

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

<h1>Internal</h1>	HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD
	<h2>Micro 07</h2>		JP5125
<ul style="list-style-type: none"> M: metric threads W: parallel pipe threads (whitworth) UN: unified inch threads NPT: American national tapered pipe threads BSPT: tapered pipe threads Partial profile with 55° or 60° angle, for metric, unified and parallel pipe threads 	Stable machining, light cut	● 1 st choice ○ suitable	○
	General machining, medium cut	● 1 st choice ○ suitable	●
	Unstable machining, heavy cut	● 1 st choice ○ suitable	●
	Dimensions		ISO
		Vc(m/min) - suggested cutting speed range (bold: 1st choice)	
		P	70 180
		M	50 140
		K	60 180
		N	
		S	
		H	

Designation		RE	TP	PDX	PDY	IC	Stock
PARTIAL PROFILE 60° P M K		0.08	-	0.7	0.6	4.762	●
	07IRA60-TPM						
PARTIAL PROFILE 55° P M K		0.08	-	0.7	0.6	4.762	●
	07IRA55-TPG						

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

PARTIAL PROFILE

- Partial profile insert works without cuts the outer diameter of the thread.
- The same insert can be used for a broad range of different thread pitches.
- Can produce burr that must be taken away.

PARTIAL PROFILE 07IR PITCH RANGES

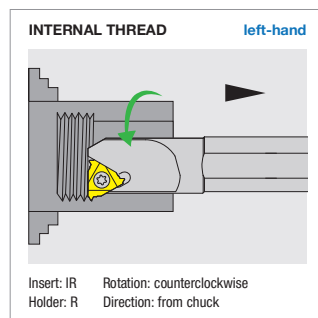
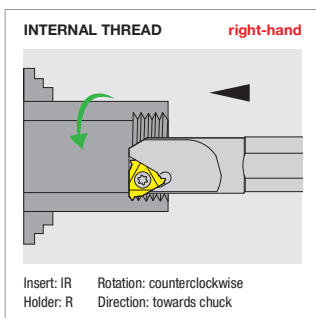
	M	UN
A60	0.50÷1.50	48÷16
BSW-BSF-BSP		
A55	48÷16	

<h1>V SI</h1>		
<h2>Micro 07</h2>		
<ul style="list-style-type: none"> • Internal threading holder • Vortex boring bar (High standard steel) • Special chip evacuation path • With coolant through 		

Designation	Stock		DMIN	DCON	WF	LF	LH	GAMO				MIID
	L	R										
NT-V10H-SI[▲]/R07-08		●	8	10	4	100	20	21°				07IR [∞]

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

Spare parts	Insert screws	Flag wrenches
		
NT-V10H-SIR07-08	NT-ST22049T07	NT-FT07



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<h1>Internal</h1>	HF: Micrograin carbide BL: Low volume CBN DP: Polycrystalline diamond PVD: Physical vapour deposition				HF PVD	HF PVD	BL PVD	DP	
	<h2>ISO 11-16-22</h2>					JP5120	JP5125	NBL350C	ND050
<ul style="list-style-type: none"> M: metric threads W: parallel pipe threads (whitworth) UN: unified inch threads NPT: American national tapered pipe threads BSPT: tapered pipe threads Partial profile with 55° or 60° angle, for metric, unified and parallel pipe threads 	Stable machining, light cut ● 1 st choice ○ suitable	General machining, medium cut ● 1 st choice ○ suitable	Unstable machining, heavy cut ▲ 1 st choice ▼ suitable						
	Dimensions				ISO				
	<p>TP: thread pitch</p> <p>S D1 11 3.18 3.20 16 3.65 4.00 22 4.71 5.00</p>				Vc(m/min) - suggested cutting speed range (bold: 1st choice)				
					P	90 200	70 180		
				M	60 150	50 140			
				K	90 190	60 180			
				N			400 1600		
				S			50 100		
				H		60 140			

