



# LAYDOWN THREADING SPECIALS

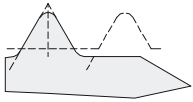
for threading all materials from low carbon steels to exotics



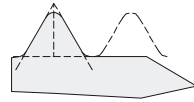
# LAYDOWN THREADING SPECIAL INSERTS

## DELIVERY 14 WORKING DAYS GUARANTEED

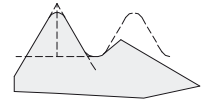
P - PARTIAL FORM



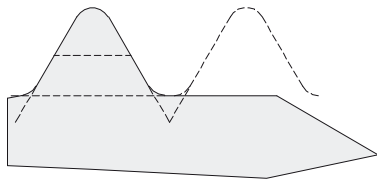
F - FULL FORM



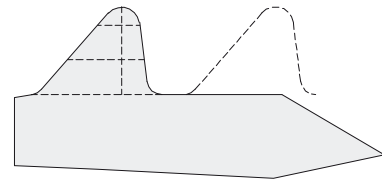
T - FULL FORM TRAILING CRESTING



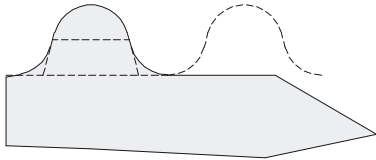
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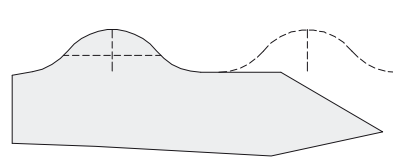
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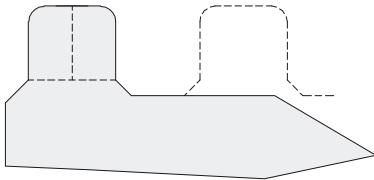
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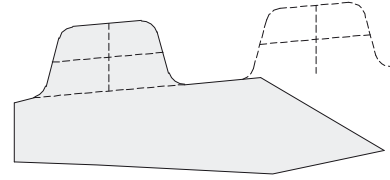
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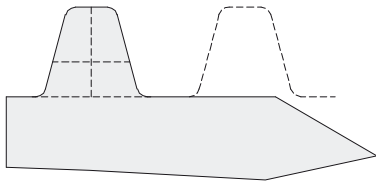
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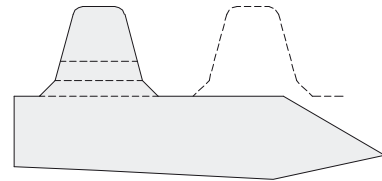
6



7



8



STYLE A – Standard Grind · STYLE B – Additional Clearances fast and slow helix applications

INSERT SIZE PITCH RATIO (dependant on profile form)				
	11	16	22	27
PITCH mm	<=2.0	<=3.5	<=6.35	<=8.47
TPI	<=18	<=7	<=4	<=3

INSERT PRICES MINIMUM 5 OFF				
PTC2/PTX	11	16	22	27
STYLE A	See your distributor for an immediate quotation			
STYLE B				
UNCOATED GRADES LESS 10%				

STANDARD QUANTITY BREAKDOWNS ARE 5 OFF, 20 OFF AND 40 OFF, FOR LESS THAN 5 OFF OR MORE THAN 40 OFF ASK YOUR DISTRIBUTOR FOR A SPECIAL QUOTATION.

Company \_\_\_\_\_

Date \_\_\_\_\_

Contact Name \_\_\_\_\_

Order / Inquiry No. \_\_\_\_\_

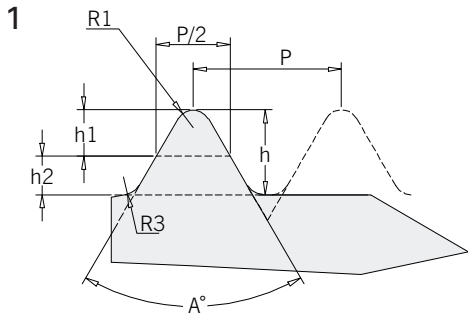
Address \_\_\_\_\_

Telephone \_\_\_\_\_

Mobile \_\_\_\_\_

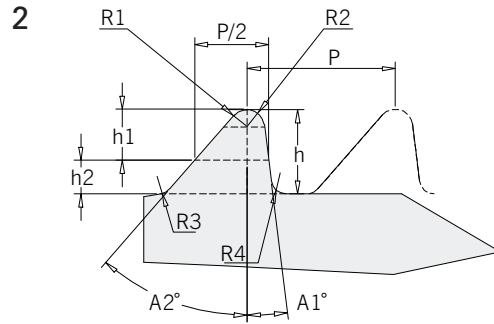
Fax \_\_\_\_\_

Email \_\_\_\_\_



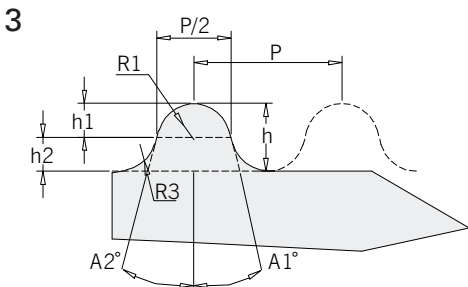
P \_\_\_\_\_  
 P/2 \_\_\_\_\_  
 A° \_\_\_\_\_  
 h \_\_\_\_\_  
 h1 \_\_\_\_\_  
 h2 \_\_\_\_\_  
 R1 \_\_\_\_\_  
 R3 \_\_\_\_\_

