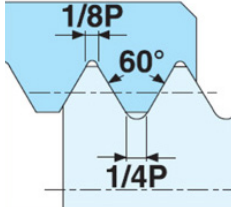
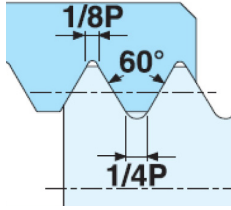
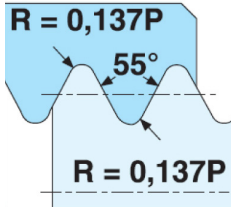
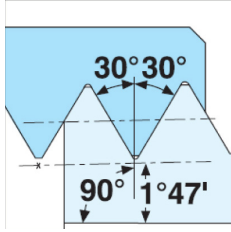
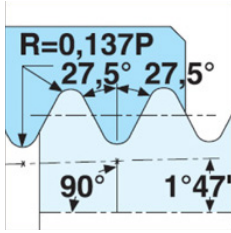


Indexable Threading Tools

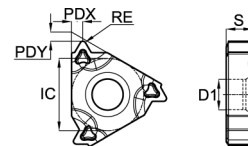


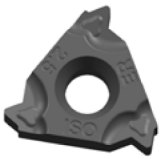
Overview of Threading Inserts

Application	Thread Type	Thread Sketch	Thread Code	Pitch
For general industry	ISO Metric Thread		ISO	1.0–5.0 (mm)
	UN Thread		UN	24–8 (TPI)
Thread for pipe fittings and couplings for gas, water and sewage.	Whitworth Thread		W	19–11 (TPI)
	NPT Thread		NPT	27–8 (TPI)
	BSPT Thread		BSPT	28–11 (TPI)

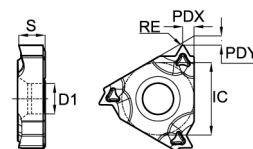
Metric 60°

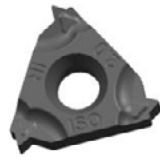
► External



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6301.0010	16ER1.00ISO-TC-GM3225	45,00	1.00	0.8	0.7	0.14	9.525	3.47	4
	6301.0020	16ER1.25ISO-TC-GM3225	45,00	1.25	0.8	0.9	0.18	9.525	3.47	4
	6301.0030	16ER1.50ISO-TC-GM3225	45,00	1.50	0.8	1.0	0.22	9.525	3.47	4
	6301.0040	16ER1.75ISO-TC-GM3225	45,00	1.75	1.2	1.2	0.25	9.525	3.47	4
	6301.0110	16ER2.00ISO-TC-GM3225	45,00	2.00	1.2	1.3	0.29	9.525	3.47	4
	6301.0120	16ER2.50ISO-TC-GM3225	45,00	2.50	1.2	1.5	0.36	9.525	3.47	4
	6301.0140	16ER3.00ISO-TC-GM3225	45,00	3.00	1.2	1.5	0.43	9.525	3.47	4
	6302.0150	22ER3.50ISO-TC-GM3225	59,50	3.50	1.6	2.3	0.45	12.7	4.71	5
	6302.0160	22ER4.00ISO-TC-GM3225	59,50	4.00	1.6	2.3	0.52	12.7	4.71	5
	6302.0170	22ER4.50ISO-TC-GM3225	59,50	4.50	1.7	2.4	0.58	12.7	4.71	5
	6302.0180	22ER5.00ISO-TC-GM3225	59,50	5.00	1.7	2.5	0.63	12.7	4.71	5
	6302.0250	22ER5.50ISO-TC-GM3225	59,50	5.50	1.9	2.7	0.72	12.7	4.71	5
	6302.0260	22ER6.00ISO-TC-GM3225	59,50	6.00	1.9	2.7	0.78	12.7	4.71	5