FULL PROFILE	Designation	RE	TP	PDX	PDY	IC	Stock			
							●	○	▲	▼
<p>TPM pressed type chip control oriented</p>	11IR100ISO-TPM	0.07	1	0.7	0.8	6.35	●			
	11IR125ISO-TPM	0.09	1.25	0.9	0.8	6.35	●			
	11IR150ISO-TPM	0.11	1.5	1	0.8	6.35	●			
	11IR175ISO-TPM	0.13	1.75	1.1	0.9	6.35	●			
	11IR200ISO-TPM	0.15	2	1.1	0.9	6.35	●			
	16IR100ISO-TPM	0.07	1	0.7	0.8	9.525	●	●		
	16IR125ISO-TPM	0.09	1.25	0.9	0.8	9.525	●	●		
	16IR150ISO-TPM	0.11	1.5	1	0.8	9.525	●	●		
	16IR175ISO-TPM	0.13	1.75	1.2	1.2	9.525	●	●		
	16IR200ISO-TPM	0.15	2	1.3	1.2	9.525	●	●		
	16IR250ISO-TPM	0.18	2.5	1.5	1.2	9.525	●	●		
	16IR300ISO-TPM	0.22	3	1.5	1.2	9.525	●	●		
	22IR350ISO-TPM	0.22	3.5	2.3	1.6	12.7	●			
	22IR400ISO-TPM	0.25	4	2.3	1.6	12.7	●			
	22IR450ISO-TPM	0.28	4.5	2.4	1.6	12.7	●			
	22IR500ISO-TPM	0.32	5	2.3	1.6	12.7	●			

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▼ stock exhaustion

FULL PROFILE



- Full profile insert will form a complete thread profile including the crest.
- The distance between root and crest is controlled.
- The insert can produce only one pitch.
- Higher tool pressure compared to partial profile.

PRESSED VS GROUND

TPM pressed

- Improves the chip control
- Strongly recommended in internal application especially for difficult materials
- Best cost-performance ratio

Precision ground

- Achieves the higher precision
- A sharper cutting edge can guarantee very smooth cutting action
- Every kind of thread's standard can be easily produced using the same blank

<h1>Internal</h1>	HF: Micrograin carbide BL: Low volume CBN DP: Polycrystalline diamond PVD: Physical vapour deposition				HF	HF	BL	DP				
	ISO 11-16-22				PVD	PVD	PVD					
<ul style="list-style-type: none"> M: metric threads W: parallel pipe threads (whitworth) UN: unified inch threads NPT: American national tapered pipe threads BSPT: tapered pipe threads Partial profile with 55° or 60° angle, for metric, unified and parallel pipe threads 	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ⚡ 1 st choice ⚡ suitable	Dimensions		ISO				Vc(m/min) - suggested cutting speed range (bold: 1st choice)				
			TP: thread pitch		P	90 200	70 180					
					M	60 150	50 140					
				K	90 190	60 180						
				N					400 1600			
				S					50 100			
				H			60 140					

FULL PROFILE	Designation	RE	TP	PDX	PDY	IC	Stock				
							●	○	▲	▽	
<p>precision ground sharpness oriented</p>	11IR050ISO	0.036	0.5	0.6	0.6	6.35	●				
	11IR075ISO	0.05	0.75	0.6	0.6	6.35	●				
	11IR100ISO	0.072	1	0.7	0.6	6.35	●				
	11IR125ISO	0.09	1.25	0.9	0.8	6.35	●				
	11IR150ISO	0.11	1.5	1	0.8	6.35	●				
	11IR175ISO	0.13	1.75	1.1	0.9	6.35	●				
	11IR200ISO	0.15	2	1.3	1	6.35	●				
	16IR100ISO	0.072	1	0.7	0.6	9.525	●				
	16IR125ISO	0.09	1.25	0.9	0.8	9.525	●				
	16IR150ISO	0.11	1.5	1	0.8	9.525	●				
	16IR175ISO	0.13	1.75	1.2	0.9	9.525	●				
	16IR200ISO	0.14	2	1.3	1	9.525	●				
	16IR250ISO	0.18	2.5	1.5	1.1	9.525	●				
	16IR300ISO	0.22	3	1.5	1.1	9.525	●				
	<p>precision ground left-hand</p>	11IL050ISO	0.036	0.5	0.6	0.6	6.35	●			
		11IL075ISO	0.05	0.75	0.6	0.6	6.35	●			
11IL100ISO		0.072	1	0.7	0.6	6.35	●				
11IL125ISO		0.09	1.25	0.9	0.8	6.35	●				
11IL150ISO		0.11	1.5	1	0.8	6.35	●				
11IL175ISO		0.13	1.75	1.1	0.9	6.35	●				
11IL200ISO		0.14	2	1.3	1	6.35	●				
16IL100ISO		0.072	1	0.7	0.6	9.525	●				
16IL125ISO		0.09	1.25	0.9	0.8	9.525	●				
16IL150ISO		0.11	1.5	1	0.8	9.525	●				
16IL175ISO		0.13	1.75	1.2	0.9	9.525	●				
16IL200ISO		0.14	2	1.3	1	9.525	●				
16IL250ISO		0.18	2.5	1.5	1.1	9.525	●				
16IL300ISO		0.22	3	1.5	1.1	9.525	●				