STYLE A  STYLE B   
 Leading  Trailing



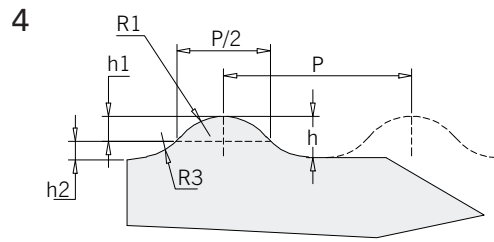
P \_\_\_\_\_  
 P/2 \_\_\_\_\_  
 A1° \_\_\_\_\_  
 A2° \_\_\_\_\_  
 h \_\_\_\_\_  
 h1 \_\_\_\_\_  
 h2 \_\_\_\_\_  
 R1 \_\_\_\_\_  
 R2 \_\_\_\_\_  
 R3 \_\_\_\_\_  
 R4 \_\_\_\_\_

STYLE A  STYLE B   
 Leading  Trailing



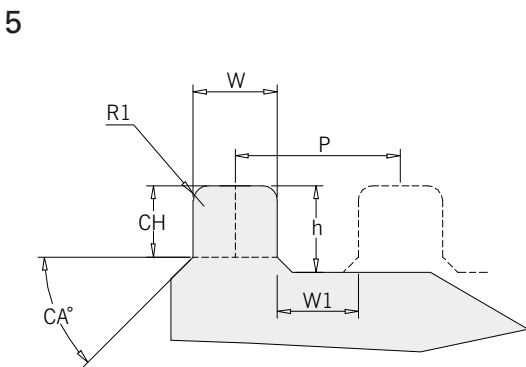
P \_\_\_\_\_  
 P/2 \_\_\_\_\_  
 A1° \_\_\_\_\_  
 A2° \_\_\_\_\_  
 h \_\_\_\_\_  
 h1 \_\_\_\_\_  
 h2 \_\_\_\_\_  
 R1 \_\_\_\_\_  
 R3 \_\_\_\_\_

STYLE A  STYLE B   
 Leading  Trailing



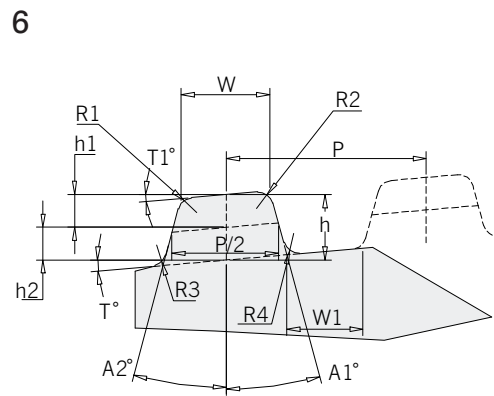
P \_\_\_\_\_  
 P/2 \_\_\_\_\_  
 h \_\_\_\_\_  
 h1 \_\_\_\_\_  
 h2 \_\_\_\_\_  
 R1 \_\_\_\_\_  
 R3 \_\_\_\_\_

STYLE A  STYLE B   
 Leading  Trailing



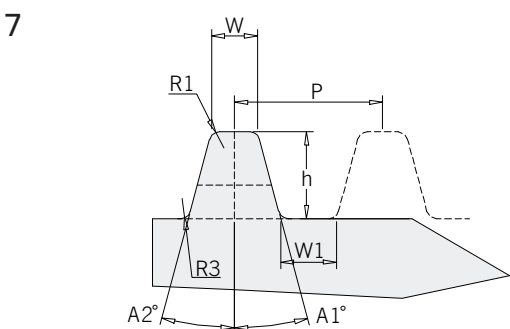
P \_\_\_\_\_  
 W \_\_\_\_\_  
 W1 \_\_\_\_\_  
 h \_\_\_\_\_  
 R1 \_\_\_\_\_  
 CH \_\_\_\_\_  
 CA° \_\_\_\_\_

STYLE A  STYLE B   
 Leading  Trailing



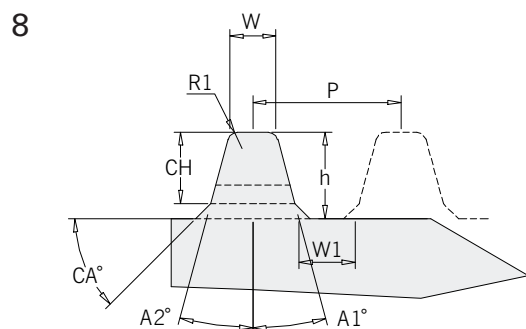
P \_\_\_\_\_  
 P/2 \_\_\_\_\_  
 A1° \_\_\_\_\_  
 A2° \_\_\_\_\_  
 h \_\_\_\_\_  
 h1 \_\_\_\_\_  
 h2 \_\_\_\_\_  
 W \_\_\_\_\_  
 W1 \_\_\_\_\_  
 T \_\_\_\_\_  
 T1 \_\_\_\_\_  
 R1 \_\_\_\_\_  
 R2 \_\_\_\_\_  
 R3 \_\_\_\_\_  
 R4 \_\_\_\_\_