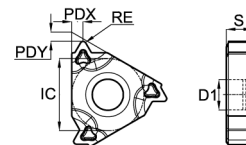
► Internal



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6301.0001	11IR1.00ISO-TC-GM3225	42,60	1.00	0.8	0.7	0.07	6.35	3.00	3.2
	6301.0002	11IR1.25ISO-TC-GM3225	42,60	1.25	0.8	0.9	0.09	6.35	3.00	3.2
	6301.0003	11IR1.50ISO-TC-GM3225	42,60	1.50	0.8	1.0	0.11	6.35	3.00	3.2
	6301.0004	11IR1.75ISO-TC-GM3225	42,60	1.75	0.9	1.1	0.13	6.35	3.00	3.2
	6301.0005	11IR2.00ISO-TC-GM3225	42,60	2.00	0.9	1.1	0.15	6.35	3.00	3.2
	6302.0010	16IR1.00ISO-TC-GM3225	45,00	1.00	0.8	0.7	0.07	9.525	3.47	4
	6302.0020	16IR1.25ISO-TC-GM3225	45,00	1.25	0.8	0.9	0.09	9.525	3.47	4
	6302.0030	16IR1.50ISO-TC-GM3225	45,00	1.50	0.8	1.0	0.11	9.525	3.47	4
	6302.0040	16IR1.75ISO-TC-GM3225	45,00	1.75	1.2	1.2	0.13	9.525	3.47	4
	6302.0110	16IR2.00ISO-TC-GM3225	45,00	2.00	1.2	1.3	0.15	9.525	3.47	4
	6302.0120	16IR2.50ISO-TC-GM3225	45,00	2.50	1.2	1.5	0.18	9.525	3.47	4
	6302.0140	16IR3.00ISO-TC-GM3225	45,00	3.00	1.2	1.5	0.22	9.525	3.47	4
	6302.0190	22IR3.50ISO-TC-GM3225	59,50	3.50	1.6	2.3	0.22	12.7	4.71	5
	6302.0200	22IR4.00ISO-TC-GM3225	59,50	4.00	1.6	2.3	0.25	12.7	4.71	5
	6302.0210	22IR4.50ISO-TC-GM3225	59,50	4.50	1.6	2.4	0.28	12.7	4.71	5
	6302.0220	22IR5.00ISO-TC-GM3225	59,50	5.00	1.6	2.3	0.32	12.7	4.71	5
	6302.0230	22IR5.50ISO-TC-GM3225	59,50	5.50	1.6	2.3	0.36	12.7	4.71	5
	6302.0240	22IR6.00ISO-TC-GM3225	59,50	6.00	1.6	2.4	0.39	12.7	4.71	5

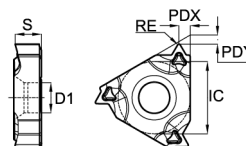
UN 60°

► External



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6303.0060	16ER24UN-TC-GM3225	45,00	24	0.8	0.8	0.15	9.525	3.47	4
	6303.0050	16ER20UN-TC-GM3225	45,00	20	0.8	0.9	0.18	9.525	3.47	4
	6303.0040	16ER18UN-TC-GM3225	45,00	18	0.8	1.0	0.20	9.525	3.47	4
	6303.0030	16ER16UN-TC-GM3225	45,00	16	0.9	1.1	0.23	9.525	3.47	4
	6303.0020	16ER14UN-TC-GM3225	45,00	14	1.2	1.5	0.26	9.525	3.47	4
	6303.0010	16ER12UN-TC-GM3225	45,00	12	1.2	1.5	0.31	9.525	3.47	4
	6303.0080	16ER8UN-TC-GM3225	45,00	8	1.3	1.7	0.46	9.525	3.47	4