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	<h2>ISO 11-16-22</h2>					JP5120	JP5125	NBL350C	ND050
<ul style="list-style-type: none"> M: metric threads W: parallel pipe threads (whitworth) UN: unified inch threads NPT: American national tapered pipe threads BSPT: tapered pipe threads Partial profile with 55° or 60° angle, for metric, unified and parallel pipe threads 	Stable machining, light cut ● 1 st choice ○ suitable	General machining, medium cut ● 1 st choice ○ suitable	Unstable machining, heavy cut ● 1 st choice ○ suitable						
	Dimensions				ISO				
	<p>TP: thread pitch</p> <p>RE, PDY, PDX, S, D1, IC</p> <p>3 edges</p> <p>11 3.18 3.20 16 3.65 4.00 22 4.71 5.00</p>				Vc(m/min) - suggested cutting speed range (bold: 1st choice)				
					P	90 200	70 180		
	M	60 150	50 140						
	K	90 190	60 180						
	N						400 1600		
	S						50 100		
	H					60 140			

FULL PROFILE	Designation	RE	TP	PDX	PDY	IC	Stock			
							●	○	▲	▽
M N <p>PCD carbide backed single edge</p>	16IR100ISO-1C	0.08	1	0.7	0.8	9.525				●
	16IR125ISO-1C	0.09	1.25	0.9		9.525				●
	16IR150ISO-1C	0.11	1.5	1		9.525				●
	16IR175ISO-1C	0.13	1.75	1.2		9.525				●
	16IR200ISO-1C	0.15	2	1.3		9.525				●
	16IR250ISO-1C	0.18	2.5	1.5		9.525				●
	16IR300ISO-1C	0.22	3	1.5		9.525				●
M H <p>PCBN solid brazing single edge</p>	16IR100ISO-1S	0.08	1	0.7	0.8	9.525				●
	16IR125ISO-1S	0.09	1.25	0.9		9.525				●
	16IR150ISO-1S	0.11	1.5	1		9.525				●
	16IR175ISO-1S	0.13	1.75	1.2		9.525				●
	16IR200ISO-1S	0.15	2	1.3		9.525				●
	16IR250ISO-1S	0.18	2.5	1.5		9.525				●
	16IR300ISO-1S	0.22	3	1.5		9.525				●
W P M K <p>TPM pressed type chip control oriented</p>	11IR14W-TPM	0.24	14	1.1	0.9	6.35				●
	16IR11W-TPM	0.3	11	1.5	1.2	9.525	●	●		
	16IR14W-TPM	0.24	14	1.5	1.2	9.525	●	●		
	16IR19W-TPM	0.17	19	1	0.8	9.525				●
UN P M K <p>TPM pressed type chip control oriented</p>	16IR08UN-TPM	0.23	8	1.7	1.3	9.525				●
	16IR12UN-TPM	0.16	12	1.5	1.2	9.525				●
	16IR14UN-TPM	0.13	14	1.5	1.2	9.525				●
	16IR16UN-TPM	0.12	16	1.1	0.9	9.525				●
	16IR18UN-TPM	0.1	18	1	0.8	9.525				●
	16IR20UN-TPM	0.09	20	0.9	0.8	9.525				●
	16IR24UN-TPM	0.08	24	0.8	0.8	9.525				●

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FULL PROFILE

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- The distance between root and crest is controlled.
- The insert can produce only one pitch.
- Higher tool pressure compared to partial profile.

