
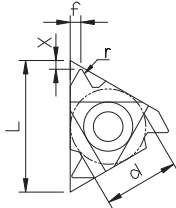
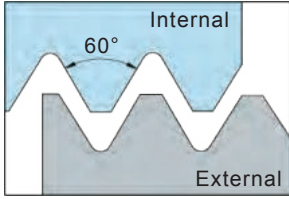



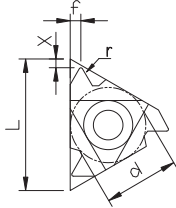
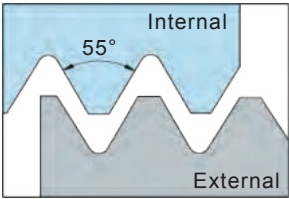
Partial profile
60° thread angle

Grade: TG3225

						(mm)																																																																									
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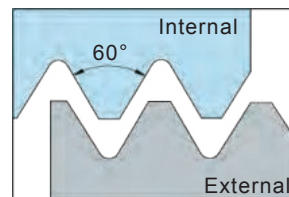
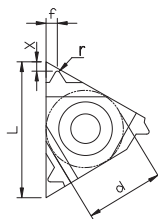
Partial profile
55° thread angle

Grade: TG3225

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Full profile
ISO Metric

Grade: TG3225



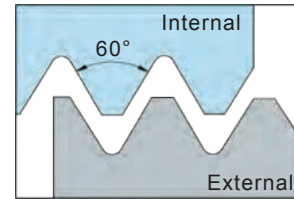
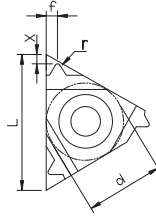
(mm)

Type	Order No.	Pitch	Dimension (mm)				
			L	X	f	r	d
External	16ER1.00ISO-TC	1	16	0.8	0.7	0.14	9.525
	16ER1.25ISO-TC	1.25	16	0.8	0.9	0.18	9.525
	16ER1.50ISO-TC	1.5	16	0.8	1	0.22	9.525
	16ER1.75ISO-TC	1.75	16	1.2	1.2	0.25	9.525
	16ER2.00ISO-TC	2	16	1.2	1.3	0.29	9.525
	16ER2.50ISO-TC	2.5	16	1.2	1.5	0.36	9.525
	16ER3.00ISO-TC	3	16	1.2	1.5	0.43	9.525
	22ER3.50ISO-TC	3.5	22	1.6	2.3	0.45	12.7
	22ER4.00ISO-TC	4	22	1.6	2.3	0.52	12.7
	22ER4.50ISO-TC	4.5	22	1.7	2.4	0.58	12.7
	22ER5.00ISO-TC	5	22	1.7	2.5	0.63	12.7
Internal	11IR1.00ISO-TC	1	11	0.8	0.7	0.07	6.35
	11IR1.25ISO-TC	1.25	11	0.8	0.9	0.09	6.35
	11IR1.50ISO-TC	1.5	11	0.8	1	0.11	6.35
	11IR1.75ISO-TC	1.75	11	0.9	1.1	0.13	6.35
	11IR2.00ISO-TC	2	11	0.9	1.1	0.15	6.35
	16IR1.00ISO-TC	1	16	0.8	0.7	0.07	9.525
	16IR1.25ISO-TC	1.25	16	0.8	0.9	0.09	9.525
	16IR1.50ISO-TC	1.5	16	0.8	1	0.11	9.525
	16IR1.75ISO-TC	1.75	16	1.2	1.2	0.13	9.525
	16IR2.00ISO-TC	2	16	1.2	1.3	0.15	9.525
	16IR2.50ISO-TC	2.5	16	1.2	1.5	0.18	9.525
	16IR3.00ISO-TC	3	16	1.2	1.5	0.22	9.525
	22IR3.50ISO-TC	3.5	22	1.6	2.3	0.22	12.7
	22IR4.00ISO-TC	4	22	1.6	2.3	0.25	12.7
	22IR4.50ISO-TC	4.5	22	1.6	2.4	0.28	12.7
	22IR5.00ISO-TC	5	22	1.6	2.3	0.32	12.7

Insert
External Toolholder
Internal Toolholder
Threading
Parting, Grooving
Miniature Tool

Full profile
Unified

Grade: TG3225

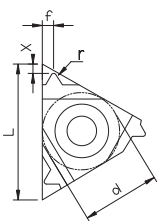
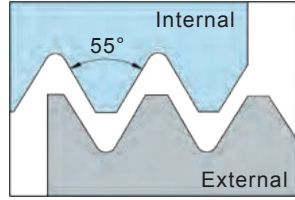


