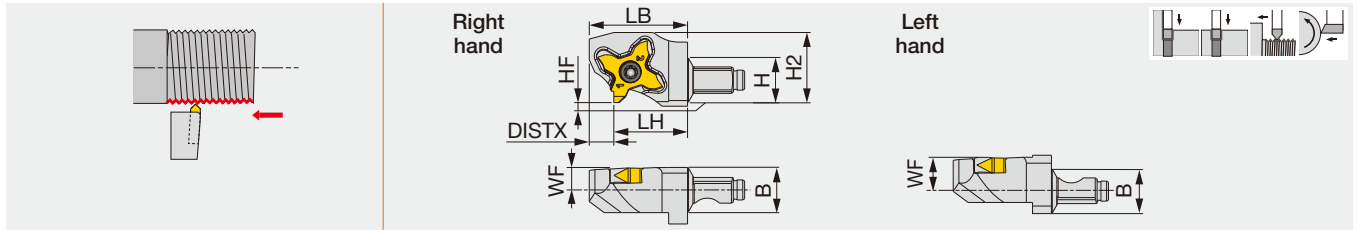
Note: Use the right-hand insert (TC*18R...) for a right-hand holder (QC12-STCR...); the left-hand insert (TC*18L...) for a left-hand holder (QC12-STCL...).

SPARE PARTS

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

QC12-STCR/L-Y

Y-axis turning modular head for external grooving and threading



Metric	H	B	LH	HF	WF**	LB	H2	DISTX	Insert	Torque*
QC12-STCR/L18-Y	12 (0.472")	12 (0.472")	19.5 (0.768")	0 (0")	6/9 (0.236" / 0.354")	26 (1.024")	18.6 (0.732")	6.5 (0.256")	TC*18...	1.2 (0.89)

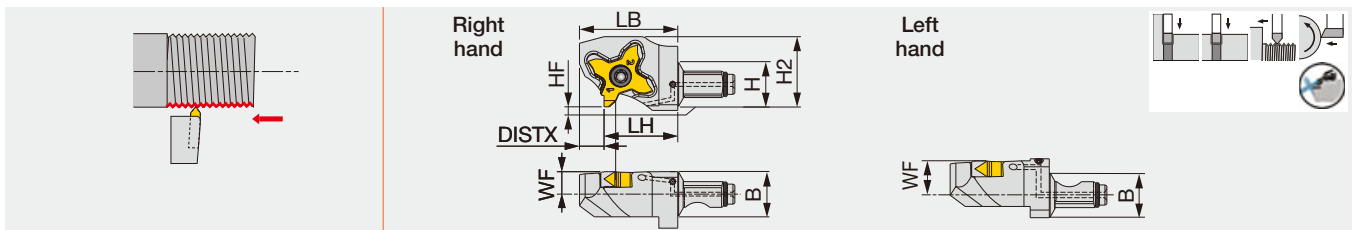
Torque* : Recommended clamping torque: N·m (lbs·ft)

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...).

QC12-STCR/L-Y-CHP

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



Metric	H	B	LH	HF	WF**	LB	H2	DISTX	Insert	Torque*
QC12-STCR/L18-Y-CHP	12 (0.472")	12 (0.472")	19.5 (0.768")	0 (0")	6 (0.236")	26 (1.024")	18.6 (0.732")	6.5 (0.256")	TC*18...	1.2 (0.89)

Torque* : Recommended clamping torque: N·m (lbs·ft)

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

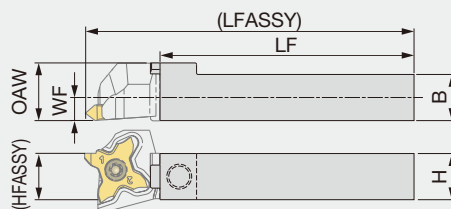
Note: Use the right-hand insert (TC*18R...) for a right-hand holder (QC12-STCR...); the left-hand insert (TC*18L...) for a left-hand holder (QC12-STCL...).

SPARE PARTS

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

Reference pages: Inserts → **E012**

Shank for modular heads



Inch	H	B	WF	LF	OAW	HFASSY	LFASSY ⁽¹⁾	Torque
QC-08F	0.500	0.500	0.236	2.559	0.591	0.500	3.346	2.21
QC-08X	0.500	0.500	0.236	3.937	0.591	0.500	4.724	2.21
Metric	H	B	WF	LF	OAW	HFASSY	LFASSY ⁽¹⁾	Torque*
QC-1212F	12	12	6	65	15	12	85	3
QC-1212X	12	12	6	100	15	12	120	3

Torque: Recommended clamping torque: lbs-ft (*N·m)

(1) The size is true when the modular head with LH = 19.5 mm is mounted.

QC-1212-CHP

Shank for modular heads, with high pressure coolant capability

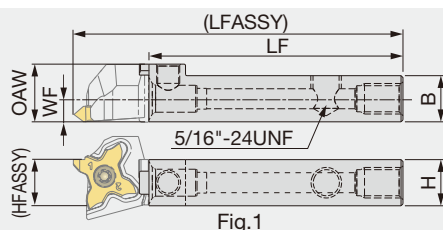


Fig.1

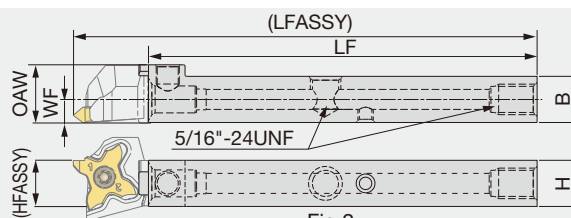


Fig.2

Inch	H	B	LF	WF	OAW	HFASSY	LFASSY ⁽¹⁾	Torque	Fig.
QC-08F-CHP	0.500	0.500	2.559	0.236	0.591	0.500	3.346	2.21	1
QC-06H-CHP ^(*)	0.375	0.500	3.268	0.197	0.512	0.375	3.937	1.84	2
QC-08X-CHP ^(*)	0.500	0.500	3.937	0.236	0.591	0.500	4.724	2.21	2
QC-10X-CHP ^(*)	0.625	0.625	3.897	0.315	0.787	0.625	4.724	6.27	2
Metric	H	B	LF	WF	OAW	HFASSY	LFASSY ⁽¹⁾	Torque*	Fig.
QC-1212F-CHP	12	12	65	6	15	12	85	3	1
QC-1212X-CHP ^(*)	12	12	100	6	15	12	120	3	2

Torque: Recommended clamping torque: lbs-ft (*N·m)

Through-coolant shank

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

(1) The size is true when the modular head with LH = 19.5 mm is mounted.

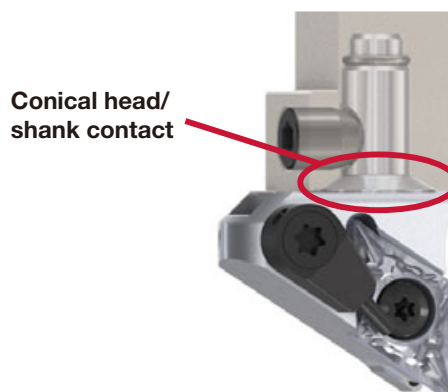
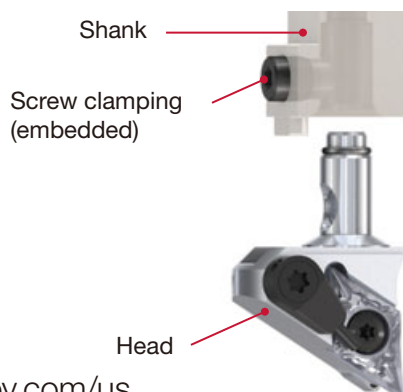
SPARE PARTS

Designation	Clamping screw	Wrench 1	Coolant plug	Wrench 2	DirectJet plug	Wrench 3
QC-08F/X, QC-1212*	SRM6X0.5-26977	P-3	-	-	-	-
QC-06H-CHP	SRM5X0.5	P-2.5	SR 5/16UNF TL360	P-4	SSHM4-4-TB	P-2
QC-08F-CHP, QC-1212F-CHP	SRM6X0.5-26977	P-3	SR5/16UNFTL360	P-4	-	-
QC-08X-CHP, QC-1212X-CHP	SRM6X0.5-26977	P-3	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2
QC-10X-CHP	SRM8X0.5	P-5	SR 5/16UNF TL360	P-4	SSHM4-6-TB	P-2

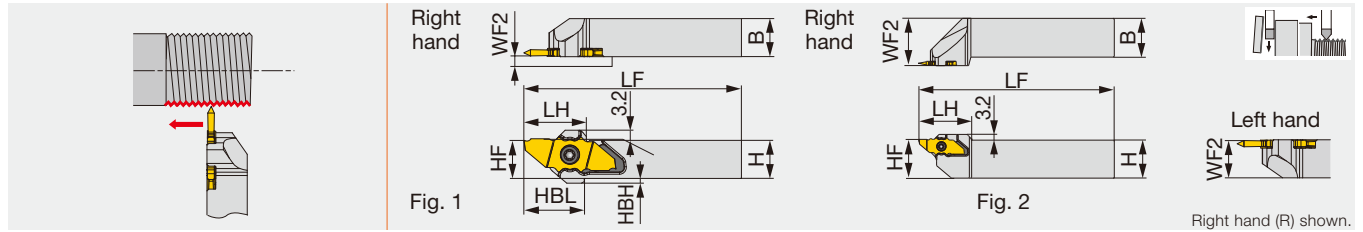
Unique coupling design

Simply loosen the clamping screw for easy tool exchanges.

Unique coupling design allows extremely high repeatability.



Threading and parting toolholder, for Swiss lathes



Inch	H	B	LF*	LH	HF	WF2 ⁽¹⁾	HBL	HBH	Insert	Torque	Fig.
JSXXR/L063	0.375	0.375	4.646	0.774	0.375	0.008 / 0.386	0.748	0.12	JX...	0.89	1
JSXXR/L083	0.500	0.500	3.268	0.774	0.500	0.008 / 0.386	0.748	0.06	JX...	0.89	1
JSXXR/L103	0.625	0.625	4.646	0.774	0.625	0.008 / 0.386	-	0.06	JX...	0.89	1
JSXXR/L123	0.750	0.750	3.950	0.886	0.750	0.008 / 0.742	-	-	JX...	0.89	1
JSXXR/L163	1.000	1.000	5.350	1.339	1.000	1.250 / 1.250	-	-	JX...	0.89	2

Metric	H	B	LF	LH	HF	WF2 ⁽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

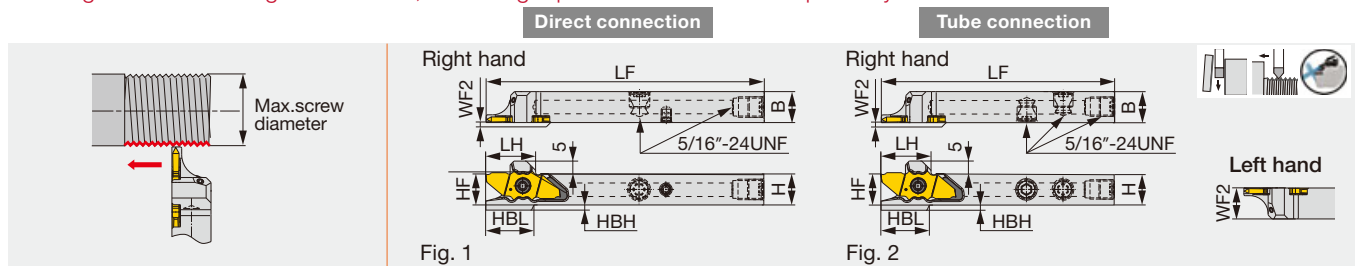
Torque: Recommended clamping torque: lbs-ft (*N·m)

(1) The first value before "/" indicates the WF2 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...).