STYLE A  STYLE B   
 Leading  Trailing



P \_\_\_\_\_  
 A1° \_\_\_\_\_  
 A2° \_\_\_\_\_  
 h \_\_\_\_\_  
 W \_\_\_\_\_  
 W1 \_\_\_\_\_  
 R1 \_\_\_\_\_  
 R3 \_\_\_\_\_

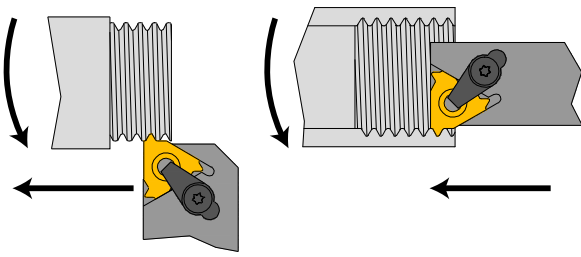
STYLE A  STYLE B   
 Leading  Trailing



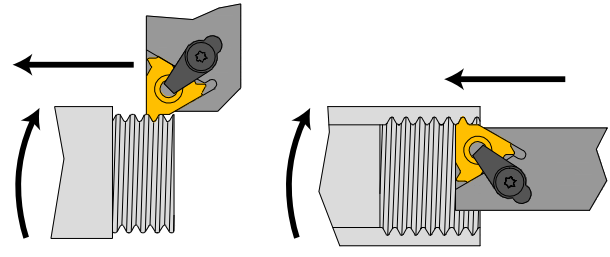
P \_\_\_\_\_  
 A1° \_\_\_\_\_  
 A2° \_\_\_\_\_  
 h \_\_\_\_\_  
 W \_\_\_\_\_  
 W1 \_\_\_\_\_  
 R1 \_\_\_\_\_  
 CH \_\_\_\_\_  
 CA° \_\_\_\_\_

STYLE A  STYLE B   
 Leading  Trailing

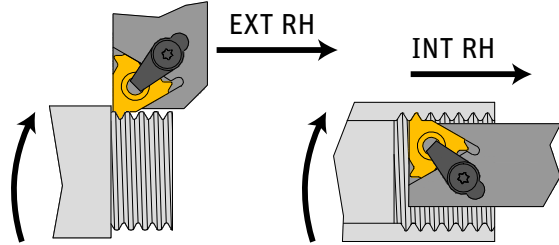
RIGHT HAND THREADS



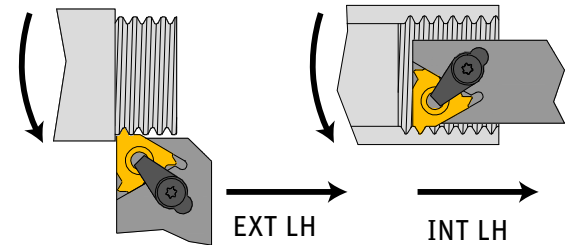
LEFT HAND THREADS



RIGHT HAND THREADS WITH LEFT HAND TOOLING



LEFT HAND THREADS WITH RIGHT HAND TOOLING



INSERT SIZE								
EXTERNAL				16	22	27	33	44
INTERNAL	06	08	11	16	22	27	33	44
I.C.	3.175	4.763	6.35	9.525	12.7	15.875	19.05	25.4

INSERT SIZE PITCH RATIO (dependant on profile form)								
	06	08	11	16	22	27	33	44
PITCH mm	0.25-1.25	<=1.5	<=2.0	<=3.5	<=6.35	<=8.47	<=10.0	<=12.7
TPI	100-20	<=16	<=18	<=7	<=4	<=3	<=2.5	<=2

Material Spec.	Grades	
	PTC2	PTX
1018 Low Carbon Steel	122/140	145/165
4140 (18/22) L80 EN19 EN24 EN34	122/140	145/165
9%-13% Chrome	122/140	145/165
4140 (30-36)	77/102	90/120
4145 (36)	77/102	90/120
T316-17-4PH	90/115	105/135
410 Stainless	90/120	125/140
Super 13% 95KSI	115/128	135/150
Inconel 625	29/46	35/55
Inconel 925	26/36	30/42
Inconel 718	23/28	27/33
K Monel	30/60	40/70
25% Chrome	51/64	60/75
Super 13 Chrome-110KSI	89/102	105/120

Material Spec.	Grades	
	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

APPLICATION	RIGHT HAND	LEFT HAND
EXTERNAL	ER	EL
INTERNAL	NR	NL

