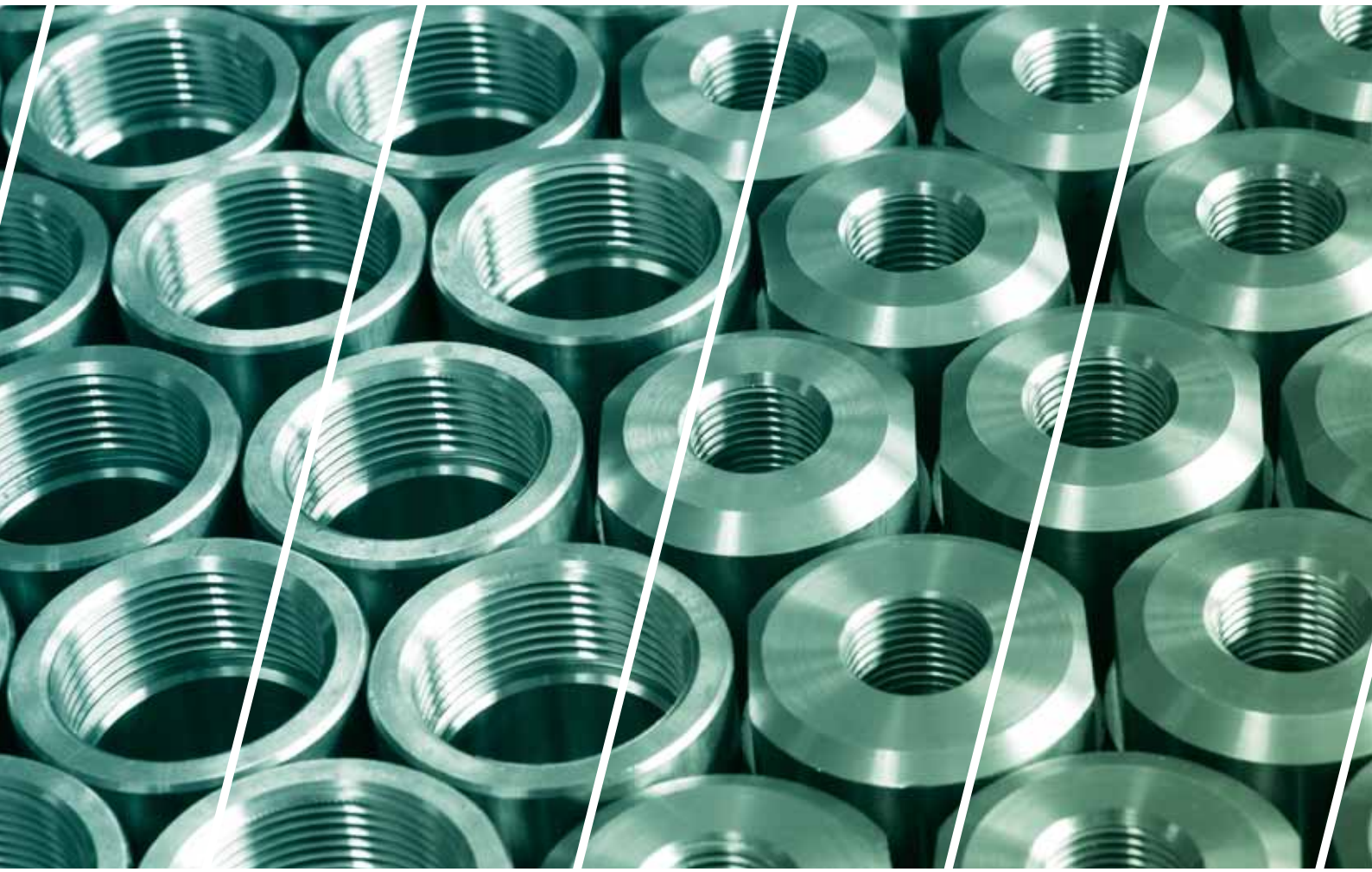
POSITHREAD



MINI CATALOGUE

inserts · tool holders · spares

TOOLING FOR OIL & GAS · AUTOMOTIVE · AEROSPACE · GENERAL ENGINEERING

POSITHREAD

Established in Washington on the North East coast of England in 1986. Positthread was set up to manufacture and grind carbide inserts specifically for the threading market. Enhanced by having unique technology in the Formed Electro Plated Diamond Wheels area, allows us the flexibility to mass produce standard and bespoke threading inserts within fine tolerances on very short lead times and in large or small quantities.

Over the last ten years Positthread has expanded introducing new threading product lines and now incorporates the manufacture of:

Oilfield Premium Threads

Under License to:

VAM, JFE, TENARIS, NIPPON STEEL

These inserts are designed and manufactured on site by a staff of highly trained grinding technicians utilising state-of-the-art 5 axis profile grinders as well as creep feed technology and 25 years of amassed Profile Grinding techniques.

Our threading knowledge pooled together over a quarter of a century of production is now second to none and is moving Positthread into new areas of the Global Market. The combination of the Positthread manufacturing expertise and the support given by the Positthread Global Sales Team has become a winning combination for our world wide customer base.

We are the “Specials Specialists” and will be glad to take on the challenge of solving your threading application problems with optimal solutions.

info@positthread.co.uk · www.positthread.co.uk

THREADING CODE IDENTIFICATION

16	E	R	8	UN	-	PTX
1	2	3	4	5	6	7

1 Insert Size

06	**L** = 6.0mm	I.C. $^{5}/_{32}$"
08	**L** = 8.0mm	I.C. $^{3}/_{16}$"
11	**L** = 11.0mm	I.C. $^{1}/_{4}$"
16	**L** = 16.0mm	I.C. $^{3}/_{8}$"
22	**L** = 22.0mm	I.C. $^{1}/_{2}$"
27	**L** = 27.0mm	I.C. $^{5}/_{8}$"

2 Insert Type

E = External

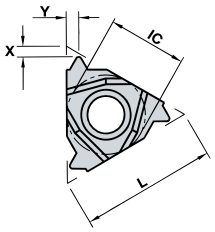
N = Internal

3 Insert Handling

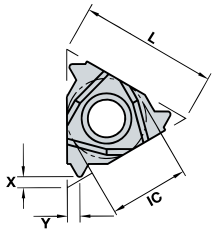
R = Right Hand

L = Left Hand

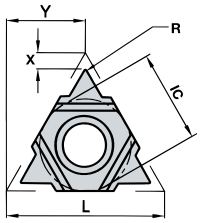
U = Right or Left Hand



ER



NR



'U'

4 Pitch - TPI

Pitch in mm: 1.0, 1.25 etc

TPI Threads per inch: 4, 5, 6 etc

Partial Profile Pitch Range

	mm	tpi
A	0.5 - 1.25	48 - 20
AG	0.5 - 3.0	48 - 8
MR	1.0 - 2.5	24 - 11
G	1.75 - 3.0	14 - 8
N	3.5 - 5.0	7 - 5
S	5.5 - 8.0	$4^{1}/_{2}$ - $3^{1}/_{2}$

5 Standard

55	55° Partial Profile
60	60° Partial Profile
W	Whitworth
ISO	ISO Metric
UN	American Unified
NPT	National Pipe Thread
BSPT	British Standard Pipe Thread
RD	Round
TR	Trapezoidal
ACME	Acme General Purpose
STACME	Stub ACME
API	American Pertoleum Institute
H90	Hughes H90
SL H90	Slimline H90
ELC	Extreme Line Casing
PAC	PAC and AOH

6 Additional Information

Multitooth = 2M 3M

API Threadform / Taper I.D.

386 V0.038R 2 TPF

504 V0.050 3 TPF

558 V0.055 $1^{1}/_{2}$ TPF

7 Grade

PTX	Available from stock
PTC2	Available from stock

ORDER EXAMPLES:

22NR 4 API 386 PTX

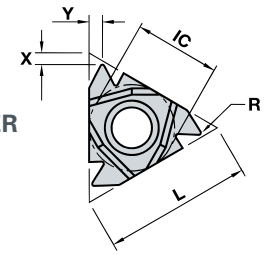
16ER 2.5 ISO PTC2

PARTIAL PROFILE THREAD FORMS

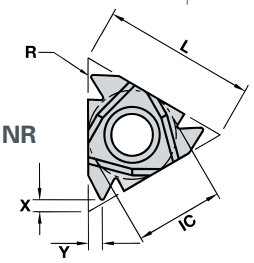
60° (non topping)

Pitch Range mm	Pitch Range inch	'L' mm	I.C inch	DESCRIPTION EXTERNAL	R max	'X' mm	'Y' mm	DESCRIPTION INTERNAL	R max	'X' mm	'Y' mm
0.5 - 1.25	48 - 20	06	5/32"	-	-	-	-	06NR A60	0.04	0.6	0.6
0.5 - 1.5	48 - 16	08	3/16"	-	-	-	-	08NR A60	0.04	0.6	0.7
1.75 - 2.0	14 - 11	08U	3/16U	-	-	-	-	08NU 60	0.13	0.8	4.0
0.5 - 1.5	48 - 16	11	1/4"	11ER A60	0.07	0.7	0.8	11NR A60	0.04	0.7	0.8
0.5 - 1.5	48 - 16	16	3/8"	16ER A60	0.07	0.7	0.8	16NR A60	0.04	0.7	0.8
0.5 - 3.0	48 - 8	16	3/8"	16ER AG60	0.07	1.3	1.5	16NR AG60	0.04	1.3	1.5
1.0 - 2.5	24 - 11	16	3/8"	16ER MR60	0.14	1.3	1.5	16NR MR60	0.07	1.3	1.5
1.75 - 3.0	14 - 8	16	3/8"	16ER G60	0.25	1.3	1.5	16NR G60	0.13	1.3	1.5
3.5 - 5.0	7 - 5	22	1/2"	22ER N60	0.51	1.8	2.5	22NR N60	0.25	1.8	2.5
5.5 - 6.0	4 1/2 - 3 1/4	22U	1/2U	22EU 60	0.39	0.8	11.0	22NU 60	0.39	0.8	11.0
5.5 - 8.0	4 1/2 - 4	27	5/8"	27ER S60	0.39	2.5	4.0	27NR S60	0.39	2.5	4.0
6.5 - 9.0	4 - 2 3/4	27U	5/8U	27EU 60	0.47	1.0	13.5	27NU 60	0.47	1.0	13.5