JSXXR/L-F/H/X-CHP

Parting and threading toolholder, with high pressure coolant capability



Inch	H	B	LF	LH	HF	WF2 ⁽¹⁾	HBL	HBH	Insert	Torque	Fig.
JSXXR/L083X-CHP	0.500	0.500	4.750	≤ 0.764	0.500	0.008/0.492	0.736	0.051	JX**06...,12...,16...	0.89	1
JSXXR/L103X-CHP	0.625	0.625	4.750	≤ 0.764	0.625	0.008/0.617	0.736	0	JX**06...,12...,16...	0.89	1
JSXXR/L083F-CHP	0.500	0.500	3.344	≤ 0.764	0.5	0.008/0.492	0.736	0.051	JX*G06...,12...,16..., 20...	0.89	1

Metric	H	B	LF	LH	HF	WF2 ⁽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
JSXXR1616X09-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: lbs-ft (*N·m)

(1) The first value before "/" indicates the WF2 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

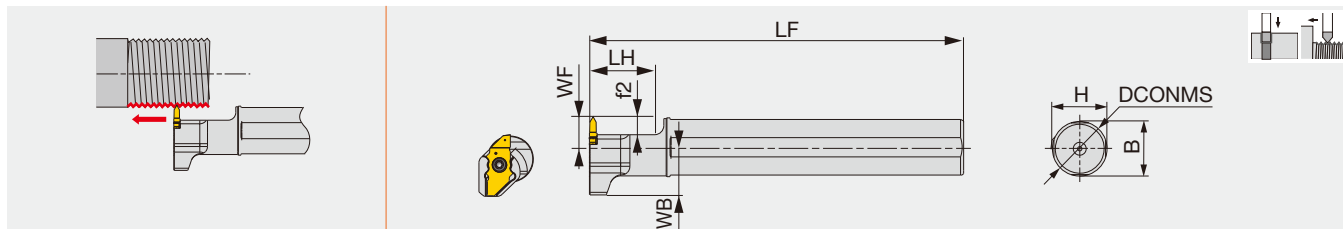
Note: Use the right-hand insert (JX***R...) for a right-hand holder (JSXXR...); the left-hand insert (JX***L...) for a left-hand holder (JSXXL...).

SPARE PARTS

Designation	Clamping screw	Wrench 1	Coolant plug	Wrench 2	DirectJet plug	Wrench 3
JSXXR...	CSTC-4L100DL	T-1008/5	-	-	-	-
JSXXL...	CSTC-4L100DR	T-1008/5	-	-	-	-
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

Reference pages: Inserts → **E012**

External threading toolholder, for 2 corner inserts

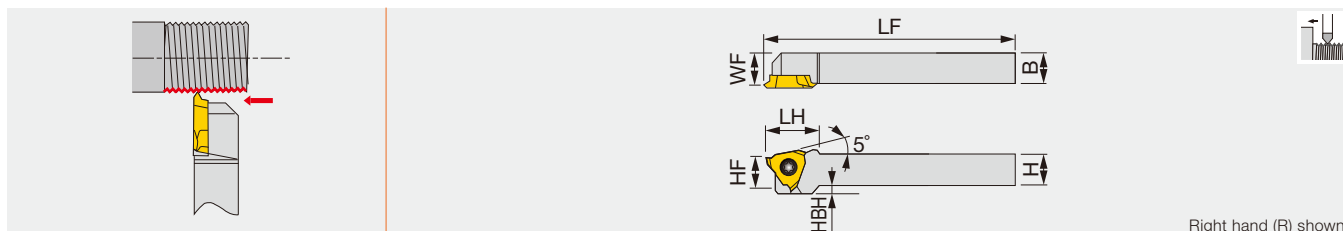


Metric	DCONMS	H	B	LF	LH	WB	WF	f2	Insert	Torque*
JS19G-SXXL09	19.05	18	18	90	21	15.43	8	4	JX**12...	1.2
JS19X-SXXL09	19.05	18	18	120	21	15.43	8	4	JX**12...	1.2
JS20G-SXXL09	20	19	19	90	21	15.4	8	4	JX**12...	1.2
JS20X-SXXL09	20	19	19	120	21	15.4	8	4	JX**12...	1.2
JS22X-SXXL09	22	21	21	120	21	15.4	8	4	JX**12...	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)

J-SERIES
JSTTR/L

External toolholder for Swiss lathes



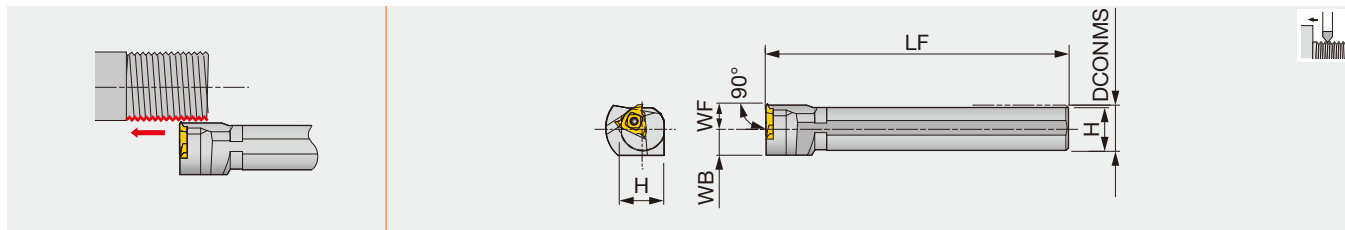
Inch	H	B	LF	LH	HF	WF	HBH	Insert
JSTTR/L063	0.375	0.375	5.000	0.6875	0.375	0.375	0.100	JTTR/L30...
JSTTR/L083	0.500	0.500	5.000	0.6875	0.500	0.500	-	JTTR/L30...
JSTTR/L103	0.625	0.625	5.000	0.6875	0.625	0.625	-	JTTR/L30...

Metric	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: 0.89 lbs-ft (1.2 N-m)

SPARE PARTS

Designation	Clamping screw 1	Clamping screw 2	Wrench 1	Wrench 2	Wrench 2 (Optional)
JSTTR/L...	-	CSTB-4SD	-	T-8F	(T-8L)
JS***-SXXL09	CSTC-4L055L	-	T-1008/5	-	-

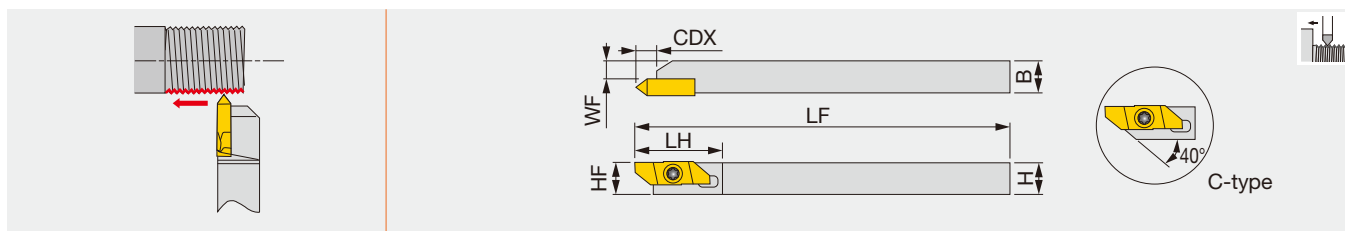


Metric	DCONMS	WF	LF	H	WB	Insert
JS19K-TTL3	19.05	10	125	18	11.5	JTTR30...
JS20K-TTL3	20	10	125	19	11.5	JTTR30...
JS22K-TTL3	22	10	125	21	11.5	JTTR30...
JS25K-TTL3	25.4	10	125	24	12.7	JTTR30...

Recommended clamping torque: 3.5 N·m

JSXBR

External threading toolholder for Swiss lathes



Metric	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.

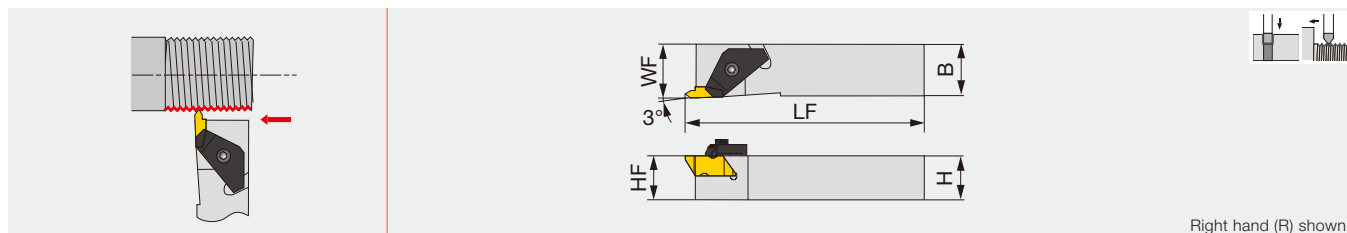
SPARE PARTS

Designation	Clamping screw	Wrench 1	Wrench 2 (Optional)
JS**-TTL3	CSTB-4S	T-15F	-
JSXBR...	CSTB-4SD	T-8F	(T-8L)

TUNGST-CLAMP

FLASR/L

External grooving and threading toolholder, for Swiss lathes



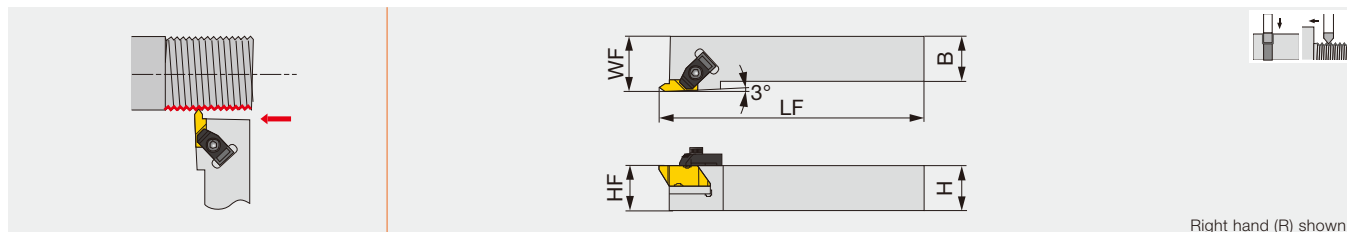
Inch	HF	H	B	LF	WF	Insert	Torque
FLASR/L-082B	0.500	0.500	0.500	6.000	0.500	FL*-3**R/L...	2.21
FLASR-102B	0.625	0.625	0.625	4.500	0.625	FL*-3**R...	2.21
FLASR/L-103B	0.625	0.625	0.625	4.500	0.625	FL*-3**R/L...	2.21
Metric	H	B	LF	HF	WF	Insert	Torque*
FLASR/L-1616M3	16	16	125	16	16	FLT-3...	3

Torque* : Recommended clamping torque: lbs-ft (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...).

FLSR/L

External grooving and threading toolholder



Inch	H	B	LF	HF	WF	Insert	Torque
FLSR/L-122B	0.750	0.750	4.500	0.750	1.000	FL*-3**R/L...	2.21
FLSR/L-162C	1.000	1.000	5.000	1.000	1.250	FL*-3**R/L...	2.21
FLSR/L-123B	0.750	0.750	4.500	0.750	1.000	FL*-3**R/L...	2.21
FLSR/L-163C	1.000	1.000	5.000	1.000	1.250	FL*-3**R/L...	2.21
FLSR/L-164D	1.000	1.000	6.000	1.000	1.250	FL*-3**R/L...	2.21
FLSR/L-203D	1.250	1.250	6.000	1.250	1.500	FL*-4**R/L...	2.21
FLSR/L-204D	1.250	1.250	6.000	1.250	1.500	FL*-4**R/L...	2.21
FLSR/L-206D	1.250	1.250	6.000	1.250	1.500	FL*-4**R/L...	2.21
FLSR/L-82V	0.500	0.500	3.500	0.750	0.750	FL*-4**R/L...	2.21
Metric	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: lbs-ft (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...).