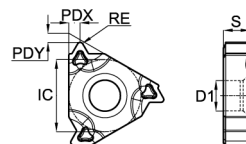
► Internal



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6303.0170	11IR20UN-TC-GM3225	42,60	20	0.8	0.9	0.09	6.35	3.00	3.2
	6303.0180	11IR18UN-TC-GM3225	42,60	18	0.8	1.0	0.10	6.35	3.00	3.2
	6303.0140	16IR24UN-TC-GM3225	45,00	24	0.8	0.8	0.08	9.525	3.47	4
	6303.0130	16IR20UN-TC-GM3225	45,00	20	0.8	0.9	0.09	9.525	3.47	4
	6303.0120	16IR18UN-TC-GM3225	45,00	18	0.8	1.0	0.10	9.525	3.47	4
	6303.0110	16IR16UN-TC-GM3225	45,00	16	0.9	1.1	0.12	9.525	3.47	4
	6303.0100	16IR14UN-TC-GM3225	45,00	14	1.2	1.5	0.13	9.525	3.47	4
	6303.0090	16IR12UN-TC-GM3225	45,00	12	1.2	1.5	0.16	9.525	3.47	4
	6303.0160	16IR8UN-TC-GM3225	45,00	8	1.3	1.7	0.23	9.525	3.47	4

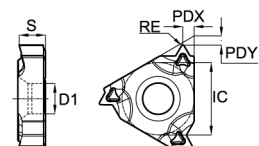
Whitworth 55°

► External



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6301.0100	16ER19W-TC-GM3225	45,00	19	0.8	1.0	0.17	9.525	3.47	4
	6301.0150	16ER18W-TC-GM3225	45,00	18	0.8	1.0	0.18	9.525	3.47	4
	6301.0160	16ER16W-TC-GM3225	45,00	16	0.9	1.1	0.20	9.525	3.47	4
	6301.0080	16ER14W-TC-GM3225	45,00	14	1.2	1.5	0.24	9.525	3.47	4
	6301.0170	16 ER12W-TC-GM3225	45,00	12	1.2	1.5	0.28	9.525	3.47	4
	6301.0060	16ER11W-TC-GM3225	45,00	11	1.2	1.5	0.30	9.525	3.47	4
	6301.0180	16 ER10W-TC-GM3225	45,00	10	1.1	1.5	0.34	9.525	3.47	4

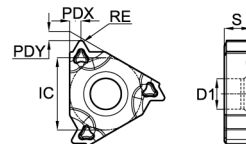
► Internal



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6302.0270	11IR19W-TC-GM3225	42,60	19	0.9	1.1	0.19	6.35	3.00	3.2
	6302.0280	11IR14W-TC-GM3225	42,60	14	0.9	1.1	0.27	6.35	3.00	3.2
	6302.0100	16IR19W-TC-GM3225	45,00	19	0.8	1.0	0.17	9.525	3.47	4
	6302.0290	16IR18W-TC-GM3225	45,00	18	0.8	1.0	0.18	9.525	3.47	4
	6302.0300	16IR16W-TC-GM3225	45,00	16	0.9	1.1	0.2	9.525	3.47	4
	6302.0080	16IR14W-TC-GM3225	45,00	14	1.2	1.5	0.24	9.525	3.47	4
	6302.0310	16IR12W-TC-GM3225	45,00	12	1.2	1.5	0.28	9.525	3.47	4
	6302.0060	16IR11W-TC-GM3225	45,00	11	1.2	1.5	0.30	9.525	3.47	4
	6302.0320	16IR8W-TC-GM3225	45,00	8	1.2	1.5	0.41	9.525	3.47	4

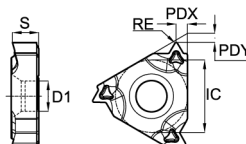
NPT 60°

► External



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6304.0040	16ER27NPT-TC-GM3225	45,00	27	0.7	0.8	0.13	9.525	3.47	4
	6304.0030	16ER18NPT-TC-GM3225	45,00	18	0.8	1.0	0.20	9.525	3.47	4
	6304.0020	16ER14NPT-TC-GM3225	45,00	14	1.2	1.5	0.22	9.525	3.47	4
	6304.0010	16ER11.5NPT-TC-GM3225	45,00	11.5	1.2	1.5	0.25	9.525	3.47	4
	6304.0050	16ER8NPT-TC-GM3225	45,00	8	1.3	1.8	0.30	9.525	3.47	4