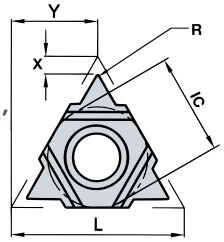
ER



NR



'U'

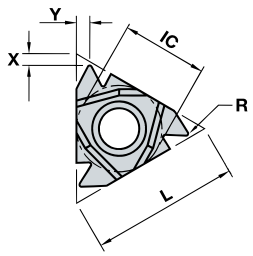


PARTIAL PROFILE THREAD FORMS

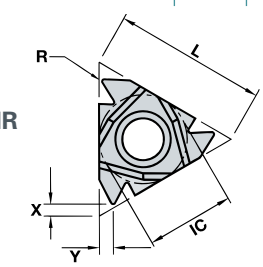
55° (non topping)

Pitch Range mm	Pitch Range inch	'L' mm	I.C inch	DESCRIPTION EXTERNAL	R max	'X' mm	'Y' mm	DESCRIPTION INTERNAL	R max	'X' mm	'Y' mm
-	48 - 20	06	5/32"	-	-	-	-	06NR A55	0.07	0.6	0.6
-	48 - 16	08	3/16"	-	-	-	-	08NR A55	0.07	0.6	0.7
-	14 - 11	08U	3/16U	-	-	-	-	08NU 55	0.25	0.8	4.0
-	48 - 16	11	1/4"	11ER A55	0.07	0.7	0.8	11NR A55	0.07	0.7	0.8
-	48 - 16	16	3/8"	16ER A55	0.07	0.7	0.8	16NR A55	0.07	0.7	0.8
-	48 - 8	16	3/8"	16ER AG55	0.07	1.3	1.5	16NR AG55	0.07	1.3	1.5
-	24 - 11	16	3/8"	16ER MR55	0.14	1.3	1.5	16NR MR55	0.14	1.3	1.5
-	14 - 8	16	3/8"	16ER G55	0.25	1.3	1.5	16NR G55	0.25	1.3	1.5
-	7 - 5	22	1/2"	22ER N55	0.49	1.8	2.5	22NR N55	0.49	1.8.	2.5
-	4 1/2 - 3 1/4	22U	1/2U	22EU 55	0.77	0.8	11.0	22NU 55	0.77	0.8	11.0
-	4 1/2 - 4	27	5/8"	27ER S55	0.77	2.5	4.0	27NR S55	0.77	2.5	4.0
-	4 - 2 3/4	27U	5/8U	27EU 55	0.87	1.2	13.5	27NU 55	0.87	1.2	13.5

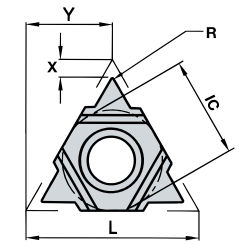
ER



NR



'U'



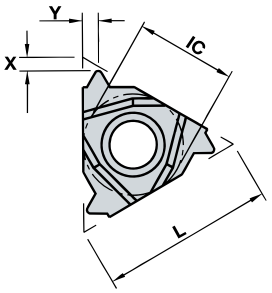
Order Example: **16ER AG60 PTX**

For **LEFT HAND** inserts, specify **L** instead of **R**

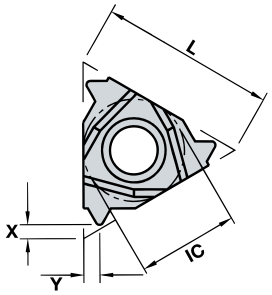
MECHANICAL THREAD FORMS

ISO (full form) DIN 13

'L' mm	I.C	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
06	5/32"	-	-	-	06NR 0.5ISO	0.5	0.5
06	5/32"	-	-	-	06NR 0.75ISO	0.5	0.5
06	5/32"	-	-	-	06NR 1.0ISO	0.6	0.6
06	5/32"	-	-	-	06NR 1.25ISO	0.6	0.7
08	3/16"	-	-	-	08NR 0.5ISO	0.5	0.5
08	3/16"	-	-	-	08NR 0.75ISO	0.5	0.5
08	3/16"	-	-	-	08NR 1.0ISO	0.6	0.6
08	3/16"	-	-	-	08NR 1.25ISO	0.6	0.7
08	3/16"	-	-	-	08NR 1.5ISO	0.7	0.8
08	3/16"U	-	-	-	08NU 1.75ISO	0.7	4.0
11	1/4"	11ER 0.25ISO	0.5	0.4	11NR 0.25ISO	0.5	0.4
11	1/4"	11ER 0.35ISO	0.5	0.4	11NR 0.35ISO	0.5	0.4
11	1/4"	11ER 0.5ISO	0.7	0.5	11NR 0.5ISO	0.7	0.5
11	1/4"	11ER 0.6ISO	0.7	0.5	11NR 0.6ISO	0.7	0.5
11	1/4"	11ER 0.7ISO	0.7	0.5	11NR 0.7ISO	0.7	0.5
11	1/4"	11ER 0.75ISO	0.7	0.5	11NR 0.75ISO	0.7	0.5
11	1/4"	11ER 0.8ISO	0.7	0.5	11NR 0.8ISO	0.7	0.5
11	1/4"	11ER 1.0ISO	0.7	0.8	11NR 1.0ISO	0.7	0.8
11	1/4"	11ER 1.25ISO	0.7	0.8	11NR 1.25ISO	0.7	0.8
11	1/4"	11ER 1.5ISO	0.7	0.9	11NR 1.5ISO	0.7	0.9
11	1/4"	11ER 1.75ISO	0.7	0.9	11NR 1.75ISO	0.7	0.9
11	1/4"	11ER 2.0ISO	0.7	1.0	11NR 2.0ISO	0.7	1.0
16	3/8"	16ER 0.25ISO	0.5	0.4	16NR 0.25ISO	0.5	0.4
16	3/8"	16ER 0.35ISO	0.5	0.4	16NR 0.35ISO	0.5	0.4
16	3/8"	16ER 0.5ISO	0.7	0.5	16NR 0.5ISO	0.7	0.5
16	3/8"	16ER 0.6ISO	0.7	0.5	16NR 0.6ISO	0.7	0.5
16	3/8"	16ER 0.7ISO	0.7	0.5	16NR 0.7ISO	0.7	0.5
16	3/8"	16ER 0.75ISO	0.7	0.5	16NR 0.75ISO	0.7	0.5
16	3/8"	16ER 0.8ISO	0.7	0.5	16NR 0.8ISO	0.7	0.5
16	3/8"	16ER 1.0ISO	0.7	0.8	16NR 1.0ISO	0.8	0.8
16	3/8"	16ER 1.25ISO	0.7	0.8	16NR 1.25ISO	0.7	0.8
16	3/8"	16ER 1.5ISO	0.7	0.8	16NR 1.5ISO	0.7	0.8
16	3/8"	16ER 1.75ISO	1.3	1.5	16NR 1.75ISO	1.3	1.5
16	3/8"	16ER 2.0ISO	1.3	1.5	16NR 2.0ISO	1.3	1.5
16	3/8"	16ER 2.5ISO	1.3	1.5	16NR 2.5ISO	1.3	1.5
16	3/8"	16ER 3.0ISO	1.3	1.6	16NR 3.0ISO	1.3	1.6
16	3/8"	16ER 3.5ISO	1.1	1.5	16NR 3.5ISO	1.1	1.5
22	1/2"	22ER 3.5ISO	1.8	2.5	22NR 3.5ISO	1.8	2.5
22	1/2"	22ER 4.0ISO	1.8	2.5	22NR 4.0ISO	1.8	2.5
22	1/2"	22ER 4.5ISO	1.8	2.5	22NR 4.5ISO	1.8	2.5
22	1/2"	22ER 5.0ISO	1.8	2.5	22NR 5.0ISO	1.8	2.5
22U	1/2U	22EU 5.5ISO	1.5	11.0	22NU 5.5ISO	1.5	11.0
22U	1/2U	22EU 6.0ISO	1.9	11.0	22NU 6.0ISO	1.9	11.0
22U	1/2U	22EU 8.0ISO	2.5	11.0	22NU 8.0ISO	2.5	11.0
27	5/8"	27ER 5.5ISO	2.1	3.2	27NR 5.5ISO	2.1	3.2
27	5/8"	27ER 6.0ISO	2.1	3.2	27NR 6.0ISO	2.1	3.2
27	5/8"	27ER 8.0ISO	2.2	3.2	27NR 8.0ISO	2.2	3.2



ER



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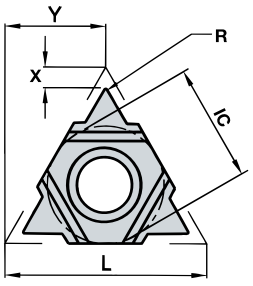