Inch SPARE PARTS

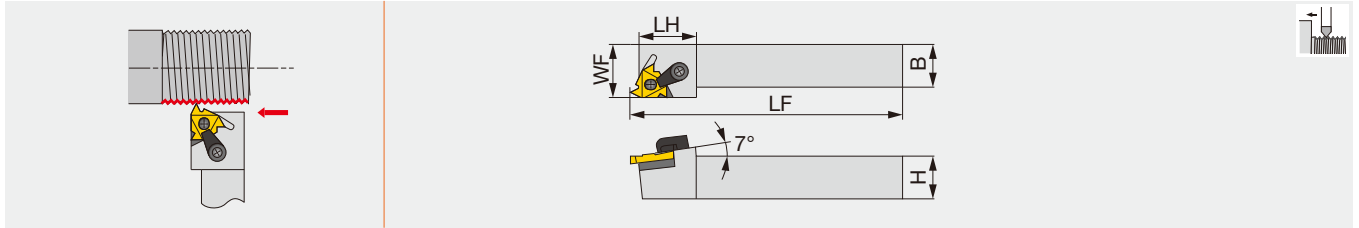
Designation	Clamp	Clamping screw	Wrench
FLASR-102B, FLASR-103B	TF-184	S-412	5/32HEX
FLASL-103B	TF-185	S-412	5/32HEX
FLSR-122B, FLSR-162C, FLSR-82V	TF-74	S-310	7/64HEX
FLSL-122B, FLSL-162C, FLSL-82V	TF-75	S-310	7/64HEX
FLSR-123B, FLSR-163C, FLSR-164D, FLSR-204D	TF-72	S-412	5/32HEX
FLSL-123B, FLSL-163C, FLSR-203D	TF-73	S-412	5/32HEX

Metric SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
FLASR-1616M3	TF-184	S-412	5/32HEX
FLASL-1616M3	TF-185	S-412	5/32HEX
FLSR-****M3	TF-72	S-412	5/32HEX
FLSL-****M3	TF-73	S-412	5/32HEX

Reference pages: Inserts → **E014**

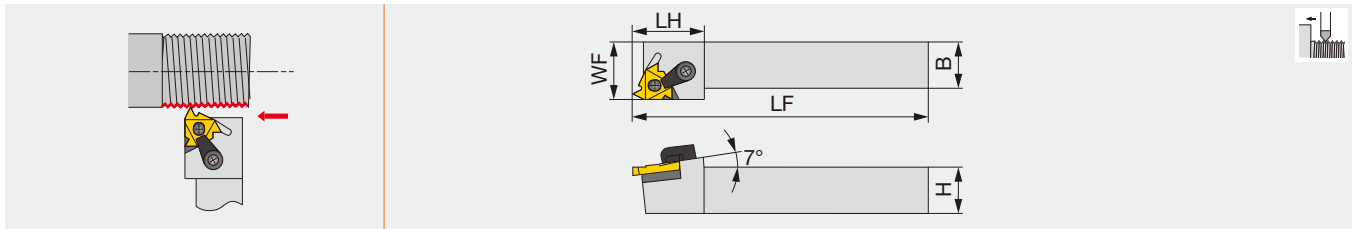
External threading toolholder, for single-sided lay down inserts



Inch	B	H	LF	LH	WF	Insert
MTVNR-2054	1.250	1.250	7.000	1.530	1.500	L535B**EXT-FC
MTVNR-2454	1.500	1.500	7.084	1.429	1.750	L535B**EXT-FC
Metric	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

MTVNR-54

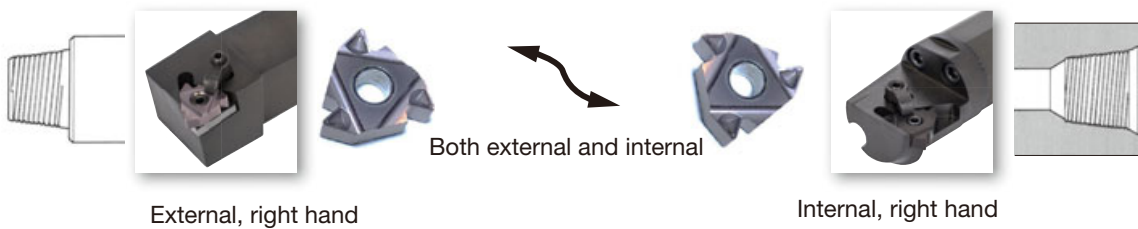
External threading toolholder, for double-sided lay down inserts



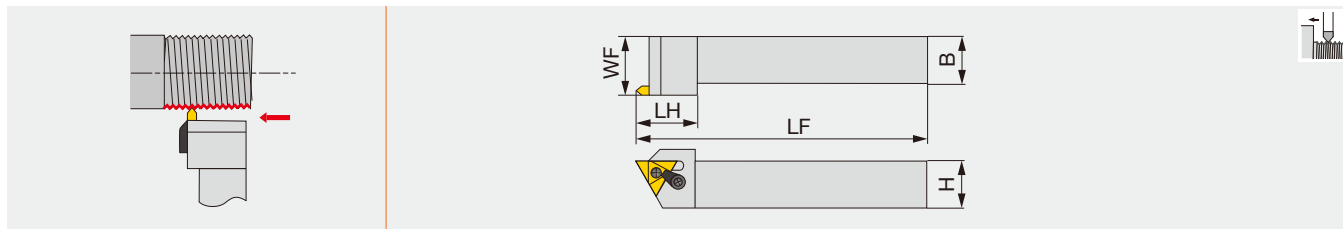
Metric	H	B	LF	LH	WF	Insert
MTVNR-3232M54	32	32	178	39	38.1	LDS54**FT-CB#...

SPARE PARTS

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



Multi-clamp external threading toolholder, for on edge inserts



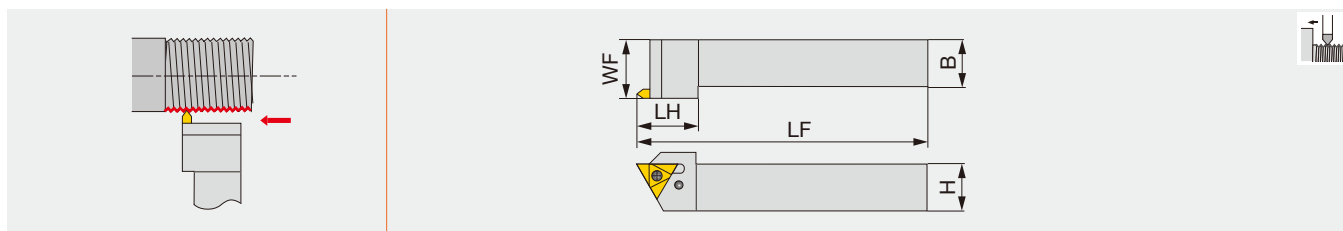
Inch	H	B	LF	LH	WF	Insert
MTVOR-164	1.000	1.000	6.000	1.230	1.250	TNM*43...
MTVOR-204	1.250	1.250	7.000	1.230	1.500	TNM*43...
MTVOR-205	1.250	1.250	7.000	1.430	1.500	TNM*54...
MTVOR-206	1.250	1.250	7.000	1.620	1.500	TNM*66...
MTVOR-2069	1.250	1.250	7.000	1.620	1.500	TNM*69...

Metric	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.

STVOR

Screw-on external threading toolholder, for on edge inserts



Inch	H	B	LF	LH	WF	Insert
STVOR-165	1.000	1.000	6.000	1.430	1.250	TNMC54...
STVOR-206	1.250	1.250	7.000	1.620	1.500	TNMC66...

Metric	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...

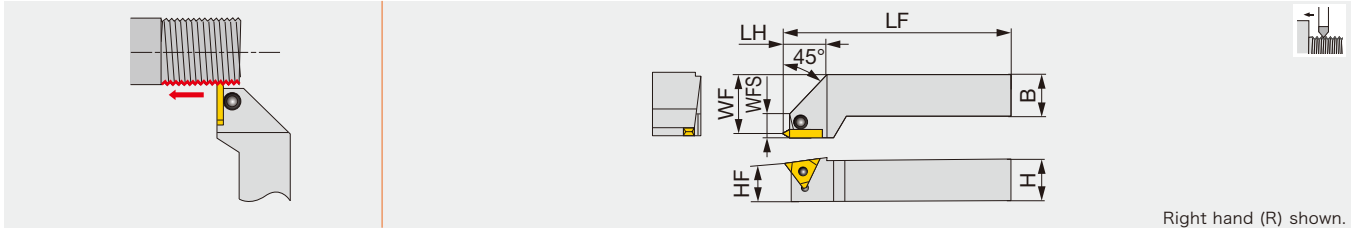
SPARE PARTS

Designation	Clamping screw	Lock pin	Wrench 1	Wrench 2	Clamp (Optional)	Clamping screw (Optional)
MTVOR-164/204, MTVOR-**M4	-	NL-44	-	3/32HEX	TC-190	STC-5
MTVOR-205, MTVOR-**M5	-	NL-56	-	1/8HEX	TC-250	STC-11
STVOR-**M4	SD2	-	T-20TORX	3/32HEX	TC-190	STC-9
STVOR-165	SD3	-	T-20TORX	1/8HEX	TC-250	STC-11
STVOR-206	SD4	-	-	1/8HEX, 5/32HEX	TC-310	STC-8

Reference pages: Inserts → [E029](#) - [E031](#), [E033](#)

TT-R/LE

TT-type pin-lock external threading toolholder

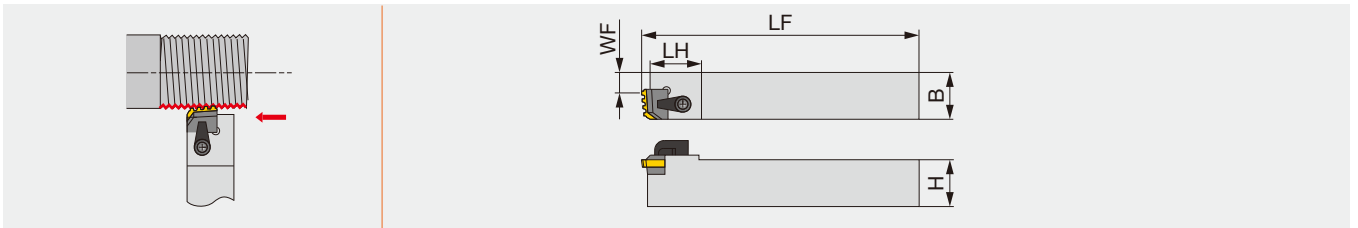


Right hand (R) shown.