ADVANCED THREADING

PCBN for ISO H

Please increase the number of passes when machining hardened steel with PCBN inserts. Keep the maximum infeed value lower than 0.10 mm

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	ISO 11-16-22				JP5120	JP5125	NBL350C	ND050	
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	Dimensions		ISO						
			Vc(m/min) - suggested cutting speed range (bold: 1st choice)						
			P	90 200	70 180				
	M	60 150	50 140						
	K	90 190	60 180						
	N					400 1600			
	S					50 100			
	H						60 140		

	Designation	RE	TP	PDX	PDY	IC	Stock						
							●	○	▲	▽			
FULL PROFILE	NPT P M K 												
	16IR11.5NPT-TPM	0.25	11.5	1.5	1.2	9.525	●						
	16IR14NPT-TPM	0.22	14	1.5	1.2	9.525	●						
	TPM pressed type chip control oriented												
	16IR18NPT-TPM	0.2	18	1	0.8	9.525	●						
FULL PROFILE	NPT P M K 												
	16IR11.5NPT	0.07	11.5	1.5	1.1	9.525	●						
	precision ground sharpness oriented												
	16IR14NPT	0.06	14	1	0.8	9.525	●						
FULL PROFILE	BSPT P M K 												
	16IR11BSPT-TPM	0.3	11	1.5	1.2	9.525	●						
	16IR14BSPT-TPM	0.24	14	1.5	1.2	9.525	●						
	16IR19BSPT-TPM	0.17	19	1	0.8	9.525	●						
	TPM pressed type chip control oriented												
	16IR28BSPT-TPM	0.11	28	0.8	0.7	9.525	●						
PARTIAL PROFILE	60° P M K 												
	11IRA60-TPM	0.08	-	0.9	0.8	6.35	●						
	16IRA60-TPM	0.08	-	0.9	0.8	9.525	●						
	16IRAG60-TPM	0.08	-	1.5	1.1	9.525	●						
	16IRG60-TPM	0.13	-	1.7	1.2	9.525	●						
	22IRN60-TPM	0.25	-	2.5	1.7	12.7	●						

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- The same insert can be used for a broad range of different thread pitches.
- Can produce burr that must be taken away.

PARTIAL PROFILE 60° PITCH RANGES

	M	UN
A60	0.50÷1.50	48÷16
AG60	0.50÷3.00	48÷8
G60	1.75÷3.00	14÷8
N60	3.50÷5.00	7÷5

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<h1>Internal</h1>	HF: Micrograin carbide BL: Low volume CBN DP: Polycrystalline diamond PVD: Physical vapour deposition				HF PVD	HF PVD	BL PVD	DP					
	<h2>ISO 11-16-22</h2>					JP5120	JP5125	NB1350C	ND050				
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	Dimensions				ISO								
	<p>TP: thread pitch</p> <p>S D1 111 3.18 3.20 161 3.65 4.00 221 4.71 5.00</p>				P		Vc(m/min) - suggested cutting speed range (bold: 1st choice)						
					M	K	N	S	H	90 200	70 180	60 150	50 140

PARTIAL PROFILE	Designation	RE	TP	PDX	PDY	IC	Stock			
							●	○	▲	▽
<p>TPM pressed type chip control oriented</p>	55° P M K 111RA55-TPM	0.08	-	0.9	0.8	6.35	●			
	161RA55-TPM	0.08	-	0.9	0.8	9.525	●			
	161RAG55-TPM	0.08	-	1.5	1.1	9.525	●			
	161RG55-TPM	0.21	-	1.7	1.2	9.525	●			
	221RN55-TPM	0.44	-	2.5	1.7	12.7	●			