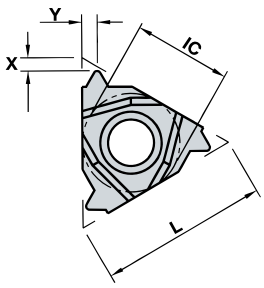
'U'

Order Example: **16ER 1.5ISO PTC2**

For **LEFT HAND** inserts, specify **L** instead of **R**

MECHANICAL THREAD FORMS

UNIFIED (full form) ASME/ANSI B1.1



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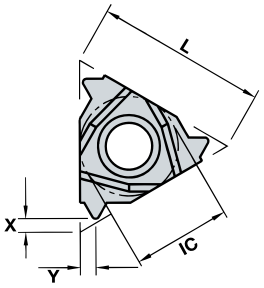

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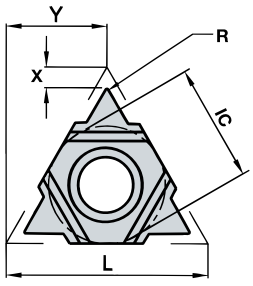


'U'

'L' mm	I.C	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
06	5/32"	-	-	-	06NR 32UN	0.5	0.5
06	5/32"	-	-	-	06NR 28UN	0.5	0.5
06	5/32"	-	-	-	06NR 24UN	0.6	0.6
06	5/32"	-	-	-	06NR 20UN	0.6	0.7
08	3/16"	-	-	-	08NR 32UN	0.5	0.5
08	3/16"	-	-	-	08NR 28UN	0.5	0.5
08	3/16"	-	-	-	08NR 24UN	0.6	0.6
08	3/16"	-	-	-	08NR 20UN	0.6	0.7
08	3/16"	-	-	-	08NR 18UN	0.7	0.8
08	3/16"U	-	-	-	08NU 16UN	0.7	4.0
11	1/4"	11ER 72UN	0.7	0.5	11NR 72UN	0.7	0.5
11	1/4"	11ER 64UN	0.7	0.5	11NR 64UN	0.7	0.5
11	1/4"	11ER 56UN	0.7	0.5	11NR 56UN	0.7	0.5
11	1/4"	11ER 36UN	0.7	0.5	11NR 36UN	0.7	0.5
11	1/4"	11ER 28UN	0.7	0.8	11NR 28UN	0.7	0.8
11	1/4"	11ER 24UN	0.7	0.8	11NR 24UN	0.7	0.8
11	1/4"	11ER 20UN	0.7	0.8	11NR 20UN	0.7	0.8
11	1/4"	11ER 18UN	0.7	0.8	11NR 18UN	0.7	0.8
11	1/4"	11ER 16UN	0.7	0.9	11NR 16UN	0.7	0.9
11	1/4"	11ER 14UN	0.7	0.9	11NR 14UN	0.7	0.9
11	1/4"	11ER 12UN	0.9	1.0	11NR 12UN	0.9	1.0
11	1/4"	11ER 11UN	0.9	1.1	11NR 11UN	0.9	1.1
16	3/8"	16ER 72UN	0.7	0.5	16NR 72UN	0.7	0.5
16	3/8"	16ER 64UN	0.7	0.5	16NR 64UN	0.7	0.5
16	3/8"	16ER 56UN	0.7	0.5	16NR 56UN	0.7	0.5
16	3/8"	16ER 44UN	0.7	0.5	16NR 44UN	0.7	0.5
16	3/8"	16ER 40UN	0.7	0.5	16NR 40UN	0.7	0.5
16	3/8"	16ER 36UN	0.7	0.5	16NR 36UN	0.7	0.5
16	3/8"	16ER 32UN	0.7	0.5	16NR 32UN	0.7	0.5
16	3/8"	16ER 28UN	0.7	0.8	16NR 28UN	0.7	0.8
16	3/8"	16ER 27UN	0.7	0.8	16NR 27UN	0.7	0.8
16	3/8"	16ER 24UN	0.7	0.8	16NR 24UN	0.7	0.8
16	3/8"	16ER 20UN	0.7	0.8	16NR 20UN	0.7	0.8
16	3/8"	16ER 18UN	0.7	0.8	16NR 18UN	0.7	0.8
16	3/8"	16ER 16UN	0.7	0.9	16NR 16UN	0.7	0.9
16	3/8"	16ER 14UN	1.3	1.5	16NR 14UN	1.3	1.5
16	3/8"	16ER 13UN	1.3	1.5	16NR 13UN	1.3	1.5
16	3/8"	16ER 12UN	1.3	1.5	16NR 12UN	1.3	1.5
16	3/8"	16ER 11½UN	1.3	1.5	16NR 11½UN	1.3	1.5
16	3/8"	16ER 11UN	1.3	1.5	16NR 11UN	1.3	1.5
16	3/8"	16ER 10UN	1.3	1.5	16NR 10UN	1.3	1.5
16	3/8"	16ER 9UN	1.3	1.5	16NR 9UN	1.3	1.5
16	3/8"	16ER 8UN	1.3	1.6	16NR 8UN	1.3	1.6
16	3/8"	16ER 7UN	1.3	1.8	16NR 7UN	1.3	1.8
22	1/2"	22ER 7UN	1.8	2.5	22NR 7UN	1.8	2.5
22	1/2"	22ER 6UN	1.8	2.5	22NR 6UN	1.8	2.5
22	1/2"	22ER 5UN	1.8	2.5	22NR 5UN	1.8	2.5
22U	1/2U	22EU 4½UN	2.0	11.0	22NU 4½UN	2.0	11.0
22U	1/2U	22EU 4UN	2.0	11.0	22NU 4UN	2.0	11.0
27	5/8"	27ER 4½UN	2.2	3.2	27NR 4½UN	2.2	3.2
27	5/8"	27ER 4UN	2.2	3.2	27NR 4UN	2.2	3.2

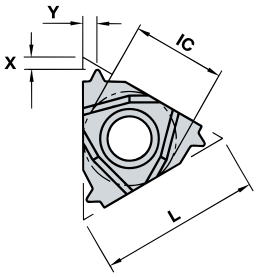
Order Example: **16ER 12UN PTX**

For **LEFT HAND** inserts, specify **L** instead of **R**

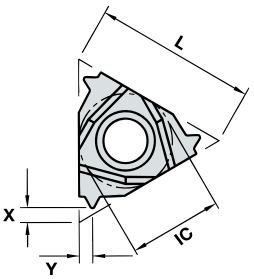
MECHANICAL THREAD FORMS

WHITWORTH (full form) BS84

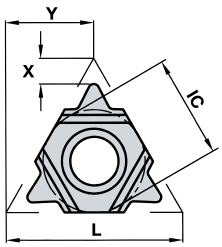
'L' mm	I.C	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
06	5/32"	-	-	-	06NR 26W	0.5	0.6
06	5/32"	-	-	-	06NR 22W	0.6	0.7
06	5/32"	-	-	-	06NR 20W	0.6	0.7
08	3/16"	-	-	-	08NR 28W	0.5	0.6
08	3/16"	-	-	-	08NR 24W	0.6	0.6
08	3/16"	-	-	-	08NR 20W	0.6	0.7
08	3/16"	-	-	-	08NR 19W	0.7	0.8
08	3/16"	-	-	-	08NR 16W	0.7	0.9
08U	3/16U	-	-	-	08NU 26W	0.5	4.0
08U	3/16U	-	-	-	08NU 22W	0.5	4.0
08U	3/16U	-	-	-	08NU 20W	0.5	4.0
11	1/4"	11ER 72W	0.7	0.5	11NR 72W	0.7	0.5
11	1/4"	11ER 60W	0.7	0.5	11NR 60W	0.7	0.5
11	1/4"	11ER 56W	0.7	0.5	11NR 56W	0.7	0.5
11	1/4"	11ER 48W	0.7	0.5	11NR 48W	0.7	0.5
11	1/4"	11ER 40W	0.7	0.5	11NR 40W	0.7	0.5
11	1/4"	11ER 36W	0.7	0.5	11NR 36W	0.7	0.5
11	1/4"	11ER 32W	0.7	0.5	11NR 32W	0.7	0.5
11	1/4"	11ER 28W	0.7	0.8	11NR 28W	0.7	0.8
11	1/4"	11ER 26W	0.7	0.8	11NR 26W	0.7	0.8
11	1/4"	11ER 24W	0.7	0.8	11NR 24W	0.7	0.8
11	1/4"	11ER 22W	0.7	0.8	11NR 22W	0.7	0.8
11	1/4"	11ER 20W	0.7	0.8	11NR 20W	0.7	0.8
11	1/4"	11ER 19W	0.7	0.8	11NR 19W	0.7	0.8
16	3/8"	16ER 72W	0.7	0.5	16NR 72W	0.7	0.5
16	3/8"	16ER 60W	0.7	0.5	16NR 60W	0.7	0.5
16	3/8"	16ER 56W	0.7	0.5	16NR 56W	0.7	0.5
16	3/8"	16ER 48W	0.7	0.5	16NR 48W	0.7	0.5
16	3/8"	16ER 40W	0.7	0.5	16NR 40W	0.7	0.5
16	3/8"	16ER 36W	0.7	0.8	16NR 36W	0.7	0.8
16	3/8"	16ER 32W	0.7	0.8	16NR 32W	0.7	0.8
16	3/8"	16ER 28W	0.7	0.8	16NR 28W	0.7	0.8
16	3/8"	16ER 26W	0.7	0.8	16NR 26W	0.7	0.8
16	3/8"	16ER 22W	0.7	0.8	16NR 22W	0.7	0.8
16	3/8"	16ER 20W	0.7	0.8	16NR 20W	0.7	0.8
16	3/8"	16ER 19W	0.7	0.8	16NR 19W	0.7	0.8
16	3/8"	16ER 14W	1.3	1.5	16NR 14W	1.3	1.5
16	3/8"	16ER 12W	1.3	1.5	16NR 12W	1.3	1.5
16	3/8"	16ER 11W	1.3	1.5	16NR 11W	1.3	1.5
16	3/8"	16ER 10W	1.3	1.5	16NR 10W	1.3	1.5
16	3/8"	16ER 9W	1.3	1.5	16NR 9W	1.3	1.5
16	3/8"	16ER 8W	1.3	1.6	16NR 8W	1.3	1.6
16	3/8"	16ER 7W	1.4	1.9	16NR 7W	1.4	1.9
22	1/2"	22ER 7W	1.8	2.5	22NR 7W	1.8	2.5
22	1/2"	22ER 6W	1.8	2.5	22NR 6W	1.8	2.5
22	1/2"	22ER 5W	1.8	2.5	22NR 5W	1.8	2.5
22U	1/2U	22EU 4 1/2W	2.0	11.0	22NU 4 1/2W	1.6	11.0
22U	1/2U	22EU 4W	2.0	11.0	22NU 4W	1.8	11.0
27	5/8"	27ER 4 1/2W	2.2	3.2	27NR 4 1/2W	2.2	3.2
27	5/8"	27ER 4W	2.2	3.2	27NR 4W	2.2	3.2
27U	5/8U	27EU 3 1/2W	2.2	13.5	27NU 3 1/2W	2.2	13.5
27U	5/8U	27EU 3 1/4W	2.2	13.5	27NU 3 1/4W	2.2	13.5
27U	5/8U	27EU 3W	2.2	13.5	27NU 3W	2.2	13.5
27U	5/8U	27EU 2 3/4W	2.2	13.5	27NU 2 3/4W	2.2	13.5