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

CLVOR

External threading toolholder, for chaser inserts



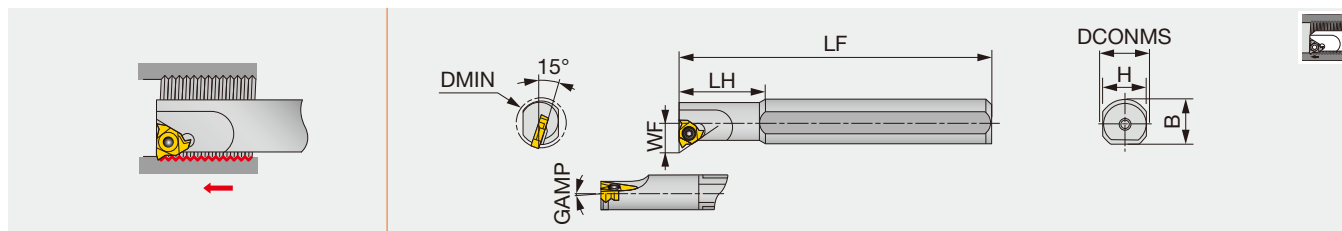
Inch	WF	LF	LH	H	B	Insert
CLVOR-208	0.800	7.000	1.250	1.250	1.250	CR***

Metric	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 1	 Clamp 2	 Clamping screw	 Wrench 1	 Wrench 2
TT-2525R/LE	-	-	CP91	-	DS-6	-	P-3
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-208, CLVOR-40M8	TF8132-E	SF60	-	TC-311	STC-4	T-20TORX	5/32HEX

Reference pages: TT-R/LE : Inserts → **E014, E016**
CLVOR : Inserts → **E026, E031 - E034**



Inch	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMP	Coolant hole	Insert
SIR0375K11	Steel	0.470	0.620	0.260	5.000	1.000	0.574	-	1.5°	Without	11IR...
SIR0375K11B	Steel	0.470	0.625	0.280	5.000	0.980	0.574	-	1.5°	With	11IR...
SIR0500M16B	Steel	0.640	0.625	0.390	6.000	1.260	0.472	-	1.5°	With	16IR...
SIR0625P16B	Steel	0.750	0.750	0.450	7.000	1.570	0.709	-	1.5°	With	16IR...
SIR0750P16	Steel	1.000	0.750	0.510	7.000	-	0.984	-	1.5°	Without	16IR...
SIR0750P16B	Steel	0.900	0.750	0.900	7.000	-	1.181	-	1.5°	With	16IR...
SIR0750P22	Steel	0.950	0.750	0.510	7.000	-	1.260	-	1.5°	Without	22IR...
SIR1000R16B	Steel	1.160	1.000	0.650	8.000	-	1.570	-	1.5°	With	16IR...
SIR1000R22	Steel	1.200	1.000	0.710	8.000	-	-	-	1.5°	Without	22IR...
SIR1250S16	Steel	1.420	1.250	0.770	10.00	-	-	-	1.5°	Without	16IR...
SIR1250S22	Steel	1.500	1.250	0.850	10.00	-	-	-	1.5°	Without	22IR...
SIR 1500 T27	Steel	1.800	1.500	1.000	12.00	-	-	-	1.5°	Without	27IR...

Metric	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.

Applicable thread size

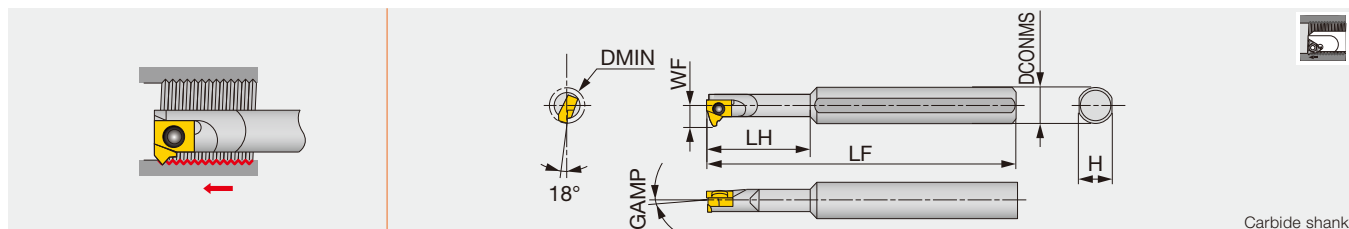
Description	ISO metric	Unified IRA60 Insert	Parallel pipe IRA55 Insert
SIR0005H06...	≥ M9	≥ 3/8-24 UNF	≥ G1/8
SIR0007K08...	≥ M11	≥ 7/16-20 UNF	≥ G1/4

SPARE PARTS

Designation	Clamping screw	Shim	Shim screw	Wrench	Seal cap
SIR0500M16B	SR5-40-L9.7-S16S	-	-	T-10/5	PL062
SIR0625P16B	SR 5-40-L9.7-S16S	-	-	T-10/5	PL 075
SIR0750P16	SR5-40-L12.2S16	AI16	SR5-40-L6.8-A16	T-10/5	-
SIR0750P16B	SR 5-40-L12.2-S16	AI16	SR 5-40-L6.8-A16	T-10/5	PL 075
SIR0750P22	SR8-32-L12-S22S	-	-	T-20/5	-
SIR1000R16B	SR 5-40-L12.2-S16	AI16	SR 5-40-L6.8-A16	T-10/5	PL 100
SIR1000R22	SR8-32-L15-S22	AI22	SR8-32-L5.8-A22	T-20/5	-
SIR1250S16	SR 5-40-L12.2-S16	AI16	SR 5-40-L6.8-A16, SR 8-32-L5.8-A22	T-10/5	-
SIR1250S22	SR8-32-L15-S22	AI22	SR8-32-L5.8-A22	T-20/5	-
SIR 1500 T27	SRM5-L22-S40	AI27	SRM5-L5.8-A27	T-25/3	-
SIR0005H06...	SR 14-552	-	-	T-6F-S	-
SIR0007K08...	SR 14-558	-	-	T-6F-S	-

SNR-2/3

Screw-on internal threading toolholder

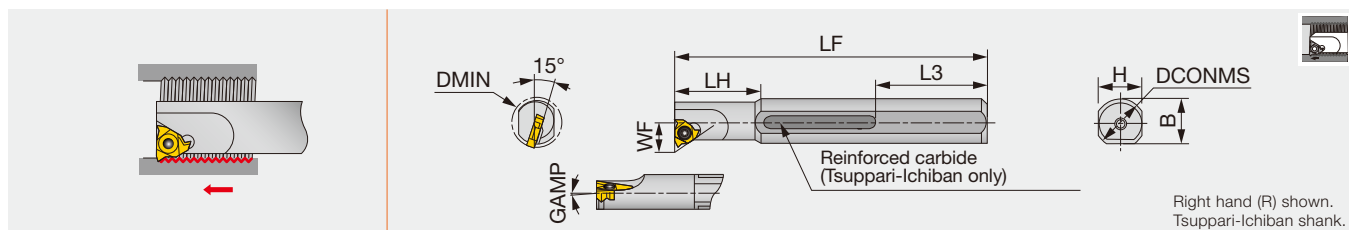


Metric	Material	DMIN	DCONMS	WF	LF	LH	H	GAMP	Insert
SNR0006H06-2	Steel	8	8	4.7	100	18	7	2°	6IR...
SNR0006H06-3	Steel	8	8	4.7	100	18	7	3°	6IR...
SNR0008H06-2	Steel	10	8	5.7	100	18	7	2°	6IR...
SNR0008H06-3	Steel	10	8	5.7	100	18	7	3°	6IR...
SNR0006K06SC-2	Carbide	8	8	4.7	125	30	7	2°	6IR...
SNR0006K06SC-3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

SNR/L

Screw-on internal threading toolholder



Metric	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...).

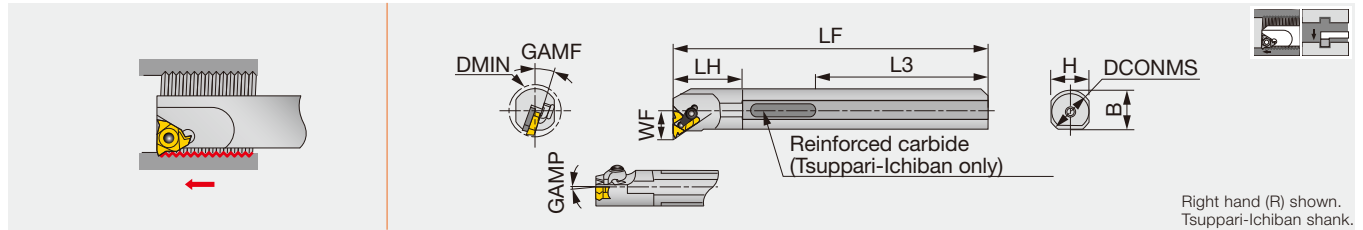
SPARE PARTS

Designation	Clamping screw	Wrench
SNR0006H06..., SNR0006K06SC...	CSTB-2L040	T-6F
SNR0008H06..., SNR0008K06SC...	CSTB-2L	T-6F
TSNR0016Q16, SNR/L0016M16..., SNR/L0016R16SC...	CSTB-3.5	T-15F
TSNR0020R22, SNR/L0020Q22...	CSTB-4	T-15F
SNR/L00**11..., SNR00**11SC...	CSTB-2.5	T-8F

Reference pages: SNR-2/3 : Inserts → E010, E015, E017, E023 - E025

SNR/L : Inserts → E010 - E011, E015, E017 - E019, E021 - E032

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



Right hand (R) shown.
Tsuppari-Ichiban shank.

Metric	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.

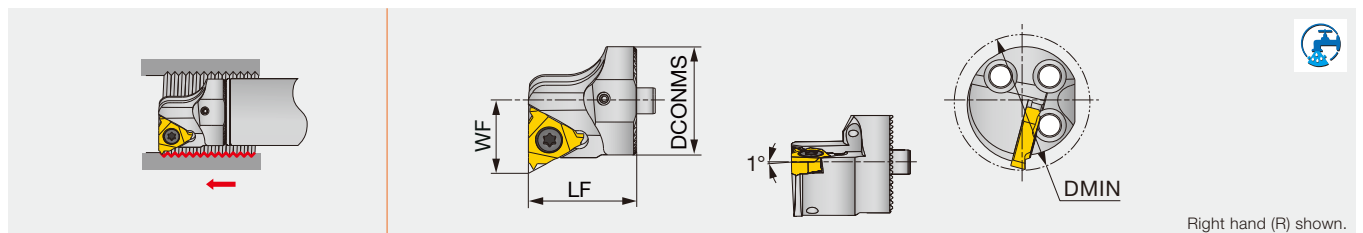
Use the right-hand insert (**IR...) for a right-hand holder (CNR...); the left-hand insert (**IL...) for a left-hand holder (CNL...).

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

BOREMEISTER

S-SNR-H

Screw-on clamp exchangeable boring head, for threading inserts



Metric	DMIN	DCONMS	WF	LF	Shank	Insert
S20-SNR16-H	25	20	14	25	D20	16IR...
S25-SNR16-H	32	25	17	25	D25	16IR...
S32-SNR16-H	40	32	22	32	D32	16IR...
S40-SNR16-H	50	40	27	32	D40, D50, D60	16IR...