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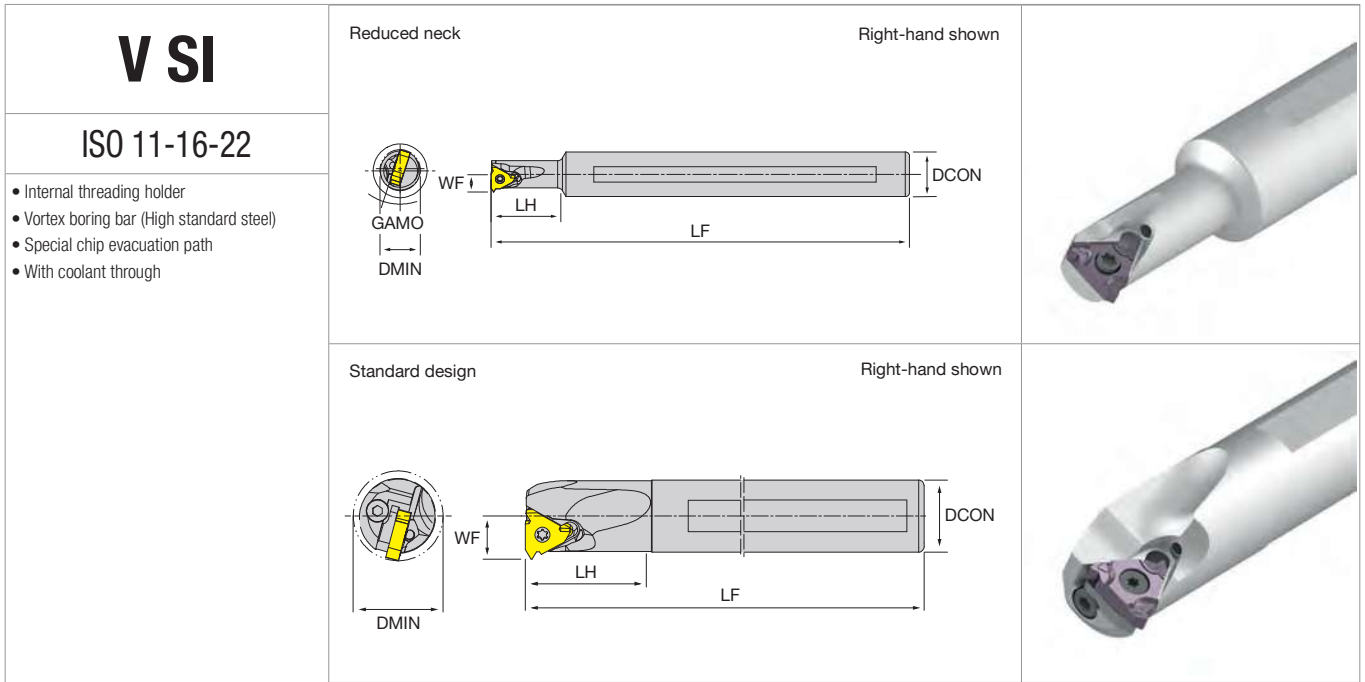
PARTIAL PROFILE



- Partial profile insert works without cuts the outer diameter of the thread.
- The same insert can be used for a broad range of different thread pitches.
- Can produce burr that must be taken away.

PARTIAL PROFILE 55° PITCH RANGES

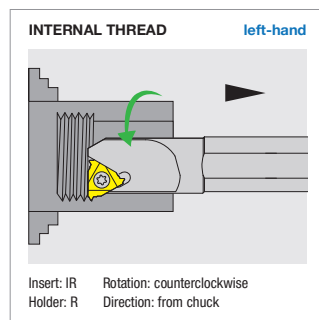
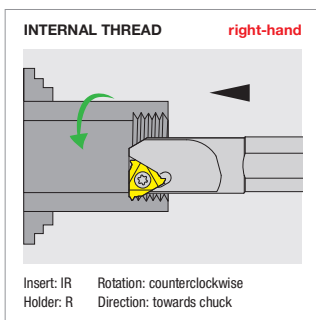
	BSW-BSF-BSP
A55	48÷16
AG55	48÷8
G55	14÷8
N55	7÷5



Designation	Stock		DMIN	DCON	WF	LF	LH	GAMO			MIID
	L	R									
REDUCED NECK											
NT-V16M-SI/11-12		●	12	16	6.3	150	25	18°			11IR000
NT-V16M-SI/11-15		●	15	16	7.5	150	25	18°			11IR000
STANDARD DESIGN											
NT-V10M-SI/11-10		●	10	10	5.2	150	25	21°			11IR000
NT-V16M-SI/16-20		●	20	16	10	150	35	15°			16IR000
NT-V20Q-SI/16-24		●	24	20	12	180	35	15°			16IR000
NT-V25R-SI/16-30		●	30	25	15	200	35	15°			16IR000
NT-V32S-SI/16-37		●	37	32	18.5	250	35	15°			16IR000