ER



NR



'U'

Order Example: **16NR 24W PTX**

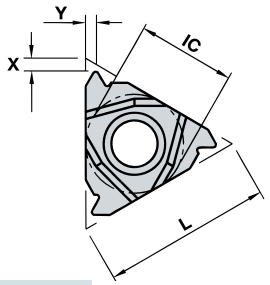
For **LEFT HAND** inserts, specify **L** instead of **R**

AEROSPACE THREAD FORMS

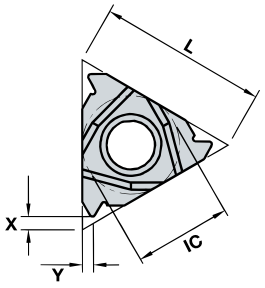
UNJ (full form) BS A 346:2000

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
16	3/8"	16ER 28UNJ	0.9	0.7	16NR 28UNJ	0.8	0.5
16	3/8"	16ER 24UNJ	0.9	0.7	16NR 24UNJ	0.9	0.6
16	3/8"	16ER 20UNJ	1.1	0.8	16NR 20UNJ	1.0	0.7
16	3/8"	16ER 18UNJ	1.1	0.8	16NR 18UNJ	1.2	0.8
16	3/8"	16ER 16UNJ	1.1	0.8	16NR 16UNJ	1.3	0.8
16	3/8"	16ER 14UNJ	1.3	1.0	16NR 14UNJ	1.5	1.0
16	3/8"	16ER 12UNJ	1.5	1.2	16NR 12UNJ	1.7	1.2
16	3/8"	16ER 10UNJ	1.8	1.5	16NR 10UNJ	1.9	1.2
22	1/2"	22ER 8UNJ	2.0	1.5	22NR 8UNJ	2.4	1.4

ER



NR

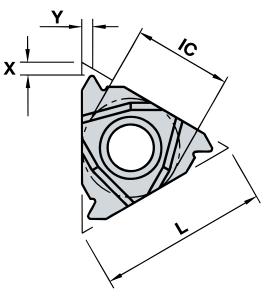


Order Example: **16ER 24UNJ PTX**

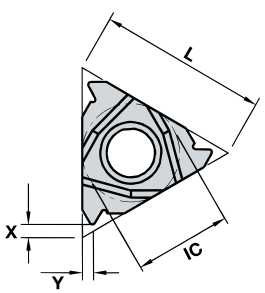
ISO-MJ (full form) BS6293-1

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
16	3/8"	16ER 0.5ISO MJ	0.7	0.5	16NR 0.5ISO MJ	0.5	0.4
16	3/8"	16ER 0.7ISO MJ	0.7	0.5	16NR 0.7ISO MJ	0.6	0.4
16	3/8"	16ER 0.8ISO MJ	0.7	0.5	16NR 0.8ISO MJ	0.7	0.4
16	3/8"	16ER 1.0ISO MJ	0.7	0.5	16NR 1.0ISO MJ	0.8	0.5
16	3/8"	16ER 1.5ISO MJ	1.0	0.8	16NR 1.5ISO MJ	1.2	0.7
16	3/8"	16ER 1.75ISO MJ	1.2	0.9	16NR 1.75ISO MJ	1.4	0.8
16	3/8"	16ER 2.0ISO MJ	1.3	1.0	16NR 2.0ISO MJ	1.5	0.9
16	3/8"	16ER 2.5ISO MJ	1.6	1.3	16NR 2.5ISO MJ	1.9	1.1
22	1/2"	22ER 3.0ISO MJ	2.0	1.5	22NR 3.0ISO MJ	2.2	1.3

ER



NR



Order Example: **16ER 2.0 ISO MJ PTC2**

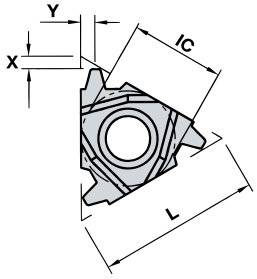
For **LEFT HAND** inserts, specify **L** instead of **R**

TRANSMISSION THREAD FORMS

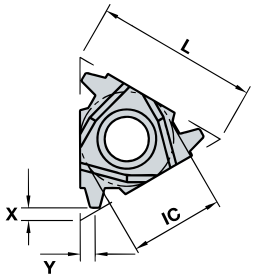
ACME (non topping) ASME/ANSI B1.5

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
11	1/4"	11ER 16ACME	0.8	0.8	11NR 16ACME	0.8	0.8
16	3/8"	16ER 16ACME	0.8	0.8	16NR 16ACME	0.8	0.8
16	3/8"	16ER 14ACME	0.8	0.8	16NR 14ACME	0.8	0.8
16	3/8"	16ER 12ACME	1.2	1.6	16NR 12ACME	1.2	1.6
16	3/8"	16ER 10ACME	1.2	1.6	16NR 10ACME	1.2	1.6
16	3/8"	16ER 8ACME	1.4	1.6	16NR 8ACME	1.4	1.6
16	3/8"	16ER 6ACME	1.5	1.6	16NR 6ACME	1.5	1.6
22	1/2"	22ER 6ACME	2.0	2.6	22NR 6ACME	2.0	2.6
22	1/2"	22ER 5ACME	2.2	2.6	22NR 5ACME	2.2	2.6
22	1/2"	22ER 4ACME SE	1.9	2.1	22NR 4ACME SE	1.9	2.1
22U	1/2"U	22EU 4ACME	2.2	11.0	22NU 4ACME	2.2	11.0
27	5/8"	27ER 4ACME	2.7	3.3	27NR 4ACME	2.7	3.3

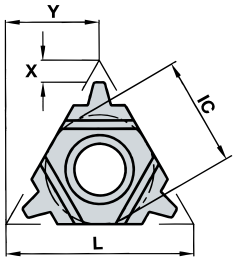
ER



NR



'U'

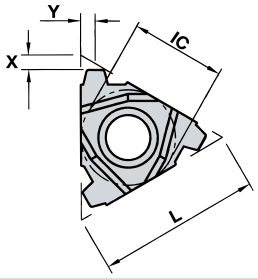


Order Example: **16ER 8ACME PTC2**

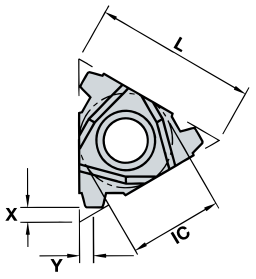
STUB ACME (non topping) ASME/ANSI B1.8

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
11	1/4"	11ER 16STACME	0.8	0.8	11NR 16STACME	0.8	0.8
16	3/8"	16ER 16STACME	0.8	0.8	16NR 16STACME	0.8	0.8
16	3/8"	16ER 14STACME	0.8	0.8	16NR 14STACME	0.8	0.8
16	3/8"	16ER 12STACME	0.8	1.6	16NR 12STACME	0.8	0.8
16	3/8"	16ER 10STACME	1.3	1.6	16NR 10STACME	1.3	1.6
16	3/8"	16ER 8STACME	1.4	1.6	16NR 8STACME	1.4	1.6
16	3/8"	16ER 6STACME	1.6	1.6	16NR 6STACME	1.6	1.6
22	1/2"	22ER 6STACME	2.2	2.6	22NR 6STACME	2.2	2.6
22	1/2"	22ER 5STACME	2.2	2.6	22NR 5STACME	2.2	2.6
22	1/2"	22ER 4STACME	1.9	2.1	22NR 4STACME	1.9	2.1
22U	1/2"U	22EU 4STACME	2.0	11.0	22NU 4STACME	2.0	11.0
27	5/8"	27ER 4STACME	2.9	3.3	27NR 4STACME	2.9	3.3

