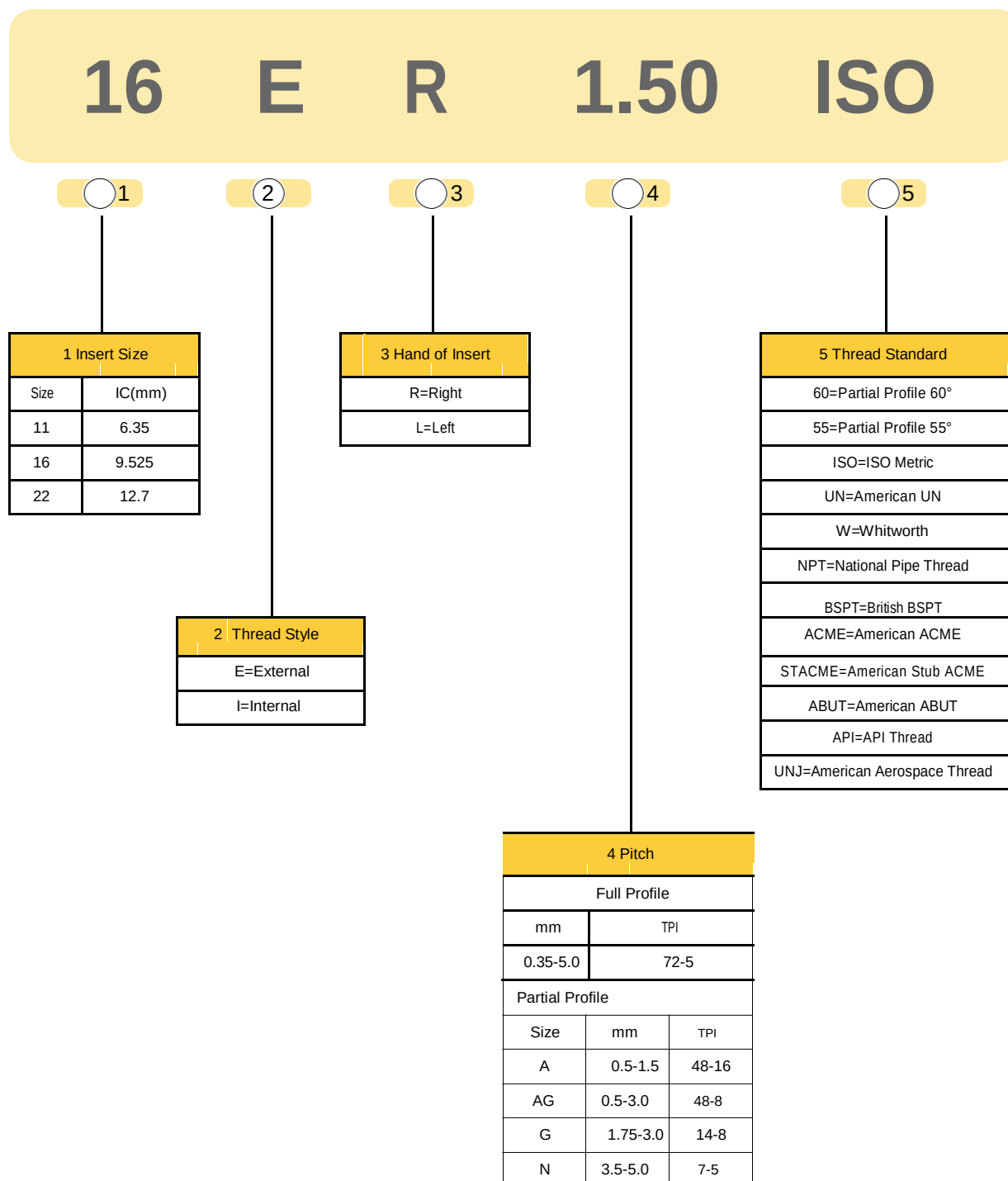
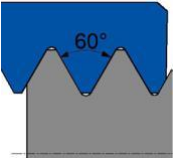
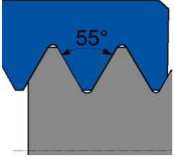
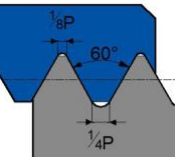
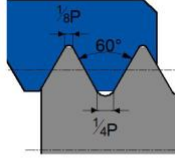
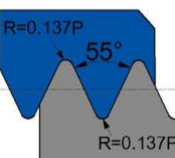
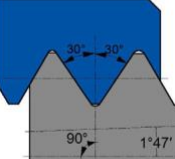
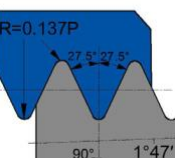
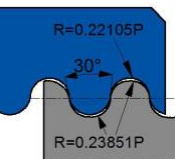