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Spare parts	Shim	Locking screws	L wrench	Insert screws	Flag wrenches
NT-V00M-SIR11-∞	-	-	-	NT-ST25059T08	NT-FT08
NT-V16M-SIR16-20	-	-	-	NT-ST35089T15	NT-FT15
NT-V20Q-SIR16-24	NT-SH065	NT-SC003	NT-WR025	NT-ST35120T15	NT-FT15
NT-V25R-SIR16-30	NT-SH065	NT-SC003	NT-WR025	NT-ST35120T15	NT-FT15
NT-V32S-SIR16-37	NT-SH065	NT-SC003	NT-WR025	NT-ST35120T15	NT-FT15



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G - SPARE PARTS

SI

ISO 11-16-22

- Internal threading holder
- Steel boring bar
- Without coolant through
- Small diameters with reduced neck

Reduced neck Right-hand shown

Standard design Right-hand shown

Designation	Stock		DMIN	DCON	WF	LF	LH	GAMO			MIID
	L	R									
REDUCED NECK											
NT-SI/r1012-11		●	10	12	5.2	150	25	21°			11IRoo
NT-SI/r1216-11		●	12	16	6.3	150	25	18°			11IRoo
NT-SI/r1516-11		●	15	16	7.5	150	25	15°			11IRoo
STANDARD DESIGN											
NT-SI/r2016-16	●	●	20	16	10	150	35	15°			16IL/Roo
NT-SI/r2420S-16	●	●	24	20	12	180	35	15°			16IL/Roo
NT-SI/r3025S-16	●	●	30	25	15	200	35	15°			16IL/Roo
NT-SI/r3732S-16	●	●	37	32	18.5	250	35	15°			16IL/Roo
NT-SI/r3025S-22		●	30	25	16	200	35	15°			22IRoo
NT-SI/r3732S-22		●	37	32	19.5	250	35	15°			22IRoo
NT-SI/r4440S-22		●	44	40	24.5	300	35	15°			22IRoo

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

Spare parts	Shim	Shim	Locking screws	L wrench	Insert screws	Flag wrenches
NT-SI/r0000-11	-	-	-	-	NT-ST25059T08	NT-FT08
NT-SI/r0000-16	-	-	-	-	NT-ST35089T15	NT-FT15
NT-SIL0000S-16	NT-SH060	-	NT-SC003	NT-WR025	NT-ST35115T15	NT-FT15
NT-SIR0000S-16	-	NT-SH065	NT-SC003	NT-WR025	NT-ST35115T15	NT-FT15
NT-SIR0000S-22	-	NT-SH067	NT-SC004	NT-WR030	NT-ST40140T15	NT-FT15