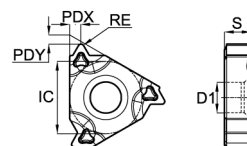
► Internal



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6304.0110	11IR18NPT-TC-GM3225	76,50	18	0.8	1.0	0.20	6.35	3.00	3.2
	6304.0090	16IR27NPT-TC-GM3225	45,00	27	0.7	0.8	0.13	9.525	3.47	4
	6304.0080	16IR18NPT-TC-GM3225	45,00	18	0.8	1.0	0.20	9.525	3.47	4
	6304.0070	16IR14NPT-TC-GM3225	45,00	14	1.2	1.5	0.22	9.525	3.47	4
	6304.0060	16IR11.5NPT-TC-GM3225	45,00	11.5	1.2	1.5	0.25	9.525	3.47	4
	6304.0100	16IR8NPT-TC-GM3225	45,00	8	1.3	1.8	0.30	9.525	3.47	4

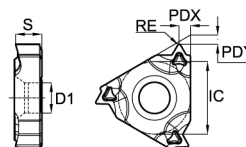
BSPT 55°

► External



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6301.0130	16ER28BSPT-TC-GM3225	45,00	28	0.7	0.8	0.11	9.525	3.47	4
	6301.0090	16ER19BSPT-TC-GM3225	45,00	19	0.8	1.0	0.17	9.525	3.47	4
	6301.0070	16ER14BSPT-TC-GM3225	45,00	14	1.2	1.5	0.24	9.525	3.47	4
	6301.0050	16ER11BSPT-TC-GM3225	45,00	11	1.2	1.5	0.30	9.525	3.47	4

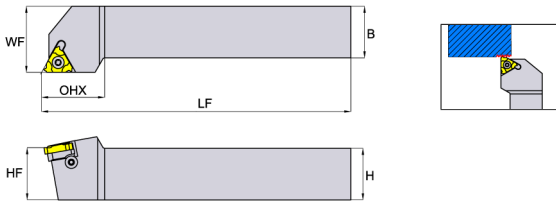
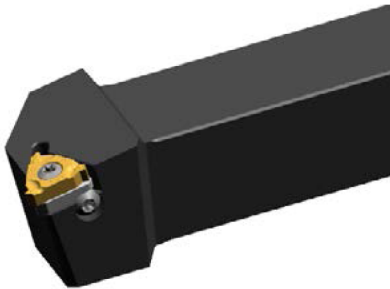
► Internal



	Ordering code	Benämning	Pris kr/st	Pitch (mm)	Dimensions					
					PDY	PDX	RE	IC	S	D1
	6302.0330	11 IR19BSPT-TC-GM3225	42,60	19	0.8	1.0	0.18	6.35	3.00	3.2
	6302.0340	11 IR14BSPT-TC-GM3225	42,60	14	0.9	1.1	0.24	6.35	3.00	3.2
	6302.0130	16IR28BSPT-TC-GM3225	45,00	28	0.7	0.8	0.11	9.525	3.47	4
	6302.0090	16IR19BSPT-TC-GM3225	45,00	19	0.8	1.0	0.17	9.525	3.47	4
	6302.0070	16IR14BSPT-TC-GM3225	45,00	14	1.2	1.5	0.24	9.525	3.47	4
	6302.0050	16IR11BSPT-TC-GM3225	45,00	11	1.2	1.5	0.30	9.525	3.47	4