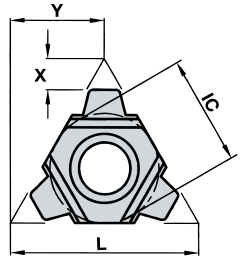
ER



NR



'U'



Order Example: **22NR 6STACME PTX**

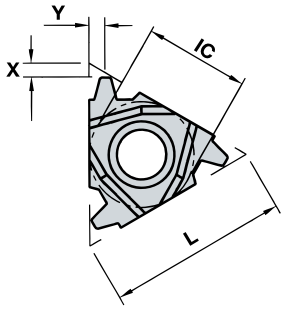
For **LEFT HAND** inserts, specify **L** instead of **R**

TRANSMISSION THREAD FORMS

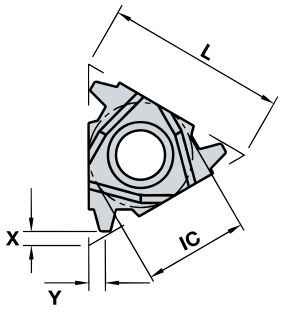
TRAPEZOIDAL (non topping) DIN 103 BS 5346

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
11	1/4"	11ER 1.5TR	0.7	0.8	11NR 1.5TR	0.7	0.8
11	1/4"	11ER 2.0TR	0.7	0.8	11NR 2.0TR	0.7	0.8
11	1/4"	11ER 2.5TR	0.9	1.0	11NR 2.5TR	0.9	1.0
16	3/8"	16ER 1.5TR	0.7	0.8	16NR 1.5TR	0.7	0.8
16	3/8"	16ER 2.0TR	0.7	0.8	16NR 2.0TR	0.7	0.8
16	3/8"	16ER 2.5TR	1.3	1.5	16NR 2.5TR	1.3	1.5
16	3/8"	16ER 3.0TR	1.3	1.5	16NR 3.0TR	1.3	1.5
22	1/2"	22ER 4.0TR	2.0	2.5	22NR 4.0TR	2.0	2.5
22	1/2"	22ER 5.0TR	2.1	2.5	22NR 5.0TR	2.1	2.5
22U	1/2"U	22EU 6.0TR	2.0	11.0	22NU 6.0TR	2.0	11.0
22U	1/2"U	22EU 7.0TR	2.3	11.0	22NU 7.0TR	2.3	11.0
27	5/8"	27ER 6.0TR	2.5	3.2	27NR 6.0TR	2.5	3.2
27	5/8"	27ER 7.0TR	2.7	3.2	27NR 7.0TR	2.7	3.2
27U	5/8"	27EU 8.0TR	2.6	13.5	27NU 8.0TR	2.6	13.5
27U	5/8"	27EU 9.0TR	3.0	13.5	27NU 9.0TR	3.0	13.5

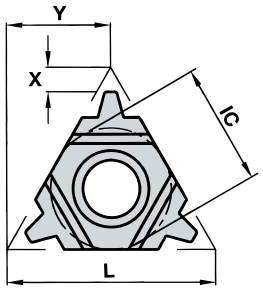
ER



NR



'U'



Order Example: **27EU 9.0TR PTX**

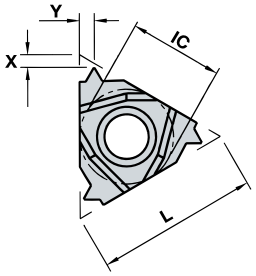
For **LEFT HAND** inserts, specify **L** instead of **R**

PIPE THREAD FORMS

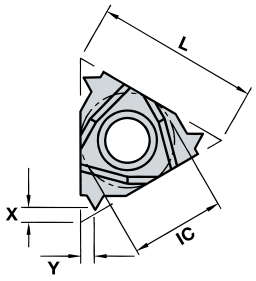
NPT (full form) ASME/ANSI B1.20.1

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
06	5/32"	-	-	-	06NR 27NPT	0.6	0.6
08	3/16"	-	-	-	08NR 27NPT	0.6	0.6
08	3/16"	-	-	-	08NR 18NPT	0.7	0.8
11	1/4"	11ER 27NPT	0.7	0.8	11NR 27NPT	0.7	0.8
11	1/4"	11ER 18NPT	0.7	0.8	11NR 18NPT	0.7	0.8
11	1/4"	11ER 14NPT	0.7	1.0	11NR 14NPT	0.7	1.0
16	3/8"	16ER 27NPT	0.7	0.8	16NR 27NPT	0.7	0.8
16	3/8"	16ER 18NPT	0.7	0.8	16NR 18NPT	0.7	0.8
16	3/8"	16ER 14NPT	1.3	1.5	16NR 14NPT	1.3	1.5
16	3/8"	16ER 11.5NPT	1.3	1.5	16NR 11.5NPT	1.3	1.5
16	3/8"	16ER 8NPT	1.3	1.7	16NR 8NPT	1.3	1.7

ER



NR

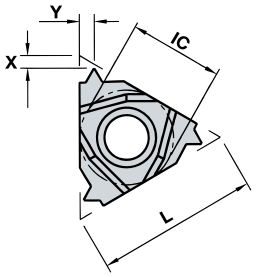


Order Example: **11NR 27NPT PTX**

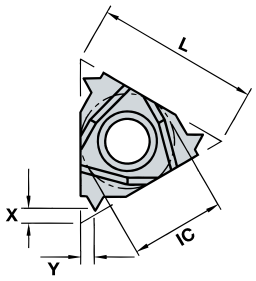
NPTF DRYSEAL (full form) ASME/ANSI B1.20.3

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
06	5/32"	-	-	-	06NR 27NPTF	0.6	0.6
08	3/16"	-	-	-	08NR 27NPTF	0.6	0.6
08	3/16"	-	-	-	08NR 18NPTF	0.7	0.8
11	1/4"	11ER 27NPTF	0.7	0.8	11NR 27NPTF	0.7	0.8
11	1/4"	11ER 18NPTF	0.7	0.8	11NR 18NPTF	0.7	0.8
11	1/4"	11ER 14NPTF	0.7	1.0	11NR 14NPTF	0.7	1.0
16	3/8"	16ER 27NPTF	0.7	0.8	16NR 27NPTF	0.7	0.8
16	3/8"	16ER 18NPTF	0.7	0.8	16NR 18NPTF	0.7	0.8
16	3/8"	16ER 14NPTF	1.3	1.5	16NR 14NPTF	1.3	1.5
16	3/8"	16ER 11.5NPTF	1.3	1.5	16NR 11.5NPTF	1.3	1.5
16	3/8"	16ER 8NPTF	1.3	1.7	16NR 8NPTF	1.3	1.7

ER



NR

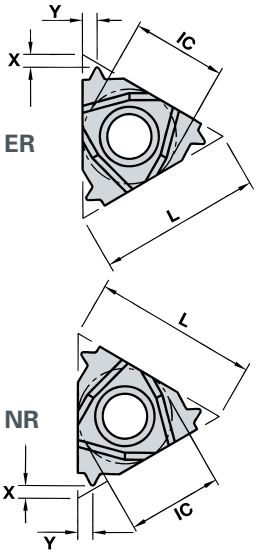


Order Example: **16ER 14NPTF PTC2**

For **LEFT HAND** inserts, specify **L** instead of **R**

PIPE THREADING

BSPT (full form) BS 21

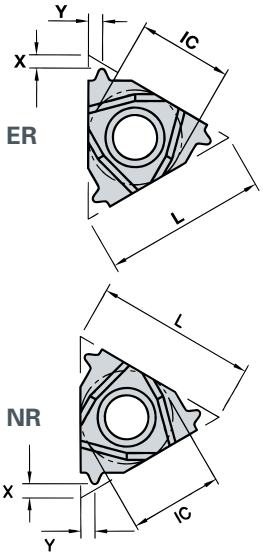


'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
06	5/32"	-	-	-	06NR 28BSPT	0.5	0.6
08	3/16"	-	-	-	08NR 19BSPT	0.7	0.8
11	1/4"	11ER 28BSPT	0.7	0.8	11NR 28BSPT	0.7	0.8
11	1/4"	11ER 19BSPT	0.7	0.8	11NR 19BSPT	0.7	0.8
16	3/8"	16ER 28BSPT	0.7	0.8	16NR 28BSPT	0.7	0.8
16	3/8"	16ER 19BSPT	0.7	0.8	16NR 19BSPT	0.7	0.8
16	3/8"	16ER 14BSPT	1.3	1.5	16NR 14BSPT	1.3	1.5
16	3/8"	16ER 11BSPT	1.3	1.5	16NR 11BSPT	1.3	1.5

Order Example: **16ER 19BSPT PTX**

MISCELLANEOUS THREADING

BRITISH ASSOCIATION (full form) BS 93



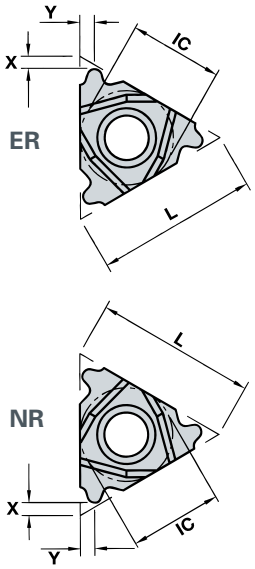
'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
11	1/4"	11ER 8BA	0.4	0.4	11NR 8BA	0.4	0.4
11	1/4"	11ER 4BA	0.7	0.5	11NR 4BA	0.7	0.5
16	3/8"	16ER 8BA	0.4	0.4	16NR 8BA	0.4	0.4
16	3/8"	16ER 6BA	0.4	0.4	16NR 6BA	0.4	0.4
16	3/8"	16ER 4BA	0.7	0.5	16NR 4BA	0.7	0.5
16	3/8"	16ER 2BA	0.8	0.7	16NR 2BA	0.8	0.7
16	3/8"	16ER 0BA	0.8	0.7	16NR 0BA	0.8	0.7