(mm)

Type	Order No.	Pitch	Dimension (mm)				
			L	X	f	r	d
External	16ER24UN-TC	24	16	0.8	0.8	0.15	9.525
	16ER20UN-TC	20	16	0.8	0.9	0.18	9.525
	16ER18UN-TC	18	16	0.8	1	0.2	9.525
	16ER16UN-TC	16	16	0.9	1.1	0.23	9.525
	16ER14UN-TC	14	16	1.2	1.5	0.26	9.525
	16ER12UN-TC	12	16	1.2	1.5	0.31	9.525
	16ER10UN-TC	10	16	1.2	1.5	0.37	9.525
	16ER8UN-TC	8	16	1.3	1.7	0.46	9.525
Internal	11IR20UN-TC	20	11	0.8	0.9	0.09	6.35
	11IR18UN-TC	18	11	0.8	1	0.1	6.35
	16IR24UN-TC	24	16	0.8	0.8	0.08	9.525
	16IR20UN-TC	20	16	0.8	0.9	0.09	9.525
	16IR18UN-TC	18	16	0.8	1	0.1	9.525
	16IR16UN-TC	16	16	0.9	1.1	0.12	9.525
	16IR14UN-TC	14	16	1.2	1.5	0.13	9.525
	16IR12UN-TC	12	16	1.2	1.5	0.16	9.525
	16IR10UN-TC	10	16	1.2	1.5	0.19	9.525
	16IR8UN-TC	8	16	1.3	1.7	0.23	9.525

Full profile
Whitworth

Grade: TG3225

				 				(mm)
Type	Order No.	Pitch	Dimension (mm)					
			L	X	f	r	d	
External	16ER19W-TC	19	16	0.8	1	0.17	9.525	
	16ER14W-TC	14	16	1.2	1.5	0.24	9.525	
	16ER11W-TC	11	16	1.2	1.5	0.3	9.525	
Internal	16IR19W-TC	19	16	0.8	1	0.17	9.525	
	16IR14W-TC	14	16	1.2	1.5	0.24	9.525	
	16IR11W-TC	11	16	1.2	1.5	0.3	9.525	

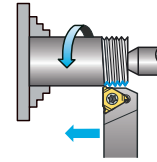
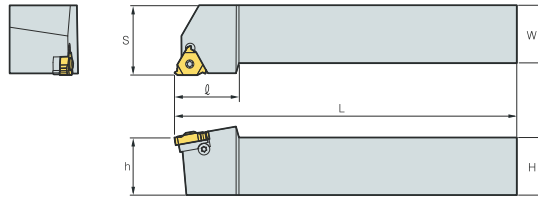
Standard Cutting Conditions

ISO	Workpiece Material		Vc(m/min)
P	Non-Alloy steel	<0.25%C	120-230
		0.25%C- 0.55%C	100-195
		≥0.55%C	90-180
	Low Alloy Steel		60-180
	High Alloy Steel		70-140
M	Martensitic Stainless Steel		70-170
	Austenitic Stainless Steel		90-140
K	Grey Cast Iron		80-160
	Ductile Cast Iron		80-160
N	Cast Aluminum Alloy		100-500
	Aluminum Alloy		300-700
	Copper Alloy		80-300
S	Heat-resistance Alloy		10-50
	Titanium Alloy		50-70
H	Hardened Alloy	45-50 HRC	40-50
		51-55 HRC	30-50

Insert
External Toolholder
Internal Toolholder
Threading
Parting, Grooving
Miniature Tool

External Threading Toolholders

SER
(Screw on system)

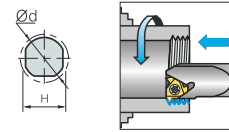
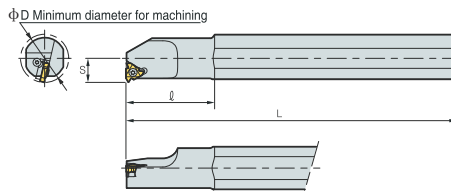


Righthand drawing
(mm)