SPARE PARTS

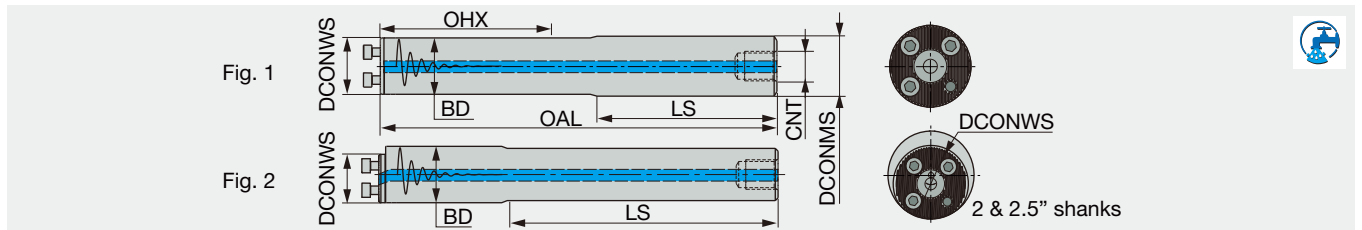
Designation	Clamp set	Clamping screw	Shim screw	Shim	Shim set R	Shim set L	Wrench 1	Wrench 2	Wrench 3
TCNR002**16DT	CSP16	CSTB-3.5ST	DTS5-3.5	A16-1DT	-	-	P-3.5	T-15F	-
TCNR0025S22DT	CSP22	CSTB-4ST	DTS6-4	GX22-1DT	-	-	P-4	T-15F	T-20F
CNR/L**16	CSP16	-	-	-	A16-1	A16-1	-	T-15F	-
CNR/L**22	CSP22	-	-	-	NXN22-1	NXE22-1	-	T-20F	-
CNR0040T27	CSP27	-	-	-	NXN27-1	NXE27-1	P-4	-	-
S**-SNR16-H	-	CSTB-3.5	-	-	-	-	-	T-15F	-

Reference pages: CNR/L : Inserts → **E010 - E011, E015, E017 - E019, E021 - E030**

S-SNR-H : Inserts → **E010 - E011, E015, E018 - E019, E021 - E030**

Straight Shank

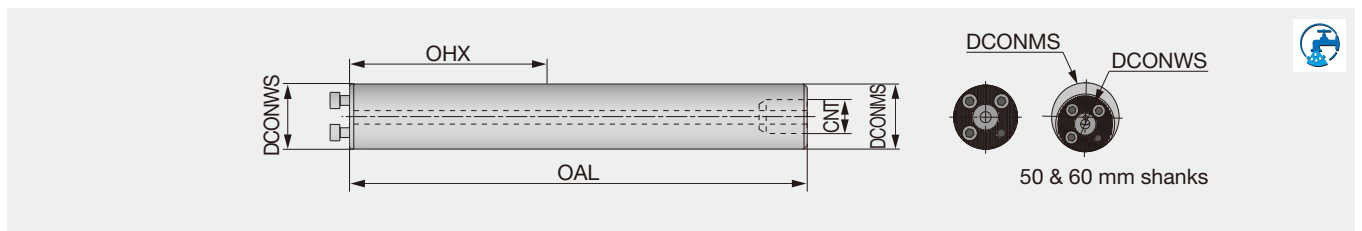
Anti-vibration bars with through coolant for interchangeable turning heads



Inch	Material	DCONWS	DCONMS	BD	OAL	LS	OHX	CNT	Fig.
D.625-L6.14-7D-C	Steel	0.630	0.625	0.630	6.140	3.600	3.500	G1/8	1
G.625-L8.03-10D-E	Carbide	0.630	0.625	0.630	8.030	5.220	5.500	-	1
D.750-L7.87-7D-C	Steel	0.787	0.750	0.787	7.870	4.940	4.400	G1/4	1
G.750-L10.24-10D-E	Carbide	0.787	0.750	0.787	10.240	6.770	7.000	-	1
D1.00-L10.2-7D-C	Steel	0.984	1.000	0.984	10.200	6.830	6.200	G1/4	1
D1.00-L13.21-10D-C	Steel	0.984	1.000	0.984	13.210	8.650	9.200	G1/4	1
D1.25-L12.48-7D-C	Steel	1.260	1.250	1.260	12.480	7.370	7.500	G3/8	1
D1.25-L16.24-10D-C	Steel	1.260	1.250	1.260	16.240	9.670	11.200	G3/8	1
D1.50-L15.26-7D-C	Steel	1.575	1.500	1.575	15.260	9.130	9.200	G1/2	1
D1.50-L19.8-10D-C	Steel	1.575	1.500	1.575	19.800	13.350	13.700	G1/2	1
D2.00-L20.74-7D-C	Steel	1.575	2.000	2.000	20.740	-	12.700	G1/2	2
D2.00-L26.73-10D-C	Steel	1.575	2.000	2.000	26.730	-	18.700	G1/2	2
D2.50-L26.2-7D-C	Steel	1.575	2.500	2.500	26.200	-	16.200	G3/4	2
D2.50-L33.72-10D-C	Steel	1.575	2.500	2.500	33.720	-	23.700	G3/4	2

Straight Shank

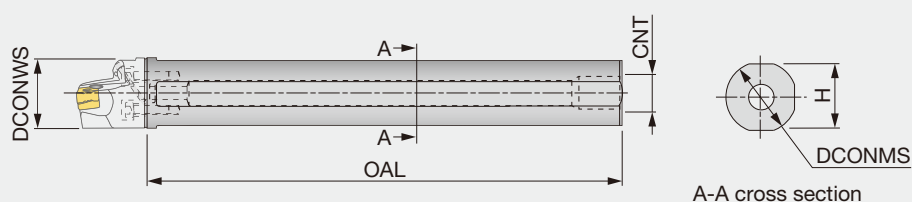
Anti-vibration bars with through coolant for interchangeable turning heads



Metric	Material	DCONWS	DCONMS	OAL	OHX	CNT
D16-L156-7D-C	Steel	16	16	156.3	92	G1/8
G16-L204-10D-E	Carbide	16	16	204.3	140	-
D20-L200-7D-C	Steel	20	20	200.3	120	G1/4
G20-L260-10D-E	Carbide	20	20	260.3	180	-
D25-L255-7D-C	Steel	25	25	257.5	155	G1/4
D25-L330-10D-C	Steel	25	25	332.5	230	G1/4
D32-L320-7D-C	Steel	32	32	323	192	G3/8
D32-L416-10D-C	Steel	32	32	419	288	G3/8
D40-L408-7D-C	Steel	40	40	411	248	G1/2
D40-L528-10D-C	Steel	40	40	531	368	G1/2
D50-L518-7D-C	Steel	40	50	523	318	G1/2
D50-L668-10D-C	Steel	40	50	673	468	G1/2
D60-L628-7D-C	Steel	40	60	633	388	G3/4
D60-L808-10D-C	Steel	40	60	813	568	G3/4

SPARE PARTS

Designation	Clamping screw	Wrench
D16-L..., G16-L..., D.625..., G.625...	SRM3X10DIN912	HW2.5
D20-L..., G20-L..., D.750..., G.750...	SR55-2M3.5X10	HW2.5
D25-L..., D1.00...	SRM4X12DIN912	HW3.0
D32-L..., D1.25...	SRM5X12DIN912	HW4.0
D40-L..., D50-L..., D60-L..., D1.50..., D2.00..., D2.50...	SRM6X16DIN912-12.9	HW5.0



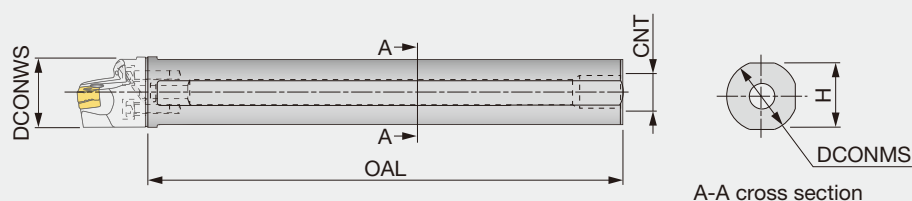
Inch	Material	DCONWS	DCONMS	OAL	CNT	H
D1.00-L7.2-4D-SH	Steel	1.000	1.000	7.200	UNF-2B 1/2"-20	0.921
D1.25-L8.74-4D-SH	Steel	1.250	1.250	8.740	UNF-2B 1/2"-20	1.142
D1.50-L10.75-4D-SH	Steel	1.575	1.500	10.75	UNF-2B 1/2"-20	1.339
D2.00-L14.72-4D-SH	Steel	1.575	2.000	14.72	UNF-2B 1/2"-20	1.811
D2.50-L18.74-4D-SH	Steel	1.575	2.500	18.74	UNF-2B 1/2"-20	2.283

SPARE PARTS



Designation	Clamping screw	Wrench
D1.00-L7.2-4D-SH	SR M4X12DIN912	HW 3.0
D1.25-L8.74-4D-SH	SR M5X12 DIN912	HW 4.0
D1.50-L10.75-4D-SH	SRM6X16DIN912-12.9	HW 5.0
D2.00-L14.72-4D-SH	SRM6X16DIN912-12.9	HW 5.0
D2.50-L18.74-4D-SH	SRM6X16DIN912-12.9	HW 5.0

D#4D-SH

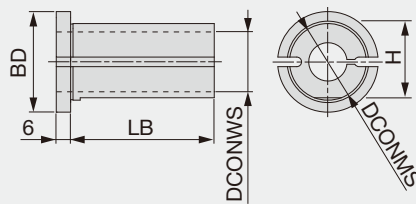


Metric	Material	DCONWS	DCONMS	OAL	CNT	H
D16-L105-4D-SH	Steel	16	16	105	UNC-2B 3/8"-16	15
D20-L140-4D-SH	Steel	20	20	140	UNFC-2B 3/8"-24	18
D25-L200-4D-SH	Steel	25	25	200	UNF-2B 1/2"-20	23
D32-L218-4D-SH	Steel	32	32	218	UNF-2B 1/2"-20	29
D40-L283-4D-SH	Steel	40	40	283	UNF-2B 1/2"-20	36

SPARE PARTS



Designation	Clamping screw	Wrench
D16**4D-SH	SRM3X10DIN912	HW2.5
D20**4D-SH	SR55-2M3.5X10	HW2.5
D25**4D-SH	SRM4X12DIN912	HW3.0
D32**4D-SH	SRM5X12DIN912	HW4.0
D40**4D-SH	SRM6X16DIN912-12.9	HW5.0



Inch	DCONWS	DCONMS	BD	LB	H
RSL-31.8-15.9-L66	0.625	1.250	1.654	2.362	1.210
RSL-31.8-19-L66	0.750	1.250	1.654	2.362	1.210
RSL-31.8-25.4-L66	1.000	1.250	1.654	2.362	1.210
RSL-38.1-15.9-L106	0.625	1.500	1.969	3.937	1.461
RSL-38.1-19-L106	0.750	1.500	1.969	3.937	1.461
RSL-38.1-25.4-L106	1.000	1.500	1.969	3.937	1.461
RSL-38.1-31.8-L106	1.250	1.500	1.969	3.937	1.461
RSL-50.8-19-L126	0.750	2.000	2.362	4.724	1.941
RSL-50.8-25.4-L126	1.000	2.000	2.362	4.724	1.941
RSL-50.8-31.8-L126	1.250	2.000	2.362	4.724	1.941
RSL-50.8-38.1-L126	1.500	2.000	2.362	4.724	1.941
RSL-63.5-31.8-L156	1.250	2.500	2.756	5.906	2.441
RSL-63.5-38.1-L156	1.500	2.500	2.756	5.906	2.441
RSL-63.5-50.8-L156	2.000	2.500	2.756	5.906	2.441
Metric	DCONWS	DCONMS	BD	LB	H
RSL-32-16-L66	16	32	42	60	31
RSL-32-20-L66	20	32	42	60	31
RSL-32-25-L66	25	32	42	60	31
RSL-40-16-L76	16	40	50	70	38.5
RSL-40-20-L76	20	40	50	70	38.5
RSL-40-25-L76	25	40	50	70	38.5