Order Example: **16ER 2BA PTC2**

For **LEFT HAND** inserts, specify **L** instead of **R**

ROUND

(full form) DIN 405



'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
16	3/8"	16ER 10RD	1.3	1.5	16NR 10RD	1.3	1.5
16	3/8"	16ER 8RD	1.3	1.5	16NR 8RD	1.3	1.5
16	3/8"	16ER 6RD	1.5	1.8	16NR 6RD	1.5	1.8
22	1/2"	22ER 6RD	1.8	2.5	22NR 6RD	1.8	2.5
22	1/2"	22ER 4RD	1.8	2.6	22NR 4RD	1.8	2.6
27	5/8"	27ER 4RD	2.4	3.2	27NR 4RD	2.4	3.2
27	5/8"	27ER 3RD	3.0	4.3	27NR 3RD	3.0	4.3

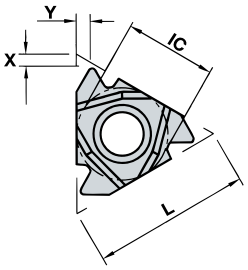
Order Example: **27ER 4RD PTC2**

For **LEFT HAND** inserts, specify **L** instead of **R**

OILFIELD THREAD FORMS

API VO.038R (full form) API spec 7-2

'L' mm	I.C inch	Taper IPF	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
22	1/2"	2	22ER 4API 386	2.0	2.9	22NR 4API 386	2.0	2.9
22	1/2"	3	22ER 4API 384	1.9	2.8	22NR 4API 384	1.9	2.8
27	5/8"	2	27ER 4API 386	2.0	2.9	27NR 4API 386	2.0	2.9
27	5/8"	3	27ER 4API 384	1.9	2.8	27NR 4API 384	1.9	2.8



API VO.040

'L' mm	I.C inch	Taper IPF	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
22	1/2"	3	22ER 5API 404	1.8	2.5	22NR 5API 404	1.8	2.5

API VO.050

'L' mm	I.C inch	Taper IPF	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
22	5/8"	2	22ER 4API 506	1.8	2.5	22NR 4API 506	1.8	2.5
22	5/8"	2	22ER 4API 504	1.8	2.5	22NR 4API 504	1.8	2.5
27	5/8"	2	27ER 4API 506	2.0	2.9	27NR 4API 506	2.0	2.9
27	5/8"	3	27ER 4API 504	2.0	2.9	27NR 4API 504	2.0	2.9

API VO.055

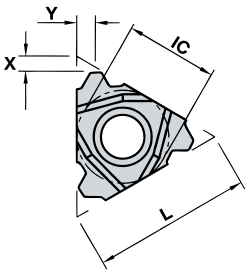
'L' mm	I.C inch	Taper IPF	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
22	1/2"	1 1/2"	22ER 6API 558	1.8	2.5	22NR 6API 558	1.8	2.5

Order Example: **27ER 4API 384 PTC-2**

For **LEFT HAND** inserts, specify **L** instead of **R**

PAC

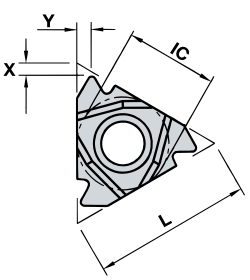
'L' mm	I.C inch	Taper IPF	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
27	5/8"	1 1/2"	27ER 4PAC	2.5	3.0	27NR 4PAC	2.5	3.0



Order Example: **27ER 4PAC PTX**

API CASING & TUBING ROUND (full form) API Spec 5-B

'L' mm	I.C inch	Taper IPF	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
16	3/8"	3/4"	16ER 10API RD	1.3	1.5	16NR 10API RD	1.3	1.5
16	3/8"	3/4"	16ER 8API RD	1.3	1.5	16NR 8API RD	1.3	1.5



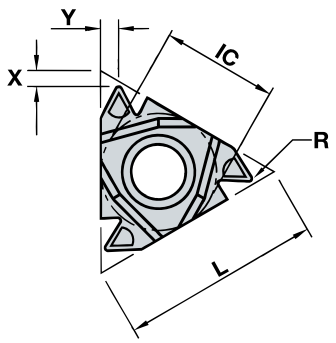
Order Example: **16ER 10API RD PTC2**

TEAR DROP INSERTS PATENTED DESIGN FOR SWARF CONTROL

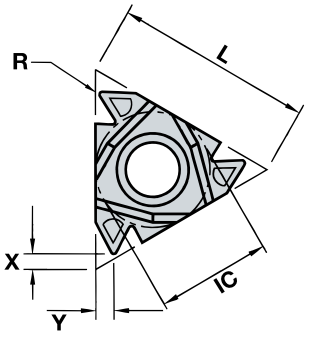
PARTIAL PROFILE THREAD FORMS 60˚ (non topping)

Pitch Range mm	Pitch Range inch	'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
0.5 - 1.5	48 - 16	16	3/8"	16ER A60 TD	0.7	0.8	16NR A60 TD	0.7	0.8
1.0 - 2.5	24 - 11	16	3/8"	16ER AG60 TD	1.3	1.5	16NR AG60 TD	1.3	1.5
1.75 - 3.0	14 - 8	16	3/8"	16ER G60 TD	1.3	1.5	16NR G60 TD	1.3	1.5

ER



NR

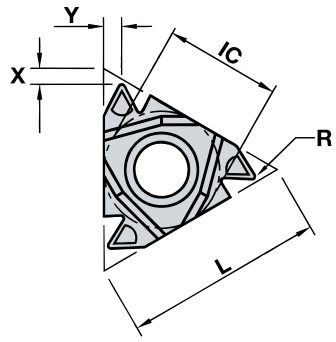


Order Example: **16NR AG60 TD PTC2**

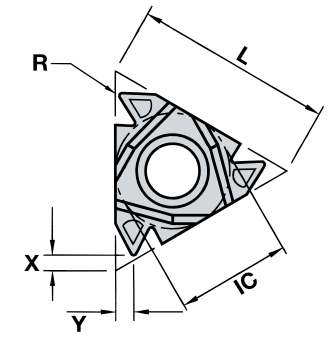
PARTIAL PROFILE THREAD FORMS 55˚ (non topping)

Pitch Range mm	Pitch Range inch	'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
0.5 - 1.5	48 - 16	16	3/8"	16ER A55 TD	0.7	0.8	16NR A55 TD	0.7	0.8
1.0 - 2.5	24 - 11	16	3/8"	16ER AG55 TD	1.3	1.5	16NR AG55 TD	1.3	1.5
1.75 - 3.0	14 - 8	16	3/8"	16ER G55 TD	1.3	1.5	16NR G55 TD	1.3	1.5

ER



NR



Order Example: **16NR AG55 TD PTC2**

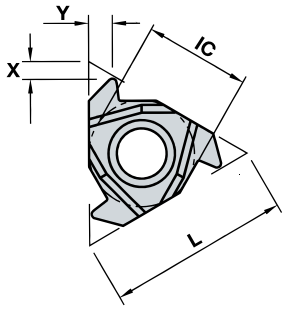
'TD' Threading Inserts
are **NOT** available in **LEFT HAND**

BUTTRESS THREAD FORMS

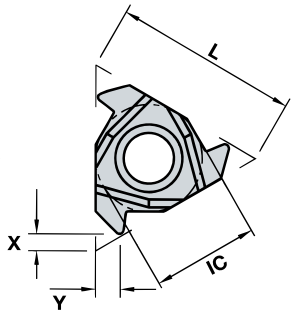
BRITISH BUTTRESS (non topping) (45° lead supplied unless otherwise requested). BS1657

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
16	3/8"	16ER 20 B BUTT	0.7	0.9	16NR 20 B BUTT	0.7	0.9
16	3/8"	16ER 16 B BUTT	0.8	1.2	16NR 16 B BUTT	0.8	1.2
16	3/8"	16ER 12 B BUTT	1.0	1.5	16NR 12 B BUTT	1.0	1.5
16	3/8"	16ER 10 B BUTT	1.2	1.8	16NR 10 B BUTT	1.2	1.8
22	1/2"	22ER 8 B BUTT	1.5	2.3	22NR 8 B BUTT	1.5	2.3
22	1/2"	22ER 6 B BUTT	2.0	3.0	22NR 6 B BUTT	2.0	3.0
27	5/8"	27ER 4 B BUTT	3.0	4.5	27NR 4 B BUTT	3.0	4.5
27	5/8"	27EU 4 B BUTT	2.9	13.5	27NU 4 B BUTT	2.9	13.5

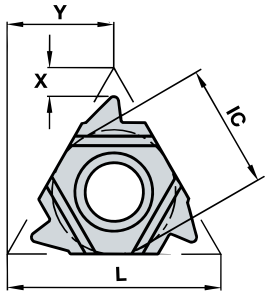
ER



NR



'U'