External Tool Holders

► SER / L Series



Ordering Code	Benämning	Pris kr/st	Dimensions						Insert	Insert screw	Shim	Shim Screw	Wrench	Wrench for shim screw
			H	B	LF	WF	HF	OHX						
6566.0170	SER1212F11	308	12	12	80	14	12	16	11ER...	6590.0500	\	\	6590.0460	\
6566.0180	SER1212F16	308	12	12	80	16	12	21	16ER...	6590.0510	\	\	6590.0470	\
6566.0010	SER1616H16	308	16	16	100	20	16	24	16ER...	6590.0210	65.PDEN16	6590.0380	6590.0470	6590.0310
6566.0020	SER2020K16	330	20	20	125	25	20	27	16ER...	6590.0210	65.PDEN16	6590.0380	6590.0470	6590.0310
6566.0030	SER2525M16	404	25	25	150	32	25	32	16ER...	6590.0210	65.PDEN16	6590.0380	6590.0470	6590.0310
6566.0040	SER3232P16	448	32	32	170	40	32	31	16ER...	6590.0210	65.PDEN16	6590.0380	6590.0470	6590.0310
6566.0050	SER2525M22	404	25	25	150	32	25	31	22ER...	6590.0230	65.PDEN22	6590.0380	6590.0480	6590.0310
6566.0060	SER3232P22	448	32	32	170	40	32	32	22ER...	6590.0230	65.PDEN22	6590.0390	6590.0480	6590.0450
6566.0190	SER3232P27	475	32	32	170	40	32	33	27ER...	6590.0490	65.PDEN27	6590.0390	6590.0480	6590.0450
	SEL1212F11	308	12	12	80	14	12	16	11ER...	6590.0500	\	\	6590.0460	\
	SEL1212F16	308	12	12	80	16	12	21	16ER...	6590.0510	\	\	6590.0470	\
	SEL1616H16	308	16	16	100	20	16	24	16ER...	6590.0210	65.PDEN16	6590.0380	6590.0470	6590.0310
	SEL2020K16	330	20	20	125	25	20	27	16ER...	6590.0210	65.PDEN16	6590.0380	6590.0470	6590.0310
	SEL2525M16	404	25	25	150	32	25	32	16ER...	6590.0210	65.PDEN16	6590.0380	6590.0470	6590.0310
	SEL3232P16	448	32	32	170	40	32	31	16ER...	6590.0210	65.PDEN16	6590.0380	6590.0470	6590.0310
	SEL2525M22	404	25	25	150	32	25	31	22ER...	6590.0230	65.PDEN22	6590.0380	6590.0480	6590.0310
	SEL3232P22	448	32	32	170	40	32	32	22ER...	6590.0230	65.PDEN22	6590.0390	6590.0480	6590.0450
	SEL3232P27	475	32	32	170	40	32	33	27ER...	6590.0490	65.PDEN27	6590.0390	6590.0480	6590.0450

Remark: Missing Ordering Code normally means about two weeks delivery time.

Spare parts

Insert screw	
	Pris kr/st
6590.0200	8,10
6590.0210	10,70
6590.0230	4,70
6590.0490	6,80
6590.0500	8,50
6590.0510	8,10
6590.0520	8,50
6590.0530	11,20
6590.0540	10,70

Shim	
	Pris kr/st
65.PDEN16	22,20
65.PDEN22	36,20
65.PDEN27	43,20
65.PDIN16	22,20
65.PDIN22	36,20
65.PDIN27	43,20

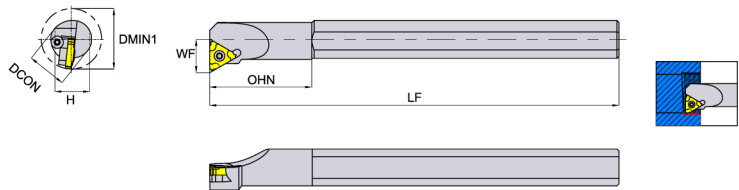
Shim Screw	
	Pris kr/st
6590.0380	8,20
6590.0390	8,20