INTERNAL THREAD right-hand

Insert: IR Rotation: counterclockwise
Holder: R Direction: towards chuck

INTERNAL THREAD left-hand

Insert: IL Rotation: clockwise
Holder: L Direction: towards chuck

INTERNAL THREAD right-hand

Insert: IL Rotation: clockwise
Holder: L Direction: from chuck

INTERNAL THREAD left-hand

Insert: IR Rotation: counterclockwise
Holder: R Direction: from chuck

M - Internal ISO-metric threads

TP	6.00	5.50	5.00	4.50	4.00	3.50	3.00	2.50	2.00	1.75	1.50	1.25	1.00	0.80	0.75	0.70	0.50	
NO. OF INFEEDS	RADIAL INFEED PER PASS																	
1	0.46	0.43	0.42	0.37	0.34	0.32	0.28	0.26	0.23	0.22	0.20	0.17	0.17	0.17	0.16	0.13	0.10	
2	0.43	0.40	0.40	0.34	0.31	0.30	0.26	0.25	0.21	0.20	0.18	0.17	0.15	0.14	0.13	0.12	0.08	
3	0.35	0.33	0.32	0.28	0.24	0.24	0.21	0.18	0.17	0.15	0.15	0.14	0.11	0.11	0.10	0.10	0.07	
4	0.30	0.26	0.26	0.23	0.21	0.19	0.16	0.15	0.15	0.13	0.13	0.10	0.09	0.07	0.07	0.07	0.06	
5	0.26	0.22	0.22	0.21	0.18	0.17	0.14	0.13	0.12	0.10	0.11	0.09	0.08	-	-	-	-	
6	0.22	0.20	0.20	0.19	0.15	0.15	0.13	0.12	0.11	0.09	0.08	0.08	-	-	-	-	-	
7	0.20	0.18	0.17	0.16	0.14	0.14	0.12	0.11	0.10	0.08	-	-	-	-	-	-	-	
8	0.19	0.17	0.16	0.15	0.13	0.13	0.11	0.10	0.08	0.08	-	-	-	-	-	-	-	
9	0.18	0.16	0.16	0.14	0.12	0.12	0.10	0.10	-	-	-	-	-	-	-	-	-	
10	0.16	0.15	0.15	0.13	0.12	0.11	0.10	0.08	-	-	-	-	-	-	-	-	-	
11	0.15	0.14	0.14	0.12	0.11	0.10	0.09	-	-	-	-	-	-	-	-	-	-	
12	0.15	0.14	0.14	0.12	0.10	0.08	0.08	-	-	-	-	-	-	-	-	-	-	
13	0.14	0.13	0.12	0.11	0.10	-	-	-	-	-	-	-	-	-	-	-	-	
14	0.13	0.12	0.10	0.10	0.08	-	-	-	-	-	-	-	-	-	-	-	-	
15	0.12	0.12	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
16	0.10	0.10	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
TOTAL INFEED	3.54	3.25	2.96	2.65	2.33	2.05	1.78	1.48	1.17	1.05	0.85	0.75	0.60	0.49	0.46	0.42	0.31	

green background are standard items all other sizes can make specials

W - Internal Whitworth threads

TP	4	4.5	5	6	7	8	9	10	11	12	14	16	18	19	20	26	28	
NO. OF INFEEDS	RADIAL INFEED PER PASS																	
1	0.49	0.46	0.45	0.38	0.37	0.32	0.30	0.29	0.28	0.28	0.24	0.24	0.23	0.22	0.21	0.19	0.18	
2	0.46	0.43	0.43	0.36	0.35	0.30	0.28	0.27	0.26	0.26	0.22	0.22	0.22	0.22	0.21	0.18	0.17	
3	0.38	0.38	0.38	0.30	0.29	0.24	0.23	0.22	0.22	0.22	0.18	0.19	0.19	0.18	0.17	0.15	0.14	
4	0.36	0.33	0.32	0.26	0.25	0.21	0.20	0.19	0.19	0.18	0.15	0.16	0.16	0.14	0.14	0.12	0.12	
5	0.34	0.29	0.28	0.22	0.22	0.19	0.18	0.17	0.16	0.16	0.13	0.13	0.13	0.12	0.11	0.08	0.08	
6	0.31	0.25	0.25	0.21	0.19	0.17	0.15	0.15	0.14	0.14	0.11	0.11	0.08	0.08	0.08	-	-	
7	0.29	0.24	0.22	0.19	0.18	0.15	0.14	0.14	0.13	0.13	0.09	0.08	-	-	-	-	-	
8	0.27	0.22	0.20	0.17	0.16	0.14	0.13	0.13	0.12	0.08	0.08	-	-	-	-	-	-	
9	0.24	0.20	0.19	0.16	0.15	0.13	0.12	0.12	0.08	-	-	-	-	-	-	-	-	
10	0.22	0.18	0.18	0.15	0.14	0.12	0.12	0.08	-	-	-	-	-	-	-	-	-	
11	0.20	0.17	0.17	0.14	0.12	0.12	0.08	-	-	-	-	-	-	-	-	-	-	
12	0.19	0.16	0.15	0.14	0.08	0.08	-	-	-	-	-	-	-	-	-	-	-	
13	0.17	0.15	0.12	0.12	-	-	-	-	-	-	-	-	-	-	-	-	-	
14	0.15	0.14	0.10	0.10	-	-	-	-	-	-	-	-	-	-	-	-	-	
15	0.12	0.12	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
16	0.10	0.10	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
TOTAL INFEED	4.29	3.82	3.44	2.90	2.50	2.17	1.93	1.76	1.58	1.45	1.20	1.13	1.01	0.96	0.92	0.72	0.69	