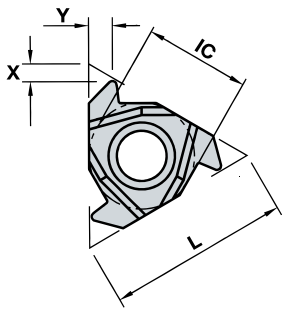


Order Example: **16NR 12B BUTT PTC2**

AMERICAN BUTTRESS (non topping) (45° lead supplied unless otherwise requested). ASME/ANSI B1.9

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
16	3/8"	16ER 20 A BUTT	0.7	1.0	16NR 20 A BUTT	0.7	1.0
16	3/8"	16ER 16 A BUTT	1.0	1.3	16NR 16 A BUTT	1.0	1.3
16	3/8"	16ER 12 A BUTT	1.2	1.8	16NR 12 A BUTT	1.2	1.8
16	3/8"	16ER 10 A BUTT	1.3	2.0	16NR 10 A BUTT	1.3	2.0
22	1/2"	22ER 8 A BUTT	1.6	2.5	22NR 8 A BUTT	1.6	2.5
22	1/2"	22ER 6 A BUTT	2.0	3.1	22NR 6 A BUTT	2.0	3.1
27	5/8"	27ER 4 A BUTT	3.2	5.0	27NR 4 A BUTT	3.2	5.0
27	5/8"	27EU 4 A BUTT	3.1	13.5	27NU 4 A BUTT	3.1	13.5

ER



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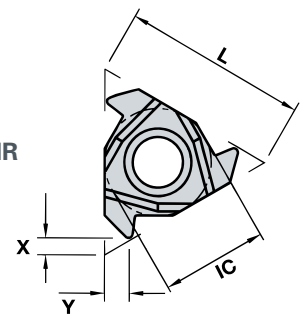
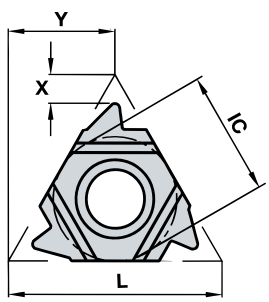


'U'



Order Example: **22NR 6 A BUTT PTX**

For **LEFT HAND** inserts, specify **L** instead of **R**

MULTI-TOOTH INSERTS

ISO (full form)

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
16	3/8"	16ER 1.0ISO 3M	1.7	2.6	16NR 1.0ISO 3M	1.7	2.6
16	3/8"	16ER 1.5ISO 2M	1.6	2.3	16NR 1.5ISO 2M	1.6	2.3
22	1/2"	22ER 2.0ISO 2M	2.0	3.0	22NR 2.0ISO 2M	2.0	3.0
22	1/2"	22ER 2.5ISO 2M	2.4	3.8	22NR 2.5ISO 2M	2.4	3.8
27	5/8"	27ER 3.0ISO 2M	2.7	4.5	27NR 3.0ISO 2M	2.7	4.5

Order Example: **16ER 1.0ISO 3M PTC2**

UNIFIED (full form)

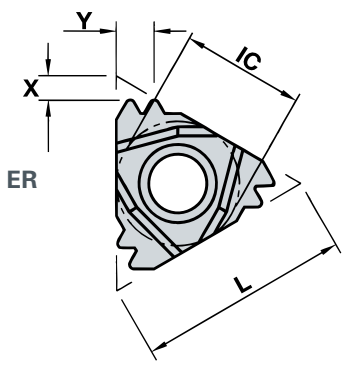
'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
16	3/8"	16ER 16UN 2M	1.7	2.4	16NR 16UN 2M	1.7	2.4
16	3/8"	16ER 12UN 2M	2.4	3.1	16NR 12UN 2M	2.4	3.1
22	1/2"	22ER 12UN 2M	3.2	5.3	22NR 12UN 2M	3.2	5.3
27	5/8"	27ER 8UN 2M	3.0	4.8	27NR 8UN 2M	3.0	4.8

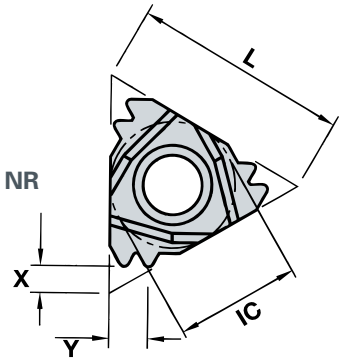
WHITWORTH (full form)

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
16	3/8"	16ER 14W 2M	1.9	2.8	16NR 14W 2M	1.9	2.8
16	3/8"	16ER 14W 3M	2.9	4.6	16NR 14W 3M	2.9	4.6
22	1/2"	22ER 11W 2M	2.0	3.3	22NR 11W 2M	2.0	3.3

NPT (full form)

'L' mm	I.C inch	DESCRIPTION EXTERNAL	'X' mm	'Y' mm	DESCRIPTION INTERNAL	'X' mm	'Y' mm
22	1/2"	22ER 11.5 NPT 2M	2.2	3.3	22NR 11.5 NPT 2M	2.2	3.3
27	5/8"	27ER 11.5 NPT 3M	3.4	5.5	27NR 11.5 NPT 3M	3.4	5.5
27	5/8"	27ER 8NPT 2M	3.0	4.8	27NR 8NPT 2M	3.0	4.8

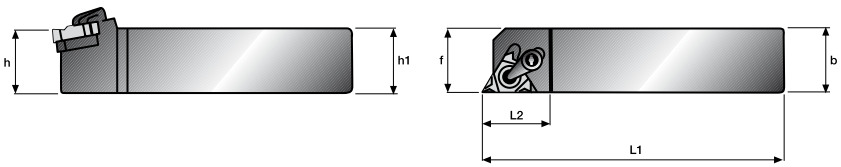




EXTERNAL LAYDOWN TOOLHOLDERS (CLAMP TYPE)

PARALLEL SHANK

(HELIX WITH STANDARD ANVIL +1°)



PART No	DIMENSIONS (mm)					SPARES				INSERT SIZE	
	$h=h_1$	b	L_1	L_2	f	Anvil	Clamp	Screw	Torq Key	mm	inch
CER 1616 - 16	16	16	100	20	16	GX16 -1	CSP16	AS16	T8 - T15	16	3/8"
CER 2020 - 16	20	20	125	25	20	GX16 -1	CSP16	AS16	T8 - T15	16	3/8"
CER 2525 - 16	25	25	150	25	25	GX16 -1	CSP16	AS16	T8 - T15	16	3/8"
CER 3232 - 16	32	32	170	25	32	GX16 -1	CSP16	AS16	T8 - T15	16	3/8"
CER 2525 - 22	25	25	150	28	25	NX22-1	CSP22	AS22	T15	22	1/2"
CER 3232 - 22	32	32	170	28	32	NX22-1	CSP22	AS22	T15	22	1/2"
CER 4040 - 22	40	40	200	28	40	NX22-1	CSP22	AS22	T15	22	1/2"
CER 2525 - 22U	25	25	150	32	25	UX22-1	CSP22	AS22	T15	22	1/2"
CER 3232 - 22U	32	32	170	32	32	UX22-1	CSP22	AS22	T15	22	1/2"
CER 4040 - 22U	40	40	200	32	40	UX22-1	CSP22	AS22	T15	22	1/2"

CRANKED SHANK

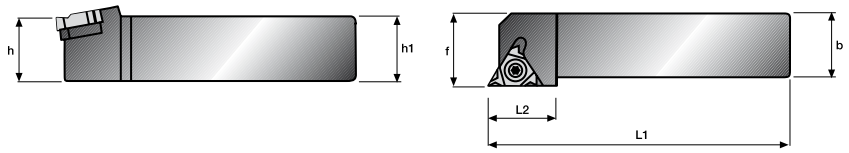
(HELIX WITH STANDARD ANVIL +1°)

PART No	DIMENSIONS (mm)					SPARES				INSERT SIZE	
	$h=h_1$	b	L_1	L_2	f	Anvil	Clamp	Screw	Torq Key	mm	inch
CER 1212 - 16Q	12	12	100	22	16	GX16 -1	CSP16	AS16	T8 - T15	16	3/8"
CER 1616 - 16Q	16	16	100	22	20	GX16 -1	CSP16	AS16	T8 - T15	16	3/8"
CER 2020 - 16Q	20	20	125	22	25	GX16 -1	CSP16	AS16	T8 - T15	16	3/8"
CER 2525 - 16Q	25	25	150	22	32	GX16 -1	CSP16	AS16	T8 - T15	16	3/8"
CER 3232 - 16Q	32	32	170	22	40	GX16 -1	CSP16	AS16	T8 - T15	16	3/8"
CER 2525 - 22Q	25	25	150	28	32	NX22-1	CSP22	AS22	T15	22	1/2"
CER 3232 - 22Q	32	32	170	28	40	NX22-1	CSP22	AS22	T15	22	1/2"
CER 4040 - 22Q	40	40	200	28	50	NX22-1	CSP22	AS22	T15	22	1/2"
CER 2525 - 27Q	25	25	150	33	32	VX27-1	CSP27	AS27	T15 - T25	27	5/8"
CER 3232 - 27Q	32	32	170	33	40	VX27-1	CSP27	AS27	T15 - T25	27	5/8"
CER 4040 - 27Q	40	40	200	33	50	VX27-1	CSP27	AS27	T15 - T25	27	5/8"