C#-SH-CHP / C#-SH-E-CHP

PSC compatible adapter with steel or carbide core

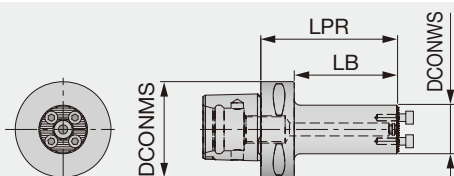


Fig. 1

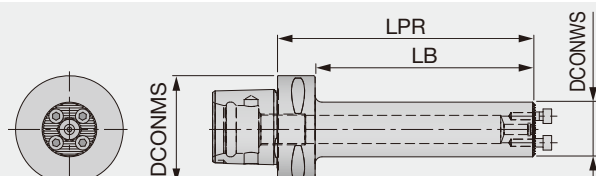


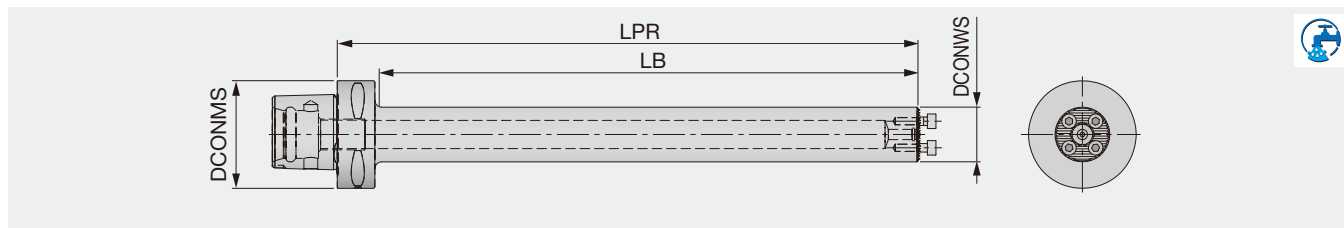
Fig. 2

Metric	Material	DCONWS	DCONMS	LPR	LB	Fig
C4-SH-D16-2.5D-CHP	Steel	16	40	40	20	1
C4-SH-D20-2.5D-CHP	Steel	20	40	50	30	1
C4-SH-D25-2.5D-CHP	Steel	25	40	55	35	1
C4-SH-D32-2.5D-CHP	Steel	32	40	75	55	1
C4-SH-D40-3D-CHP	Steel	40	40	80	80	1
C6-SH-D20-5D-E-CHP	Carbide	20	63	100	78	2
C6-SH-D25-5D-E-CHP	Carbide	25	63	115	93	2
C6-SH-D32-5D-E-CHP	Carbide	32	63	150	128	2
C6-SH-D40-5D-E-CHP	Carbide	40	63	185	163	2

SPARE PARTS



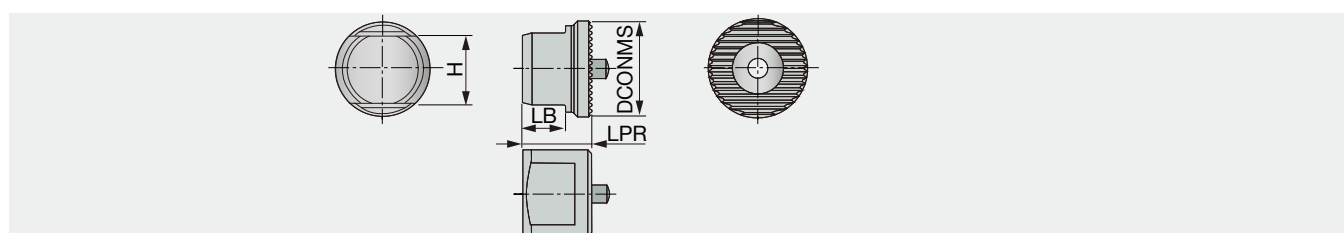
Designation	Clamping screw	Wrench
C4**D16...	SRM3X10DIN912	HW2.5
C4/C6**D20...	SR55-2M3.5X10	HW2.5
C4/C6**D25...	SRM4X12DIN912	HW3.0
C4/C6**D32...	SRM5X12DIN912	HW4.0
C4/C6**D40...	SRM6X16DIN912-12.9	HW5.0



Metric	Material	DCONWS	DCONMS	LPR	LB	WT (kg)
C6-D25-L230-9D-C	Steel	25	63	230.5	200.1	1.65
C6-D32-L288-9D-C	Steel	32	63	288.5	259.5	2.73
C6-D40-L368-9D-C	Steel	40	63	368.5	339	4.45

AVC-SET

Center height set up device



Metric	DCONMS	H	LPR	LB	Applicable shank
AVC-SET 16-25	20	15	14.5	8.9	16, 20, 25
AVC-SET 32-60	29	16	17.5	11.43	32, 40, 50, 60

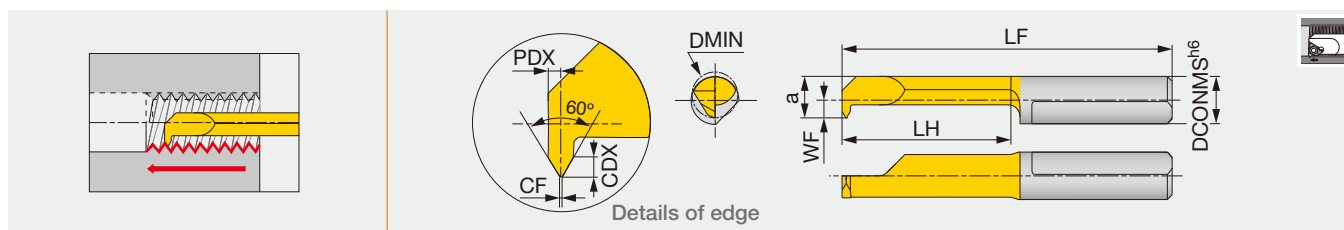
SPARE PARTS

Designation	Clamping screw	Wrench
C6-D25...	SRM4X12DIN912	HW3.0
C6-D32...	SRM5X12DIN912	HW4.0
C6-D40...	SRM6X16DIN912-12.9	HW5.0

TINYM^{INI}TURN

TBIR

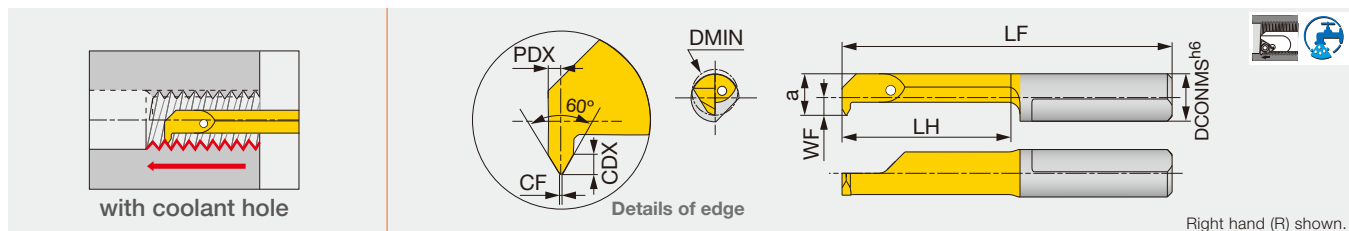
Solid boring bar for internal threading



Metric	SH725	Pitch	DMIN	CF- ⁰ _{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

Solid boring bars for threading (metric)

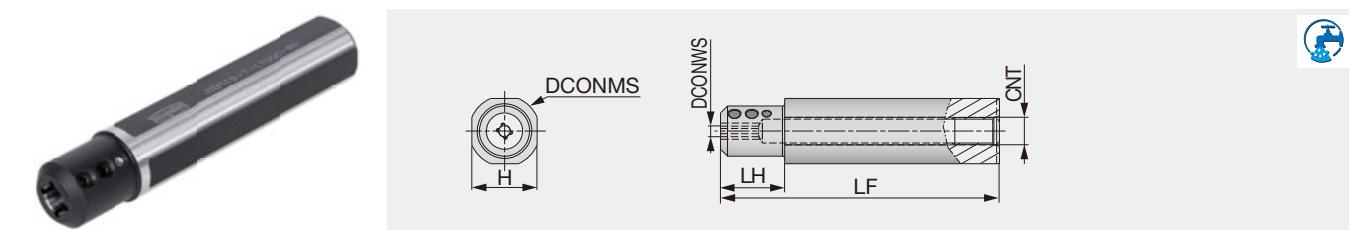


Metric	SH725	Pitch	DMIN	CF $\frac{0}{0.02}$	DCONMS	WF	a	LF	LH	CDX	PDX
JBIR04140050-D040	●	0.5	4	0.06	4	1.5	3.5	30	14	0.3	0.35
JBIR07140050-D050	●	0.5	5	0.06	7	0.9	4.4	30	14	0.3	0.35
JBIR07140075-D050	●	0.75	5	0.09	7	0.9	4.4	30	14	0.4	0.45
JBIR07140100-D048	●	1	4.8	0.12	7	0.9	4.4	30	14	0.6	0.55
JBIR07140100-D060	●	1	6	0.12	7	1.8	5.3	30	14	0.6	0.55
JBIR07140125-D060	●	1.25	6	0.15	7	1.8	5.3	30	14	0.7	0.65
JBIR07140150-D060	●	1.5	6	0.18	7	1.8	5.3	30	14	0.8	0.75
JBIR07140150-D070	●	1.5	7	0.18	7	2.8	6.3	30	14	0.8	0.75

● : Line up

JBBS-4N

Sleeve for internal coolant supply with 4 coolant holes



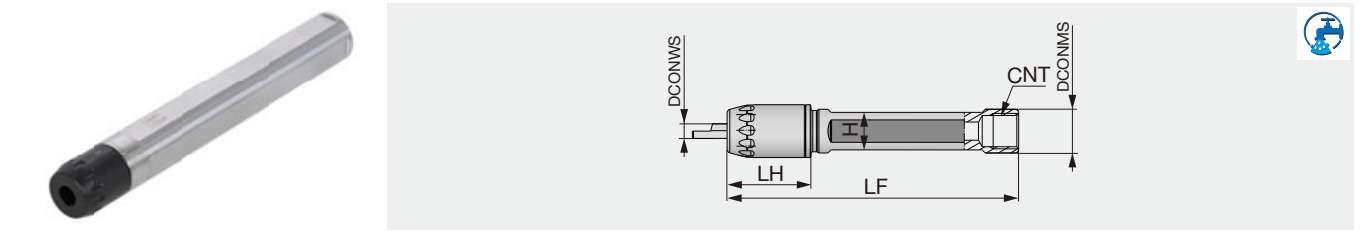
Metric	DCONMS	DCONWS	LF	LH	H	CNT
JBBS12-4-L80C-4N	12	4	80	10	10.3	Rc1/16
JBBS127-4-L80C-4N	12.7	4	80	10	11.6	Rc1/16
JBBS14-4-L80C-4N	14	4	80	10	12	Rc1/8
JBBS159-4-L100C-4N	15.875	4	100	10	14.58	Rc1/8
JBBS159-7-L100C-4N	15.875	7	100	10	14.58	Rc1/8
JBBS16-4-L100C-4N	16	4	100	10	15	Rc1/8
JBBS16-7-L100C-4N	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

JBBSA-C

Collet chuck sleeve with internal coolant supply



Metric	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

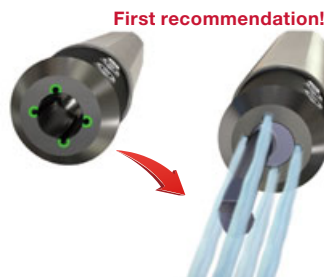
SPARE PARTS

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

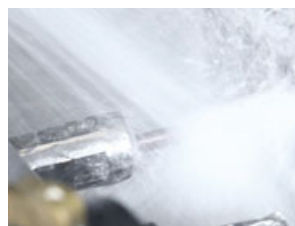


Excellent chip evacuation



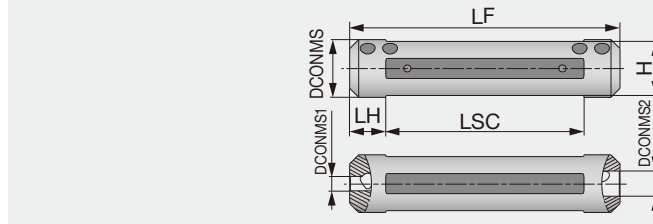
- No chip jamming
- No machine stoppage
- No downtime