Order No.	Dimension (mm)					Insert	Pin	Shim	Wrench	Screw
	H	W	S	L	h					
SER-1212H16	12	12	16	100	12	16ER..	ST3509	-	T15	-
SER-1616H16	16	16	20	100	16		ST3512	STM16	T15 L2.5	ST3006N
SER-2020K16	20	20	25	125	20					
SER-2525M16	25	25	32	150	25					
SER-3232P16	32	32	40	170	32					
SER-2525M22	25	25	32	150	25	22ER..	ST4016	STM22	T20 L3	ST4006N
SER-3232P22	32	32	40	170	32					

Internal Threading Bars

SNR
(Screw on system)



Righthand drawing

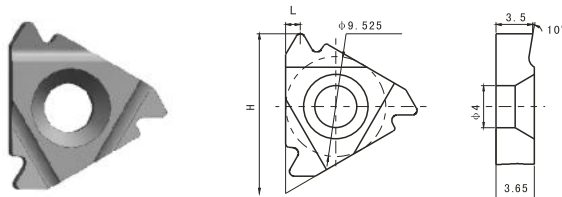
(mm)

Order No.	Dimension (mm)						Insert	Pin	Shim	Wrench	Screw
	D	d	L	S	H	I					
SNR-0008K11	11	8	125	5.5	7	20	11IR..	ST2508	-	T8	-
SNR-0010K11	13	10	125	6.5	9	22					
SNR-0012K11	15	12	125	7.5	11	26					
SNR-0016Q16	19	16	180	10	15	36	16IR..	ST3509	-	T15	-
SNR-0020R16	24	20	200	12	18	40					
SNR-0025R16	29	25	200	14.5	23	45					
SNR-0032T16	36	32	300	18.5	30	45					
SNR-0040T16	44	40	300	22	37	60					
SNR-0020R22	23	20	200	11.5	18	40	22IR..	ST4016	STM22	T20 L3	ST4006N
SNR-0025S22	31	25	250	16	23	45					
SNR-0032T22	38	32	300	19.5	30	45					
SNR-0040T22	46	40	300	24	37	60					

API tubing and casing round threading > Standard triangle series round threading inserts

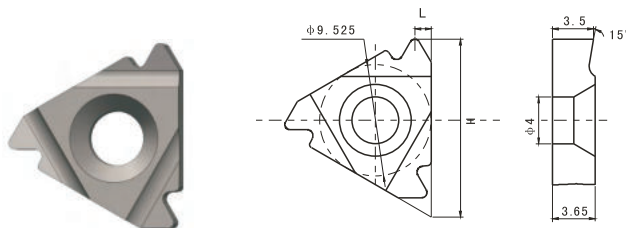
Grade	Introduce of use performance and application
0124	With good red-hardness and toughness, suitable for the high-effective threading machine tooling the dry steel, intermediate grade and high-grade steel (such as J55, K55, N80, L80 etc.) tubing, casing treading and connecting threading.
0326	With good high-intensity and red-hardness, meanwhile own excellent impact resistance. Suitable for the high-effective threading machine tooling the intermediate and high grade steel (such as N80, P110. etc.) tubing, casing and connecting threading.

External threading insert



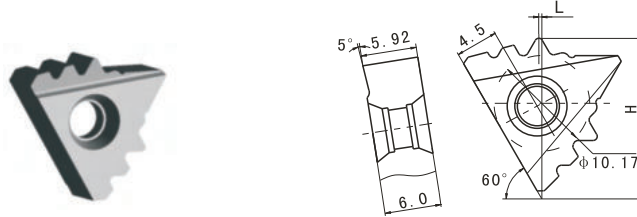
Ordering code	Teeth/inch	Taper	Thread form	H	L	Grade
16ER8API	8	1:16	API round tubing casing thread	15.2	1.4	0124/0326
16ER10API	10	1:16	API round tubing casing thread	15.2	1.2	0124/0326

Internal threading insert



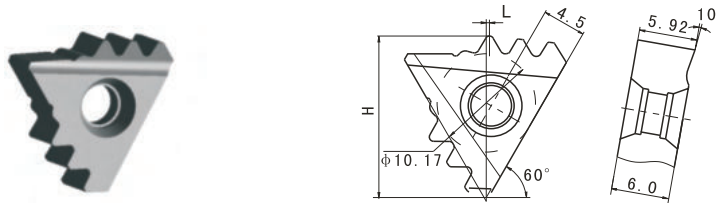
Ordering code	Teeth/inch	Taper	Thread form	H	L	Grade
16IR8API	8	1:16	API round tubing casing thread	15.2	1.4	0124/0326
16IR10API	10	1:16	API round tubing casing thread	15.2	1.2	0124/0326

API tubing and casing round threading > Papilionaceous series round threading inserts
External threading insert