EXTERNAL CENTRE SCREW TOOLHOLDERS

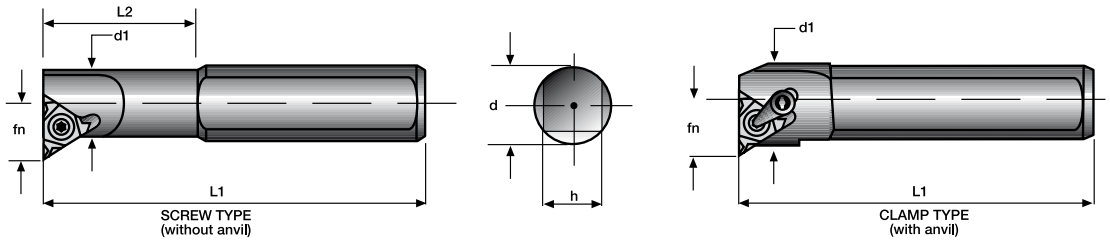
CRANKED SHANK

(HELIX WITH STANDARD ANVIL +1½°)



PART No.	DIMENSIONS (mm)					SPARES				INSERT SIZE	
	$h=h_1$	b	L_1	L_2	f	Anvil	Insert Screw	Side Screw	Torq Key	mm	inch
SEAR 2020 -16Q	20	20	125	30	25	SE16	SA16	SY16	T10 - T20	16	3/8"
SEAR 2525 -16Q	25	25	150	30	32	SE16	SA16	SY16	T10 - T20	16	3/8"
SEAR 3232 -16Q	32	32	175	30	40	SE16	SA16	SY16	T10 - T20	16	3/8"
SEAR 2525 -22Q	25	25	150	30	32	SE22	SA22	SY22	T10 - T20	22	1/2"
SEAR 3232 -22Q	32	32	175	30	40	SE22	SA22	SY22	T10 - T20	22	1/2"

- Special toolholders can be supplied on request.
- Toolholders for special machines such as:- STAR HARDINGE PLATEN CRI-DAN can also be quoted for on request.



LAYDOWN SCREW TYPE

(HELIX IN POCKET +2°)

PART No.	DIMENSIONS (mm)							SPARES		INSERT SIZE	
	d	d_1	L_1	L_2	f_n	h	Min Bore	Screw	Torq Key	mm	inch
SNR 0010 - 11	10	10	125	-	7.5	10	13	S11	T7	11	1/4"
SNR 0010 - 11 -S	16	10	125	30	7.5	14	12	S11	T7	11	1/4"
SNR 0013 -11 - S	16	13	125	35	8.0	14	15	S11	T7	11	1/4"
SNR 0016 - 16	16	16	150	-	10.3	14	19	S16	T15	16	3/8"
SNR 0020 - 16	20	20	170	-	13.0	18	24	S16	T15	16	3/8"
SNR 0020 - 22	20	20	170	-	14.0	18	24	S22	T15	22	1/2"

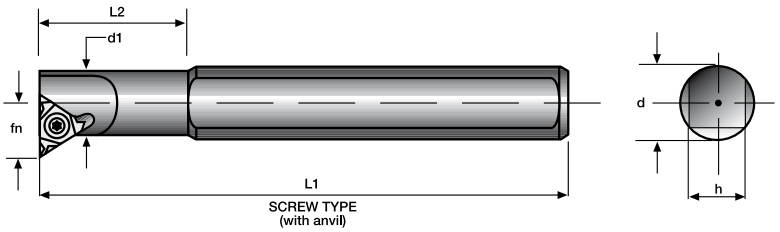
LAYDOWN CLAMP TYPE

(HELIX WITH STANDARD ANVIL +1°)

PART No.	DIMENSIONS (mm)						SPARES		INSERT SIZE			
	d	d_1	L_1	f_n	h	Min Bore	Anvil	Clamp	Screw	Torq Key	mm	inch
CNR 0020 -16	20	20.5	170	13.8	18	24	GX16-1	CSP16	AS16	T8 - T15	16	3/8"
CNR 0025 -16	25	25.5	250	16.3	23	29	GX16-1	CSP16	AS16	T8 - T15	16	3/8"
CNR 0032 -16	32	32.5	250	19.8	29	36	GX16-1	CSP16	AS16	T8 - T15	16	3/8"
CNR 0040 -16	40	40.5	300	23.8	36	44	GX16-1	CSP16	AS16	T8 - T15	16	3/8"
CNR 0050 -16	50	50.5	350	28.8	46	54	GX16-1	CSP16	AS16	T8 - T15	16	3/8"
CNR 0025 -22	25	25.5	250	17.8	23	30	NX22-1	CSP22	AS22	T15	22	1/2"
CNR 0032 -22	32	32.5	250	21.3	29	38	NX22-1	CSP22	AS22	T15	22	1/2"
CNR 0040 -22	40	40.5	300	25.3	36	46	NX22-1	CSP22	AS22	T15	22	1/2"
CNR 0050 -22	50	50.5	350	30.3	46	56	NX22-1	CSP22	AS22	T15	22	1/2"
CNR 0063 -22	63	63.5	400	36.8	59	69	NX22-1	CSP22	AS22	T15	22	1/2"
CNR 0032 -22U	32	32.5	250	21.95	29	40	UX22-1	CSP22	AS22	T15	22U	1/2U
CNR 0040 -22U	40	40.5	300	25.95	36	48	UX22-1	CSP22	AS22	T15	22U	1/2U
CNR 0050 -22U	50	50.5	350	30.95	46	58	UX22-1	CSP22	AS22	T15	22U	1/2U
CNR 0063 -22U	63	63.5	400	37.45	59	70	UX22-1	CSP22	AS22	T15	22U	1/2U
CNR 0032 -27	32	32.5	250	23.0	29	42	VX27-1	CSP27	AS27	T15 - T25	27	5/8"
CNR 0040 -27	40	40.5	300	27.3	36	48	VX27-1	CSP27	AS27	T15 - T25	27	5/8"
CNR 0050 -27	50	50.5	350	32.2	46	58	VX27-1	CSP27	AS27	T15 - T25	27	5/8"
CNR 0063 -27	63	63.5	400	38.7	59	70	VX27-1	CSP27	AS27	T15 - T25	27	5/8"

INTERNAL TOOLHOLDERS

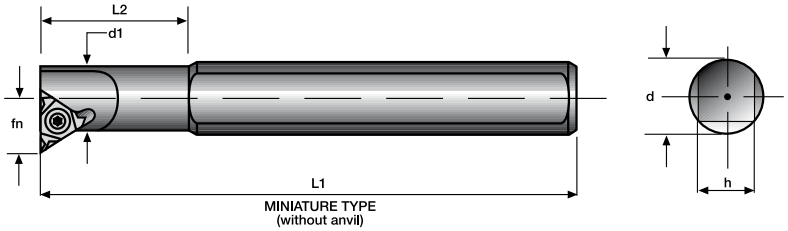
INTERNAL CENTRE SCREW TYPE (HELIX WITH STANDARD ANVIL +1½°)



PART No.	DIMENSIONS (mm)							SPARES				INSERT SIZE	
	d	d_1	L_1	L_2	f_n	h	Min Bore	Anvil	Insert Screw	Side Screw	Torq Key	mm	inch
SNAR 0020 -16	20	20	170	30	13.8	18	24	SN16	SA16	SY16	T10 - T20	16	3/8"
SNAR 0025 -16	25	25	250	30	16.3	23	29	SN16	SA16	SY16	T10 - T20	16	3/8"
SNAR 0032 -16	32	32	300	30	19.8	29	36	SN16	SA16	SY16	T10 - T20	16	3/8"
SNAR 0025 -22	25	25	250	30	17.8	23	30	SN22	SA22	SY22	T10 - T20	22	1/2"
SNAR 0032 -22	32	32	300	30	21.3	29	38	SN22	SA22	SY22	T10 - T20	22	1/2"

MINIATURE SCREW TYPE

(HELIX IN POCKET +2°) (NO ANVIL)



PART No.	DIMENSIONS (mm)							SPARES		INSERT SIZE	
	d	d_1	L_1	L_2	f_n	h	Min Bore	Screw	Torq Key	mm	inch
SNR 0006 -06S	12	5.8	100	13	4.2	11	6.0	S8	T6	06	5/32"
SNR 0006 -08S	16	6.3	125	17	5.1	11	7.8	S8	T6	08	3/16"
SNR 0008 -08US	16	8.2	125	21	6.0	14	9.0	S8	T6	08U	3/16U"
SNR 0008 -08S	16	7.8	125	17	5.8	14	10.0	S8	T6	08	3/16"
SNR 0006 -06S-VF	12	5.2	100	25	4.2	11	6.0	S8	T6	06	5/32"
SNR 0006 -08S-VF	16	6.3	125	30	5.2	11	7.8	S8	T6	08	3/16"
SNR 0008 -08US-VF	16	8.2	125	40	6.3	14	9.0	S8	T6	08U	3/16U"
SNR 0008 -08S-VF	16	8.1	125	40	6.0	14	10.0	S8	T6	08	3/16"

NOTE

Some inserts with coarse thread forms will require a modification to the toolholder to suit the extra depth of thread. For example - 7W or 6ACME should be produced on 22 size inserts as shown in the catalogue. However, these and other similar sizes are listed using the smaller 16 size insert and are available on request. Care is required and machine operators should check toolholder clearances as well as helix angles.

	Grades	
Material Spec.	**PTC2**	**PTX**
Low/Med Carbon Steel	122/140	145/185
High Carbon Steel	100/125	120/160
Alloy/Heat Treated Steel	100/125	115/145
Stainless Steel	90/120	125/140
Cast Iron HB 180-250	105/135	135/185
Non Ferrous Materials	195/245	210/315
High Temp Alloys	28/55	40/85

Speeds and feeds for uncoated inserts upon request

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