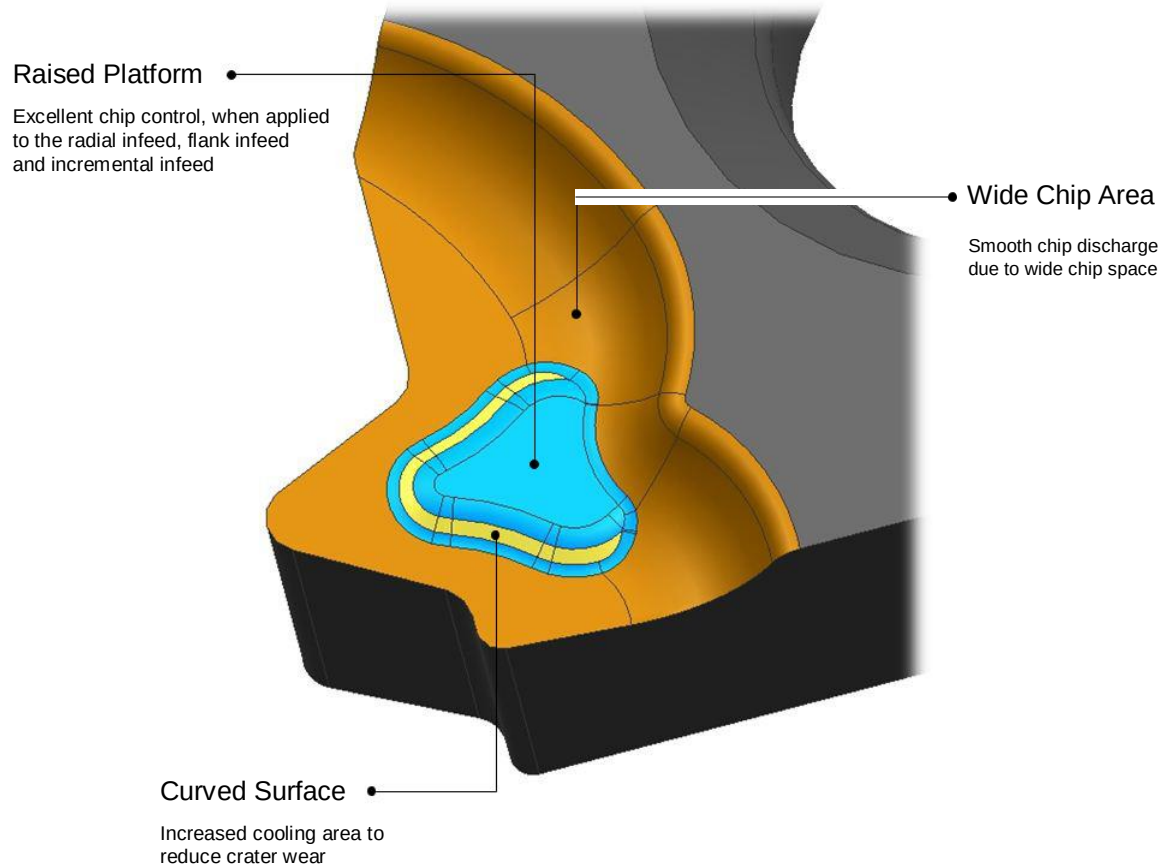
Threading Inserts Identification System



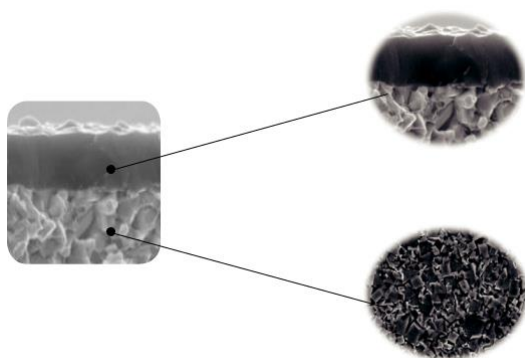
Overview of Threading Tools

Application	Thread Type	Thread Sketch	Thread Code	Pitch	Page
For general industry	Partial Profile 60°		60	0.5-5.0 (mm)	5
	Partial Profile 55°		55	48-5 (TPI)	6
	ISO Metric		ISO	1.0-5.0 (mm)	7
	UN		UN	24-8 (TPI)	9
Thread for pipe fittings and couplings for gas, water and sewage	Whitworth		W	19-11 (TPI)	10
	NPT		NPT	27-8 (TPI)	12
Thread for pipe fittings and couplings for gas, steam and water lines	BSPT		BSPT	28-11 (TPI)	11
Thread for pipe couplings in food and firefighting industry	Round (DIN 405)		RD	10-4 (TPI)	13

Advanced Geometry



FT325M-General Grade for Thread Turning



New TiAlN nano-structure coating

New TiAlN nano-structure coating with excellent heat resistance and bonding resistance

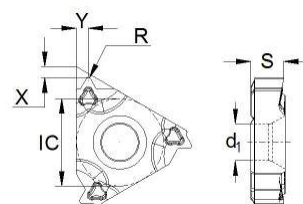
Micro-grain carbide substrate

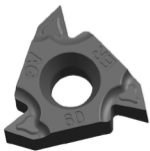
Micro-grain carbide substrate with high wear resistance and good toughness, suitable for thread turning a wide range of materials.