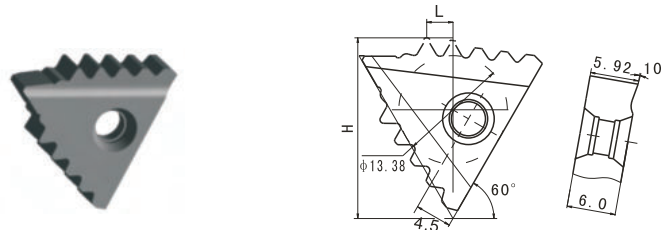


Ordering code	Teeth/inch	Taper	Thread form	H	L	Grade
B8W2-3(15°)	8	1:16	API round tubing thread	17.09	0.32	0124/0326
B8W2-3(12°)	8	1:16	API round casing thread	17.09	0.32	0124/0326
B10W2-4	10	1:16	API round tubing thread	17.09	0.32	0124/0326

Internal threading insert

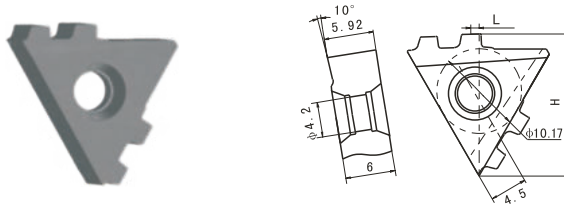


Ordering code	Teeth/inch	Taper	Thread form	H	L	Grade
B8N2-3	8	1:16	API round tubing casing thread	17.09	0.32	0124/0326
B10N2-4	10	1:16	API round tubing thread	17.09	0.01	0124/0326



Ordering code	Teeth/inch	Taper	Thread form	H	L	Grade
B8N2-5	8	1:16	API round tubing casing thread	21.84	3.24	0124/0326

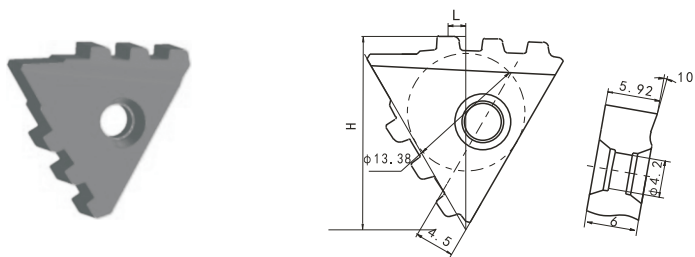
GOST buttress threading inserts for oil pipe
External threading insert



Ordering code	Teeth/inch	Taper	Thread form	H	L	Grade
E5BW2-2	5	1:16	OTTM \ OTTG	17.03	0.83	0124/0326

GOST buttress threading inserts for oil pipe

Internal threading insert



Ordering code	Teeth/inch	Taper	Thread form	H	L	Grade
E5BN2-3	5	1:16	OTTM \ OTTG	22.075	2.0	0124/0326

Insert

External Toolholder

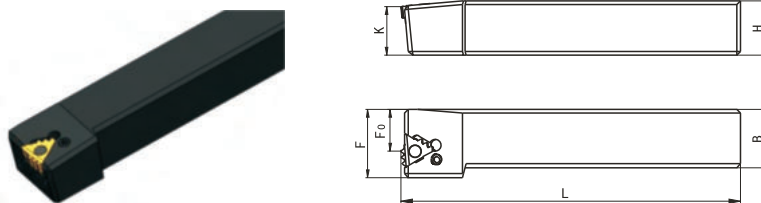
Internal Toolholder

Threading

Parting, Grooving

Miniature Tool

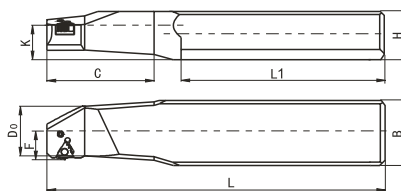
Tool shank for papilionaceous round external threading inserts



Type	Ordering code	Working range	Dimension							Machine tool
			L	H	K	B	F	F ₀	λ	
A	P10 (8) W2-A28×25	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	175	28	25	30	35	22	70'	C620
	P10 (8) W2-A35×32		175	35	32	35	40	27	70'	
	P10 (8) W2-A40×40		175	40	40	40	45	30	70'	
B	P10 (8) W2-B35×32	4"~5 $\frac{1}{2}$ "	175	35	32	35	40	27	50'	QK1312
	P10 (8) W2-B40×40		175	40	40	40	45	30	50'	
C	P10 (8) W2-C35×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	175	35	32	35	40	27	30'	S1-344
	P10 (8) W2-C40×40		175	40	40	40	45	30	30'	
D	P10 (8) W2-D35×32	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	175	35	32	35	40	27	15'	S1-189
	P10 (8) W2-D40×40		175	40	40	40	45	30	15'	