green background are standard items all other sizes can make specials

- A - TURNING
- B - THREADING
- C - GROOVING
- D - MILLING
- E - DRILLING
- F - ACCESSORIES
- G - SPARE PARTS

UN - Internal UN threads

TP	4	4.5	5	6	7	8	9	10	11	12	13	14	16	18	20	24	28	32
NO. OF INFEEDES	RADIAL INFEEDE PER PASS																	
1	0.44	0.41	0.42	0.35	0.34	0.30	0.28	0.27	0.27	0.27	0.25	0.23	0.22	0.23	0.20	0.18	0.17	0.17
2	0.41	0.38	0.38	0.33	0.32	0.28	0.26	0.25	0.23	0.23	0.20	0.18	0.18	0.17	0.16	0.15	0.14	0.14
3	0.39	0.34	0.33	0.25	0.24	0.22	0.19	0.18	0.18	0.18	0.15	0.14	0.14	0.14	0.13	0.13	0.09	0.10
4	0.33	0.28	0.27	0.21	0.21	0.18	0.16	0.15	0.15	0.15	0.13	0.13	0.12	0.12	0.10	0.10	0.08	0.08
5	0.28	0.23	0.23	0.18	0.17	0.15	0.14	0.13	0.13	0.13	0.12	0.11	0.10	0.10	0.09	0.08	0.08	-
6	0.24	0.20	0.20	0.16	0.15	0.13	0.13	0.12	0.11	0.11	0.11	0.10	0.09	0.08	0.08	-	-	-
7	0.22	0.19	0.18	0.15	0.14	0.12	0.12	0.11	0.11	0.10	0.10	0.09	0.08	-	-	-	-	-
8	0.21	0.18	0.17	0.14	0.13	0.11	0.11	0.10	0.10	0.08	0.08	0.08	-	-	-	-	-	-
9	0.20	0.17	0.16	0.13	0.12	0.11	0.10	0.10	0.08	-	-	-	-	-	-	-	-	-
10	0.18	0.16	0.15	0.12	0.12	0.10	0.09	0.08	-	-	-	-	-	-	-	-	-	-
11	0.17	0.15	0.14	0.12	0.11	0.10	0.08	-	-	-	-	-	-	-	-	-	-	-
12	0.16	0.14	0.14	0.11	0.08	0.08	-	-	-	-	-	-	-	-	-	-	-	-
13	0.15	0.14	0.12	0.11	-	-	-	-	-	-	-	-	-	-	-	-	-	-
14	0.14	0.13	0.10	0.10	-	-	-	-	-	-	-	-	-	-	-	-	-	-
15	0.12	0.12	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
16	0.10	0.10	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
TOTAL INFEEDE	3.74	3.32	2.99	2.46	2.13	1.88	1.66	1.49	1.36	1.25	1.14	1.06	0.93	0.84	0.76	0.64	0.56	0.49

green background are standard items all other sizes can make specials

NPT - Internal NPT threads

TP	8	11.5	14	18	27.0
NO. OF INFEEDES	RADIAL INFEEDE PER PASS				
1	0.28	0.28	0.28	0.28	0.28
2	0.25	0.25	0.25	0.25	0.25
3	0.22	0.22	0.22	0.22	0.22
4	0.19	0.19	0.19	0.19	0.19
5	0.18	0.18	0.18	0.18	0.18
6	0.18	0.18	0.18	0.18	0.18
7	0.17	0.17	0.17	0.17	0.17
8	0.17	0.17	0.17	0.17	0.17
9	0.16	0.16	0.16	0.16	0.16
10	0.16	0.16	0.16	0.16	0.16
11	0.14	0.14	0.14	0.14	0.14
12	0.13	0.13	0.13	0.13	0.13
13	0.12	0.12	0.12	0.12	0.12
14	0.11	0.11	0.11	0.11	0.11
15	0.08	0.08	0.08	0.08	0.08
TOTAL INFEEDE	2.54	1.76	1.45	1.12	0.75

green background are standard items all other sizes can make specials

BSPT - British tapered pipe threads

TP	11	14	19	28
NO. OF INFEEDES	RADIAL INFEEDE PER PASS			
1	0.25	0.24	0.22	0.17
2	0.23	0.20	0.19	0.14
3	0.21	0.17	0.15	0.11
4	0.18	0.14	0.12	0.10
5	0.16	0.12	0.12	0.06
6	0.14	0.12	0.06	-
7	0.13	0.11	-	-
8	0.12	0.06	-	-
9	0.06	-	-	-
TOTAL INFEEDE	1.58	1.20	0.86	0.58

green background are standard items all other sizes can make specials