Wrench	
	Pris kr/st
6590.0340	9,70
6590.0460	9,70
6590.0470	8,00
6590.0480	12,50

Wrench for shim screw	
	Pris kr/st
6590.0310	7,10

Internal Tool Holders

► SIR / L Series



Ordering Code	Benämning	Pris kr/st	Dimensions						Insert	Insert screw	Shim	Shim Screw	Wrench	Wrench for shim screw
			DMIN1	DCON	H	LF	WF	OHN						
6566.0200	SIR0008K08	250	9.9	8	7	125	4.95	20	08IR...	6590.0520	\	\	6590.0340	\
6566.0070	SIR0010K11	210	13	10	9	125	6.5	25	11IR...	6590.0200	\	\	6590.0460	\
6566.0080	SIR0012K11	226	15	12	11	125	7.4	28	11IR...	6590.0200	\	\	6590.0460	\
6566.0210	SIR0013M16	242	19	16	15	150	9.4	32	16IR...	6590.0510	\	\	6590.0470	\
6566.0090	SIR0016Q16	242	21	16	15	180	10.8	40	16IR...	6590.0510	\	\	6590.0470	\
6566.0100	SIR0020Q16	375	24	20	18	180	13.1	40	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
6566.0110	SIR0025R16	477	29	25	23	200	15.6	45	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
6566.0120	SIR0032S16	530	38	32	30	250	19.1	50	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
6566.0130	SIR0040T16	780	44	40	38	300	23.1	55	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
6566.0220	SIR0050U16	1370	60	50	48	350	28.1	50	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
6566.0230	SIR0020Q22	375	26	20	18	180	13.2	40	22IR...	6590.0540	\	\	6590.0470	\
6566.0160	SIR0025R22	482	32	25	23	200	16.4	46	22IR...	6590.0230	65.PDIN22	6590.0390	6590.0470	6590.0450
6566.0140	SIR0032S22	530	39	32	30	250	19.9	50	22IR...	6590.0230	65.PDIN22	6590.0390	6590.0470	6590.0450
6566.0150	SIR0040T22	780	47	40	38	300	23.9	55	22IR...	6590.0230	65.PDIN22	6590.0390	6590.0470	6590.0450
6566.0240	SIR0050U22	1370	57	50	48	350	28.9	70	22IR...	6590.0230	65.PDIN22	6590.0390	6590.0470	6590.0450
6566.0250	SIR0040T27	910	50	40	38	300	25	55	27IR...	6590.0490	65.PDIN27	6590.0390	6590.0480	6590.0450
6566.0260	SIR0050U27	1370	60	50	48	350	30.1	70	27IR...	6590.0490	65.PDIN27	6590.0390	6590.0480	6590.0450
	SIL0008K08	250	9.9	8	7	125	4.95	20	08IR...	6590.0520	\	\	6590.0340	\
	SIL0010K11	210	13	10	9	125	6.5	25	11IR...	6590.0200	\	\	6590.0460	\
	SIL0012K11	226	15	12	11	125	7.4	28	11IR...	6590.0200	\	\	6590.0460	\
	SIL0013M16	242	19	16	15	150	9.4	32	16IR...	6590.0510	\	\	6590.0470	\
	SIL0016Q16	242	21	16	15	180	10.8	40	16IR...	6590.0510	\	\	6590.0470	\
	SIL0020Q16	375	24	20	18	180	13.1	40	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
	SIL0025R16	477	29	25	23	200	15.6	45	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
	SIL0032S16	530	38	32	30	250	19.1	50	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
	SIL0040T16	780	44	40	38	300	23.1	55	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
	SIL0050U16	1370	60	50	48	350	28.1	50	16IR...	6590.0530	65.PDIN16	6590.0380	6590.0470	6590.0310
	SIL0020Q22	375	26	20	18	180	13.2	40	22IR...	6590.0540	\	\	6590.0470	\
	SIL0025R22	482	32	25	23	200	16.4	46	22IR...	6590.0230	65.PDIN22	6590.0390	6590.0470	6590.0450
	SIL0032S22	530	39	32	30	250	19.9	50	22IR...	6590.0230	65.PDIN22	6590.0390	6590.0470	6590.0450
	SIL0040T22	780	47	40	38	300	23.9	55	22IR...	6590.0230	65.PDIN22	6590.0390	6590.0470	6590.0450
	SIL0050U22	1370	57	50	48	350	28.9	70	22IR...	6590.0230	65.PDIN22	6590.0390	6590.0470	6590.0450
	SIL0040T27	910	50	40	38	300	25	55	27IR...	6590.0490	65.PDIN27	6590.0390	6590.0480	6590.0450
	SIL0050U27	1370	60	50	48	350	30.1	70	27IR...	6590.0490	65.PDIN27	6590.0390	6590.0480	6590.0450

Remark: Missing Ordering Code normally means about two weeks delivery time.