Accessory	Insert	Shim	Oblique rod	Lock screw	Wrench
Image					
Ordering code	B8W2-3H B10W2-4H	169. 798	φ4 Oblique rod	M6	S3

Square tool shank for papilionaceous round internal threading inserts

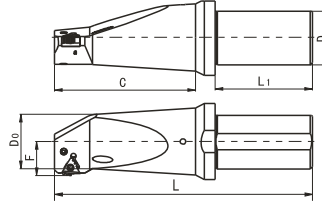


Type	Ordering code	Working range	Dimension									Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ	
A	P10 (8) N2-AS40×25	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	275	150	40	100	25	26	42	65	70'	C620
	P10 (8) N2-AS48×32		305	180	48	100	32	26	42	74	70'	QK1312 Q1319
	P10 (8) N2-AS48×32(A1)	2 $\frac{3}{8}$ "	265	140	48	85	32	26.5	45	74	70'	-
	P10 (8) N2-AS48×32(A2)	2 $\frac{7}{8}$ "~3 $\frac{1}{2}$ "	275	140	48	95	32	30.5	50	74	70'	-
B	P10 (8) N2-BS48×32	4"~5 $\frac{1}{2}$ "	335	180	48	130	32	31	50	74	50'	QK1312 Q1319
	P10 (8) N2-BS55×36		335	200	55	130	36	31	50	77	50'	S1-262 S1-245 QK1312 Q1319
C	P10 (8) N2-CS48×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	358	180	48	158	32	36	56	74	30'	S1-262 S1-245 QK1312 Q1319
	P10 (8) N2-CS55×36		378	200	55	158	36	36	56	77	30'	S1-262 S1-245
D	P10 (8) N2-DS55×36	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	395	200	55	175	36	43	60	81	15'	S1-262 S1-245

Accessory	Insert	Shim	Oblique rod	Lock screw	Wrench
Image					
Ordering code	B8N2-3H B10N2-4H	169. 523	Φ4 Oblique rod	M6	S3

Insert
External Toolholder
Internal Toolholder
Threading
Parting, Grooving
Miniature Tool

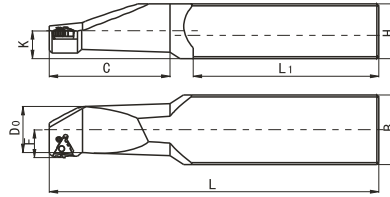
Round tool shank for papilionaceous round internal threading inserts



Type	Ordering code	Working range	Dimension							Machine tool
			L	L ₁	D	C	D ₀	F	λ	
A	P10 (8) N2-AR40×80	2 $\frac{3}{8}$ "~3 $\frac{1}{2}$ "	205	80	40	100	42	26	70'	CK7815 CK7620
	P10 (8) N2-AR50×90		215	90	50	100	42	26	70'	CK7832 CK3263A
	P10 (8) N2-AR60×100		225	100	60	100	42	26	70'	CK7840
	P10 (8) N2-AR80×140		265	140	80	100	42	26	70'	CK3263B
	P10 (8) N2-AR60×140 (A1)	2 $\frac{3}{8}$ "	265	140	60	85	45	26.5	70'	-
	P10 (8) N2-AR60×140 (A2)	2 $\frac{7}{8}$ "~3 $\frac{1}{2}$ "	275	140	60	95	50	30.5	70'	-
B	P10 (8) N2-BR40×80	4"~5 $\frac{1}{2}$ "	235	80	40	130	50	31	50'	CK7815 CK7620
	P10 (8) N2-BR50×90		245	90	50	130	50	31	50'	CK7832 CK3263A
	P10 (8) N2-BR60×100		255	100	60	130	50	31	50'	CK7840
	P10 (8) N2-BR80×140		295	140	80	130	50	31	50'	CK3263B
C	P10 (8) N2-CR50×90	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	268	90	50	158	56	36	30'	CK7840
	P10 (8) N2-CR60×100		278	100	60	158	56	36	30'	CK3263B
	P10 (8) N2-CR80×140		318	140	80	158	56	36	30'	CK7832 CK3263A
D	P10 (8) N2-DR60×100	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	295	100	60	175	60	43	15'	CK7840
	P10 (8) N2-DR80×140		335	140	80	175	60	43	15'	CK3263B