Conventional (External coolant)



- Chip jamming
- Increased machine downtime

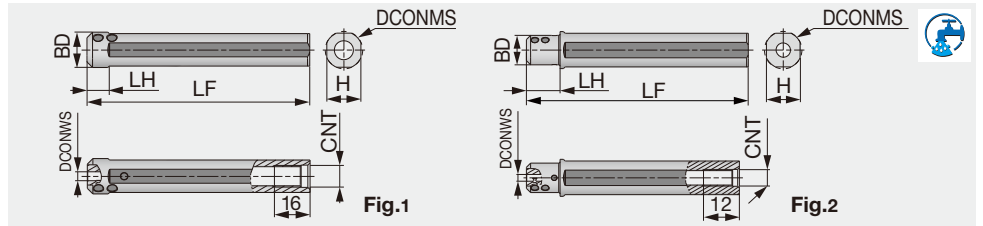
Sleeve for external coolant supply



Metric	DCONMS	DCONWS1	DCONWS2	LF	LH	LSC	H
JBBS12-4-4	12	4	4	75	10	55	10.3
JBBS127-4-4	12.7	4	4	76.2	10	56.2	11.6
JBBS14-4-4	14	4	4	75	10	55	12
JBBS159-4-7	15.875	4	7	76.2	10	56.2	14
JBBS16-4-7	16	4	7	75	10	55	15
JBBS19-4-7	19.05	4	7	89	10	69	17.2
JBBS20-4-7	20	4	7	90	10	70	18
JBBS22-4-7	22	4	7	90	10	70	20
JBBS25-4-7	25	4	7	100	10	80	23
JBBS254-4-7	25.4	4	7	90	10	70	23.4

JBBS-C

Sleeve for internal coolant supply

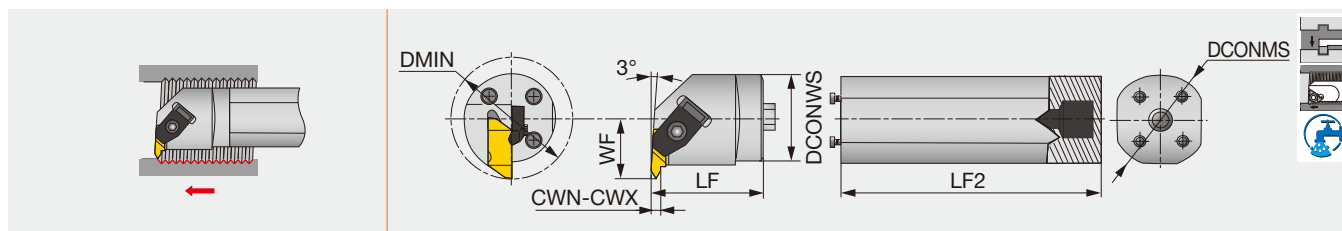


Metric	DCONMS	BD	DCONWS	LF	LH	H	CNT	Fig
JBBS159-4-L100C	15.875	15.875	4	100	10	14.58	Rc1/8	1
JBBS159-7-L100C	15.875	15.875	7	100	10	14.58	Rc1/8	1
JBBS16-4-L100C	16	16	4	100	10	15	Rc1/8	1
JBBS16-7-L100C	16	16	7	100	10	15	Rc1/8	1
JBBS19-4-L100C	19.05	17.5	4	100	20	17.2	Rc1/8	2
JBBS19-7-L100C	19.05	17.5	7	100	20	17.2	Rc1/8	2
JBBS20-4-L100C	20	17.5	4	100	20	18	Rc1/8	2
JBBS20-7-L100C	20	17.5	7	100	20	18	Rc1/8	2
JBBS22-4-L100C	22	17.5	4	100	20	20	Rc1/8	2
JBBS22-7-L100C	22	17.5	7	100	20	20	Rc1/8	2
JBBS25-4-L100C	25	18	4	100	23	23	Rc1/8	2
JBBS25-7-L100C	25	18	7	100	23	23	Rc1/8	2
JBBS254-4-L100C	25.4	18	4	100	23	23.4	Rc1/8	2
JBBS254-7-L100C	25.4	18	7	100	23	23.4	Rc1/8	2

SPARE PARTS



Designation	Clamping screw	Wrench
JBBS12-4-4, JBBS14-4-4 JBBS**-7-L100C	SSHM5-4PF-S	P-2.5
JBBS127-4-4, JBBS**-4-7 JBBS**-4-L100C	SSHM5-6PF-S	P-2.5



Metric	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

** Compatible with the BoreMeister system.

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 2	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

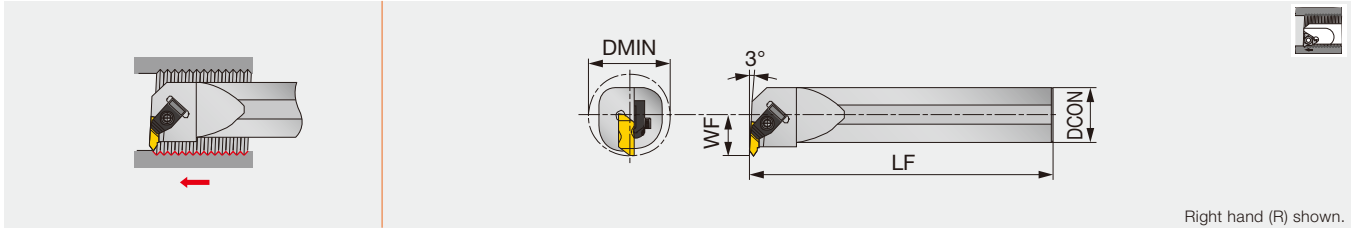


Designation	Clamping screw	Wrench
S-570-40M-40	SS100	5/32HEX
S-570-50M-50	SS94	1/4EX

TUNG-CLAMP

A_M-FLER/L

Internal grooving and threading toolholder



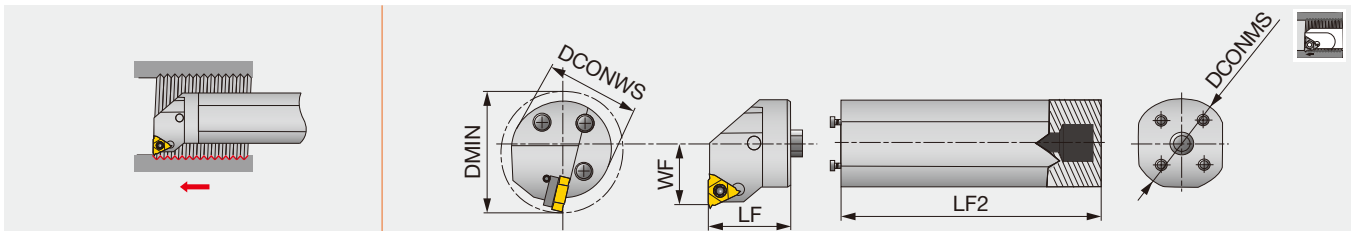
Right hand (R) shown.

Inch	Pitch	DMIN	DCON	LF	WF	Insert
A08-FLER/L2	0.031 - 0.125	0.730	0.500	8.000	0.437	FL*-2**L/R...
A10-FLER2	0.031 - 0.125	1.000	0.625	10.000	0.500	FL*-2**L...
A12-FLER/L2	0.031 - 0.128	1.125	0.750	10.000	0.562	FL*-2**L/R...
A16-FLER/L2	0.031 - 0.128	1.375	1.000	12.000	0.688	FL*-2**L/R...
A16-FLER/L3	0.031 - 0.250	1.375	1.000	12.000	0.688	FL*-3**L/R...
Metric	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...

TUNGTHREAD

HS-LNFR-53

Head exchangeable internal threading, for single-sided lay down inserts



Metric	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

* Compatible with the BoreMeister system.

Inch

SPARE PARTS

Designation	Clamp	Clamping screw	Wrench
A08-FLER2	TF-146	S-310	7/64HEX
A08-FLEL2	TF-147	S-310	7/64HEX
A10-FLER2, A12-FLER2, A16-FLER2	TF-75	S-310	7/64HEX
A12-FLEL2, A16-FLEL2	TF-74	S-310	7/64HEX
A16-FLER3	TF-73	S-412	5/32HEX
A16-FLEL3	TF-72	S-412	5/32HEX

Metric

SPARE PARTS

Designation	Lock pin	Clamp 1	Clamp 2	Clamping screw 1	Clamping screw 2	Wrench
A**M-FLER3	-	TF-73	-	S-412	-	5/32HEX
A**M-FLEL3	-	TF-72	-	S-412	-	5/32HEX
HS**-LNFR-53	NL-56	-	TC-250	-	STC-11	1/8HEX

Shank

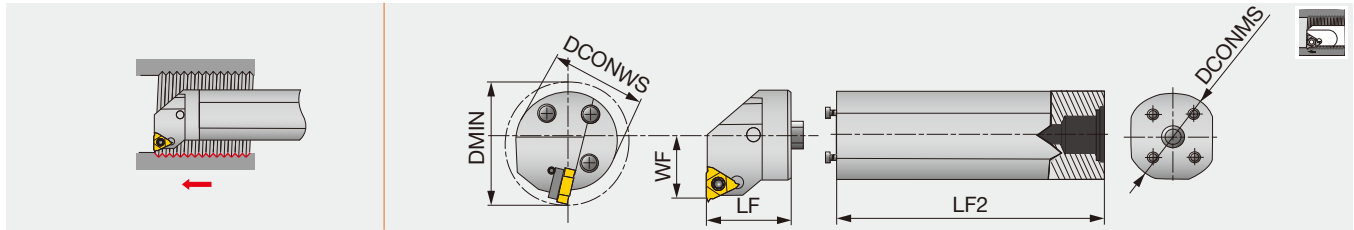
Inch	DCONMS	LF2
S-570-32-50	2.000	14.410
Metric	DCONMS	LF2
S-570-40M-40	40	273
S-570-50M-50	50	366

SPARE PARTS

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

Reference pages: A_M-FLER/L : Inserts → [E014](#)
HS-LNFR-53 : Inserts → [E032](#)

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



Metric	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#...

* Compatible with the BoreMeister system.

Shank

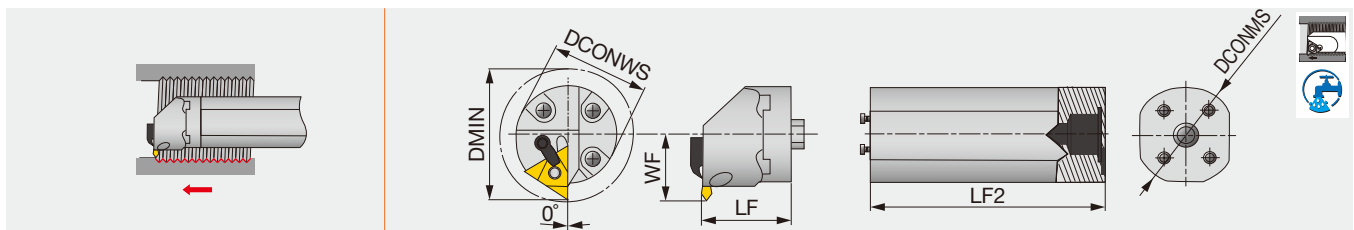
Designation	DCONMS	LF2
S-570-40M-40	40	273
S-570-50M-50	50	366

SPARE PARTS

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

HS-MTHOR

Multi-clamp internal threading toolholder, for on edge inserts



Metric	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...