Cutting Passes and Radial Infeed Recommendation Table

► ISO Metric / External

[illegible]

► ISO Metric/ Internal

[illegible]

► UN / External

Pitch (TPI)	24	20	18	16	14	12	10	8
Total infeed (mm)	0.70	0.84	0.92	1.04	1.17	1.35	1.62	2.02
Total passes	5	6	6	7	8	8	10	12
No. of infeed	Radial infeed per pass (mm)							
1	0.18	0.18	0.20	0.19	0.18	0.22	0.21	0.22
2	0.16	0.17	0.18	0.18	0.18	0.21	0.20	0.21
3	0.15	0.15	0.17	0.17	0.17	0.20	0.19	0.20
4	0.13	0.14	0.15	0.16	0.16	0.19	0.18	0.20
5	0.08	0.12	0.13	0.14	0.15	0.17	0.17	0.19
6		0.08	0.08	0.12	0.14	0.15	0.16	0.18
7				0.08	0.12	0.13	0.15	0.17
8					0.08	0.08	0.14	0.16
9							0.12	0.15
10							0.08	0.14
11								0.12
12								0.08

► UN / Internal

Pitch (TPI)	24	20	18	16	14	12	10	8
Total infeed (mm)	0.66	0.78	0.86	0.96	1.07	1.25	1.48	2.03
Total passes	5	6	6	7	8	8	10	12
No. of infeed	Radial infeed per pass (mm)							
1	0.16	0.16	0.18	0.17	0.16	0.20	0.19	0.22
2	0.15	0.16	0.17	0.16	0.16	0.19	0.18	0.21
3	0.14	0.14	0.16	0.15	0.15	0.18	0.17	0.20
4	0.12	0.13	0.14	0.14	0.14	0.17	0.17	0.20
5	0.08	0.12	0.13	0.13	0.14	0.16	0.16	0.19
6		0.08	0.08	0.12	0.13	0.14	0.15	0.18
7				0.08	0.11	0.13	0.14	0.17
8					0.08	0.08	0.13	0.16
9							0.12	0.15
10							0.08	0.14
11								0.12
12								0.08

► Whitworth / External& Internal

Pitch (TPI)	19	18	16	14	12	11	10	8
Total infeed (mm)	0.90	0.97	1.08	1.20	1.42	1.51	1.70	2.10
Total passes	6	7	8	8	8	9	10	12
No. of infeed	Radial infeed per pass (mm)							
1	0.19	0.17	0.17	0.19	0.23	0.22	0.22	0.23
2	0.18	0.16	0.16	0.18	0.22	0.21	0.21	0.22
3	0.17	0.16	0.15	0.17	0.21	0.20	0.20	0.21
4	0.15	0.15	0.15	0.16	0.19	0.19	0.19	0.21
5	0.13	0.13	0.14	0.15	0.18	0.18	0.18	0.20
6	0.08	0.12	0.13	0.14	0.16	0.16	0.17	0.19
7		0.08	0.11	0.12	0.14	0.15	0.16	0.18
8			0.08	0.08	0.08	0.13	0.15	0.17
9						0.08	0.13	0.16
10							0.08	0.14
11								0.12
12								0.08

► NPT / External& Internal

Pitch (TPI)	27	18	14	11.5	8
Total infeed (mm)	0.76	1.11	1.42	1.73	2.48
Total passes	6	8	10	12	15
No. of infeed	Radial infeed per pass (mm)				
1	0.15	0.17	0.18	0.18	0.21
2	0.15	0.17	0.17	0.17	0.21
3	0.14	0.16	0.16	0.17	0.20
4	0.13	0.15	0.16	0.16	0.20
5	0.11	0.14	0.15	0.16	0.19
6	0.08	0.13	0.14	0.15	0.18
7		0.11	0.14	0.15	0.18
8		0.08	0.13	0.14	0.17
9			0.11	0.13	0.17
10			0.08	0.12	0.16
11				0.11	0.15
12				0.08	0.14
13					0.13
14					0.11
15					0.08