Accessory	Insert	Shim	Oblique rod	Lock screw	Wrench
Image					
Ordering code	B8N2-3H B10N2-4H	169. 523	Φ4 Oblique rod	M6	S3

Square tool shank for papilionaceous buttress internal threading inserts

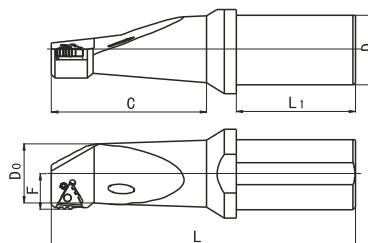


Type	Ordering code	Working range	Dimension										Machine tool
			L	L ₁	H	C	K	F	D ₀	B	λ		
B	P5BN2-BS48×32	4"~5 ¹ / ₂ "	335	180	48	130	32	31	50	74	60'	S1-127 S1-344	
	P5BN2-BS55×36		355	200	55	130	36	31	50	77	60'		
C	P5BN2-CS48×32	6 ⁵ / ₈ "~8 ⁵ / ₈ "	358	180	48	158	32	36	56	74	40'	S1-127 S1-344	
	P5BN2-CS55×36		378	200	55	158	36	36	56	77	40'		
D	P5BN2-DS55×36	9 ⁵ / ₈ "~13 ³ / ₈ "	395	200	55	175	36	43	60	81	20'	S1-245 S1-262	

Accessory	Insert	Shim	Oblique rod	Lock screw	Wrench
Image					
Ordering code	B5BN2-3	169. 973	Φ4 Oblique rod	M6	S3

Insert
 External Toolholder
 Internal Toolholder
 Threading
 Parting, Grooving
 Miniature Tool

Round tool shank for papilionaceous buttress internal threading inserts

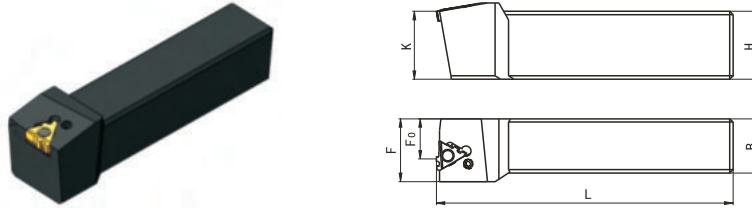


(mm)

Type	Ordering code	Working range	Dimension							Machine tool
			L	L ₁	D	C	D ₀	F	λ	
B	P5BN2-BR50×90	4 1/2" ~ 6 5/8"	245	90	50	130	50	31	60'	CK7820 CK7832
	P5BN2-BR60×100		255	100	60	130	50	31	60'	CK7840 S1-181
	P5BN2-BR80×140		295	140	80	130	50	31	60'	CK3263
C	P5BN2-CR60×100	7" ~ 11 3/4"	283	100	60	158	56	36	40'	CK7820 CK7832
	P5BN2- CR80×140		323	140	80	158	56	36	40'	CK3263
D	P5BN2- DR60×100	13 3/8" ~ 20"	300	100	60	175	60	43	20'	CK7840 S1-181
	P5BN2- Dr80×140		340	140	80	175	60	43	20'	Ck3263

Accessory	Insert	Shim	Oblique rod	Lock screw	Wrench
Image					
Ordering code	B5BN2-3	169. 973	φ 4 Oblique rod	M6	S3

Tool shank for papilionaceous buttress external threading inserts



Type	Ordering code	Working range	Dimension							Machine tool
			L	H	K	B	F	F ₀	λ	
B	P5BW2-B35×32	4"~5 $\frac{1}{2}$ "	175	35	32	35	40	25	60'	QK1312 S1-245 S1-127
C	P5BW2-C35×32	6 $\frac{5}{8}$ "~8 $\frac{5}{8}$ "	175	35	32	35	40	25	40'	
D	P5BW2-D35×32	9 $\frac{5}{8}$ "~13 $\frac{3}{8}$ "	175	35	32	35	40	25	20'	

Accessory	Insert	Shim	Oblique rod	Lock screw	Wrench
Image					
Ordering code	B5BW2-2	169.798	φ4 Oblique rod	M6	S3

Insert

External Toolholder

Internal Toolholder

Threading

Parting, Grooving

Miniature Tool