* Compatible with the BoreMeister system.

Shank

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

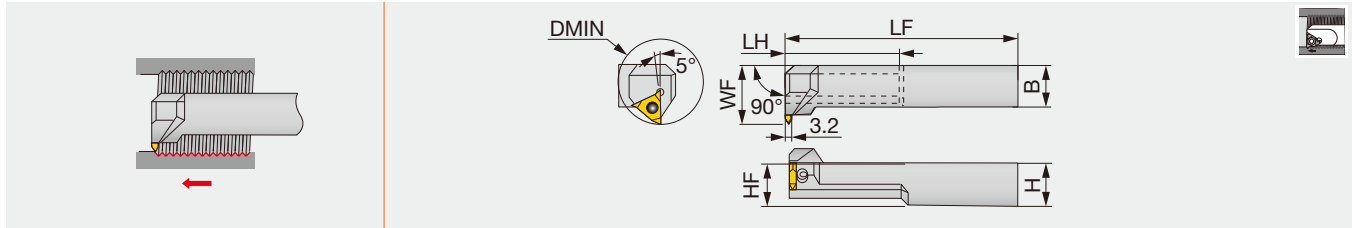
SPARE PARTS

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

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
HS**-MTHOR-4	NL-44	TC-190	STC-5	3/32HEX
HS**-MTHOR-5	NL-56	TC-250	STC-11	1/8HEX

Reference pages: HS-LNFR-54API : Inserts → **E035**
HS-MTHOR : Inserts → **E029 - E031, E033**

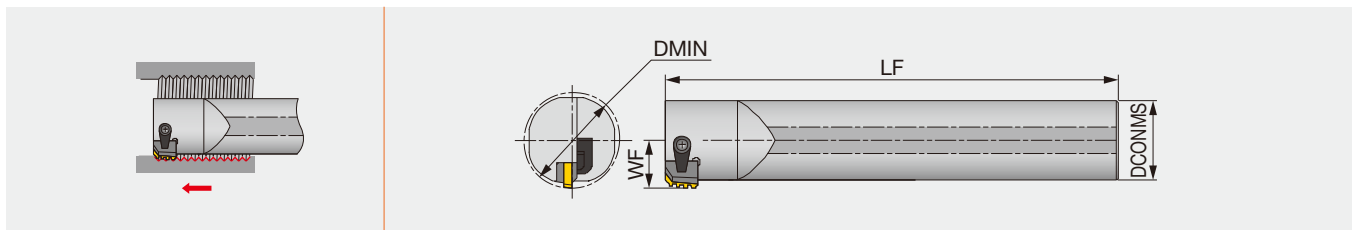


Metric	DMIN	H	B	LF	LH	HF	WF	Insert
TT-2525RI	50	25	25	200	70	25	35	TTL42...

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

SI-CLHOR

Internal threading toolholder, for chaser inserts



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

SPARE PARTS

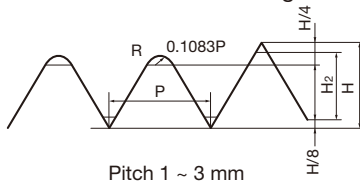
Designation	Clamp	Clamp	Right-left screw	Wrench
TT-2525RI	CP91	-	DS-6	P-3
SI-CLHOR-40M6	-	TC-311	STC-8	5/32HEX

Reference pages: TT-RI : Inserts → [E014](#), [E016](#)

SI-CLHOR : Inserts → [E026](#), [E031](#)

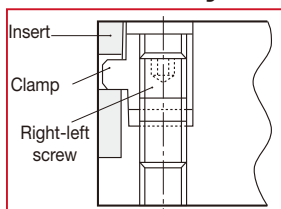
Technical Guide

- Relationship between pitch, depth of cut and number of passes for external metric threading



Note: Maximum machinable pitch is 3 mm.

Part assembly



	P	1	1.25	1.5	1.75	2	2.5	3
H ₂	0.6	0.76	0.92	1.09	1.25	1.57	1.9	
H	0.866	1.083	1.299	1.516	1.732	2.165	2.598	
Number of passes	1	0.25	0.3	0.3	0.3	0.35	0.4	0.4
	2	0.15	0.2	0.25	0.25	0.25	0.3	0.35
	3	0.1	0.1	0.15	0.2	0.2	0.25	0.28
	4	0.05	0.06	0.1	0.1	0.16	0.2	0.2
	5	0.05	0.06	0.05	0.1	0.1	0.15	0.2
	6		0.06	0.05	0.07	0.07	0.1	0.13
	7			0.02	0.05	0.05	0.07	0.1
	8				0.02	0.02	0.05	0.1
	9					0.02	0.03	0.05
	10						0.02	0.05
	11							0.02
	12							0.02

Technical Guide

STANDARD CUTTING CONDITIONS

TUNGTHREAD

ISO	Workpiece material	Hardness	Cutting speed: Vc (sfm)						
			AH8015	T05HP	AH725	T313V	NS9530	TH10	BX330
P	Steel / Alloy steel 1045, 4140, etc.	< 200HB	262 - 591	328 - 656	262 - 591	328 - 656	492 - 656	-	-
		> 200HB	197 - 525	328 - 492	197 - 525	328 - 492	328 - 558	-	-
M	Stainless steel 304SS, etc.	-	164 - 427	230 - 427	164 - 427	230 - 427	-	-	-
K	Cast iron Class 25, Class 30, etc.	-	197 - 492	230 - 492	164 - 328	230 - 492	-	230 - 295	-
N	Non-ferrous metal	-	-	-	-	-	-	328 - 1640	-
S	Superalloys Ti-6Al-4V, Inconel718, etc.	-	66 - 262	-	-	-	-	33 - 131	-
H	Hardened steel	50 - 60HRC	-	-	-	-	-	33 - 98	164 - 656

TETRAMCUT

TCT18R/L / TCT18FR

ISO	Workpiece material	Hardness	Priority	Grade	Cutting speed Vc (sfm)	Pitch (in)	Threads per inch (TPI)
P	Steel / Alloy steel 1045, 4140, etc.	< 200HB	First choice	SH725	197 - 492	0.016 - 0.079	64 - 12
			Fracture resistance	AH725	197 - 492	0.031 - 0.118	32 - 8
		> 200HB	First choice	SH725	197 - 492	0.016 - 0.079	64 - 12
			Fracture resistance	AH725	197 - 492	0.031 - 0.118	32 - 8
M	Stainless steel 304SS, etc.	-	First choice	SH725	164 - 262	0.016 - 0.079	64 - 12
		-	Fracture resistance	AH725	164 - 262	0.031 - 0.118	32 - 8
K	Cast iron Class 25, Class 30, etc.	-	First choice	AH725	164 - 328	0.031 - 0.118	32 - 8
		-	Sharpness	SH725	164 - 328	0.016 - 0.079	64 - 12
S	Superalloys Ti-6Al-4V, Inconel718, etc.	-	First choice	SH725	98 - 328	0.016 - 0.079	64 - 12
		-	Fracture resistance	AH725	98 - 328	0.031 - 0.118	32 - 8

DUOJUST CUT

ISO	Workpiece material	Hardness	Grade	Cutting speed Vc (sfm)	Pitch (in)	Threads per inch (TPI)
P	Steel / Alloy steel 1045, 4140, etc.	< 200HB	SH725	164 - 656	0.008 - 0.059	127 - 16
		> 200HB	SH725	164 - 656	0.008 - 0.059	127 - 16
M	Stainless steel 304SS, etc.	-	SH725	164 - 656	0.008 - 0.059	127 - 16
N	Aluminum alloys 5056, 6061, etc.	-	SH725	492 - 656	0.008 - 0.059	127 - 16
	Copper alloy C2600, C280C, etc.	-	SH725	328 - 656	0.008 - 0.059	127 - 16
S	Superalloys Ti-6Al-4V, Inconel718, etc.	-	SH725	98 - 262	0.008 - 0.059	127 - 16

Reference pages: TungThread : Inserts → **E010 - E011, E014 - E019, E021 - E035**

External toolholders → **E036 - E040, E051 - E053**

Internal toolholders → **E054 - E056, E065 - E067**

TetraMini-Cut: Inserts → **E012**, External toolholders → **E041 - E044**

DuoJust-Cut : Inserts → **E012**, External toolholders → **E047 - E048**

STANDARD CUTTING CONDITIONS

TUNG T-CLAMP

ISO	Workpiece material	Hardness	Grade	Application	Cutting speed Vc (sfm)	Pitch (in)	Threads per inch (TPI)
P	Steel / Alloy steel 1045, 4140, etc.	< 200HB	AH725	Threading	262 - 591	Internal 0.083 - 0.200 External 0.050 - 0.167	Internal 5 - 12 External 6 - 20
		> 200HB	AH725	Threading	197 - 525	Internal 0.083 - 0.200 External 0.050 - 0.167	Internal 5 - 12 External 6 - 20
M	Stainless steel 304SS, etc.	-	AH725	Threading	164 - 427	Internal 0.083 - 0.200 External 0.050 - 0.167	Internal 5 - 12 External 6 - 20

TINY M^{INI} TURN



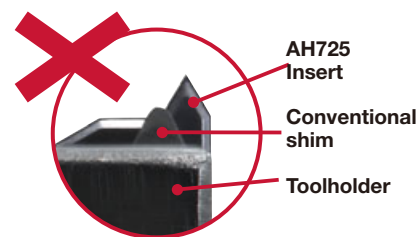
Internal threading

ISO	Workpiece material	Hardness	Grade	Cutting speed Vc (m/min)	Cutting speed Vc (sfm)	Number of passes				
						Pitch (mm) / (in)				
						0.5 (0.020)	0.75 (0.029)	1 (0.039)	1.25 (0.049)	1.5 (0.059)
P	Steel / Alloy steel 1045, 4140, etc.	< 200HB	SH730, SH725	40 - 140	131 - 459	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
		> 200HB	SH730, SH725	40 - 140	131 - 459	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
M	Stainless steel 304SS, etc.	-	SH730, SH725	40 - 140	131 - 459	8	10	12	15	18
K	Cast iron Class 25, Class 30, etc.	-	SH730, SH725	30 - 100	98 - 328	7	9	12	14	17
N	Aluminum alloys, Copper alloy Si < 12%	-	SH730, SH725	90 - 200	295 - 656	6	8	10	12	15

Reference pages: TungT-Clamp : Inserts → **E014**, External toolholders → **E050**
 Internal toolholders → **E064 - E065**
 TinyMini-Turn: Solid carbide boring bars → **E060**

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)

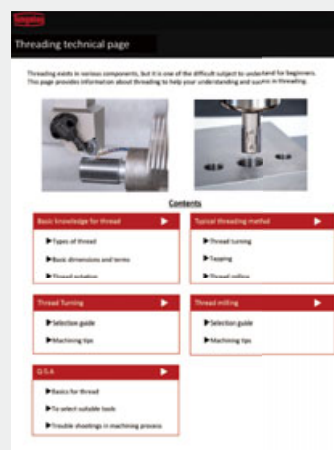
Thread	External		Replacement	Internal		Replacement
	Designation	Grade		Designation	Grade	
ISO			① Conventional shim ① Standard (New)	16IR15ISO-B	AH725	② Conventional shim ② Standard (New)
				16IR17ISO-B	AH725	
				16IR20ISO-B	AH725	
55°	16ERAG55-B	AH725		16IRAG55-B	AH725	
				16IRG55-B	AH725	
60°	16ERA60-B	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	

Want to learn more about threads and thread machining?

Visit this special website for the latest information on thread machining.

The website provides information on:

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



Scan this QR code to access the website