► BSPT / External& Internal

Pitch (TPI)	28	19	14	11
Total infeed (mm)	0.62	0.90	1.20	1.51
Total passes	5	6	8	9
No. of infeed	Radial infeed per pass (mm)			
1	0.15	0.19	0.19	0.22
2	0.14	0.18	0.18	0.21
3	0.13	0.17	0.17	0.20
4	0.12	0.15	0.16	0.19
5	0.08	0.13	0.15	0.18
6		0.08	0.14	0.16
7			0.12	0.15
8			0.08	0.13
9				0.08

Cutting Speed Recommendation Table

ISO	Workpiece Material		Workpiece Material	Cutting Range	Cutting way	Geometry	Grade	Cutting Speed Vc (m/min)	
	Carbon Steel	Low-carbon (C=0.1-0.25%)	HB125	Finishing, Semi-finishing	Continuous Cutting	TC	GM3225	120-160-230	
		Medium-carbon (C=0.25-0.55%)	HB150					100-150-195	
		High-carbon (C=0.55-0.80%)	HB170					90-140-180	
	Low-alloy Steel	Non-hardened	HB180					100-130-180	
		Hardened and tempered	HB275					75-100-140	
		Hardened and tempered	HB350					60-80-130	
	High-alloy Steel	Annealed	HB200					80-110-140	
		Hardened and tempered	HB325					70-90-115	
	Steel Castings	Unalloyed	HB180					180-200-220	
		Low-alloy	HB200					70-110-150	
		High-alloy	HB225					60-100-120	
		Manganese steel (12-14% Mn)	HB250					30-40-50	
	Stainless Steel	Austenitic	HB180	Finishing, Semi-finishing	Continuous Cutting	TC	GM3225	90-120-140	
		Ferritic/Martensitic	HB200					70-140-170	
		Duplex stainless steel	HB230					60-90-120	
	Malleable Cast Iron	Ferritic	HB130	Finishing, Semi-finishing	Continuous Cutting	TC	GM3225	110-130-170	
		Pearlitic	HB230					85-100-145	
	Gray Cast Iron	Low tensile strength	HB180					100-120-160	
		High tensile strength	HB260					80-100-140	
	Nodular Cast Iron	Ferritic	HB160					110-125-160	
		Ferritic	HB250					80-100-120	
	Wrought Aluminum Alloys	Non aging	HB60	Finishing, Semi-finishing	Continuous Cutting	TC	GM3225	350-500-700	
		Aged	HB100					300-400-500	
	Cast Aluminum Alloys	Non aging	HB75					300-450-500	
		Aged	HB90					200-290-400	
		Containing silicon (13-22% Si)	HB130					100-200-300	
	Copper and Copper Alloys	Brass	HB90					100-220-300	
		Bronze and non-leaded copper	HB100					80-180-255	
	Heat-resistant Alloys	Iron base	Annealed	HB200	Finishing, Semi-finishing	Continuous Cutting	TC	GM3225	35-45-60
			Aged	HB280					25-35-50
		Nickel base and cobalt base	Annealed	HB250					15-25-30
			Aged	HB350					10-15-25
			Cast	HB320					10-13-20
	Titanium Alloys	Commercial pure (99.5% Ti)		400Rm					140-150-170
		α+β alloys		1050Rm					50-60-70
	High Hardness Materials	Hardened steel	HRC55	Finishing, Semi-finishing	Continuous Cutting	TC	GM3225	40-45-50	
		Chilled cast iron	HB400					30-40-50	



Mere information og kontaktoplysninger finder du på www.edeco.dk

vi forbeholder os retten til at lave trykfejl