Partial Profile 60°

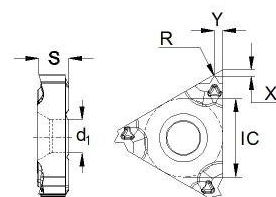
► EXTERIOR

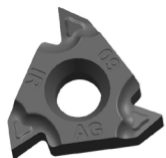


Ordering Code	Pitch (mm)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	16 ERA60	0.5-1.5	0.8	0.9	0.08	9.525	3.47	4	6.53€
	16 ERAG60	0.5-3.0	1.1	1.5	0.08	9.525	3.47	4	6.53€
	16 ERG60	1.75-3.0	1.2	1.7	0.25	9.525	3.47	4	6.53€
	22 ERN60	3.5-5.0	1.7	2.5	0.51	12.7	4.71	5	9.46€

Partial Profile 60°

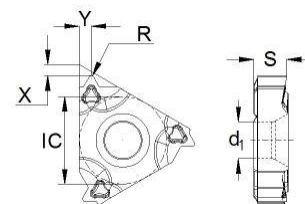
► INTERIOR



Ordering Code	Pitch (mm)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	11 IRA60	0.5-1.5	0.8	0.9	0.08	6.35	3	3.2	6.21€
	16 IRA60	0.5-1.5	0.8	0.9	0.08	9.525	3.47	4	6.53€
	16 IRAG60	0.5-3.0	1.1	1.5	0.08	9.525	3.47	4	6.53€
	16 IRG60	1.75-3.0	1.2	1.7	0.13	9.525	3.47	4	6.53€
	22 IRN60	3.5-5.0	1.7	2.5	0.25	12.7	4.71	5	9.46€

Partial Profile 55°

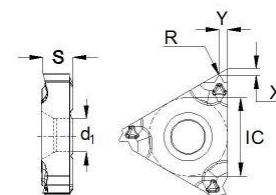
► EXTERIOR

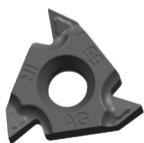


Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	16 ERA55	48-16	0.8	0.9	0.08	9.525	3.47	4	6.53€
	16 ERAG55	48-8	1.1	1.5	0.08	9.525	3.47	4	6.53€
	16 ERG55	14-8	1.2	1.7	0.21	9.525	3.47	4	6.53€
	22 ERN55	7-5	1.7	2.5	0.44	12.7	4.71	5	9.46€

Partial Profile 55°

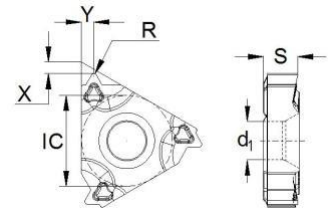
► INTERIOR



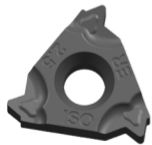
Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	11 IRA55	48-16	0.8	0.9	0.08	6.35	3	3.2	6.21€
	16 IRA55	48-16	0.8	0.9	0.08	9.525	3.47	4	6.53€
	16 IRAG55	48-8	1.1	1.5	0.08	9.525	3.47	4	6.35€
	16 IRG55	14-8	1.2	1.7	0.21	9.525	3.47	4	6.35€
	22 IRN55	7-5	1.7	2.5	0.44	12.7	4.71	5	9.46€

Metric 60°

► EXTERIOR



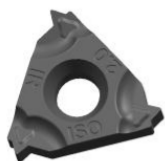
Ordering Code	Pitch (mm)	Dimensions (mm)							Preço
		X	Y	R	IC	S	d1	FT325M	
16 ER1.00ISO	1.00	0.8	0.7	0.14	9.525	3.47	4		6.35€
16 ER1.25ISO	1.25	0.8	0.9	0.18	9.525	3.47	4		6.35€
16 ER1.50ISO	1.50	0.8	1.0	0.22	9.525	3.47	4		6.35€
16 ER1.75ISO	1.75	1.2	1.2	0.25	9.525	3.47	4		6.35€
16 ER2.00ISO	2.00	1.2	1.3	0.29	9.525	3.47	4		6.35€
16 ER2.50ISO	2.50	1.2	1.5	0.36	9.525	3.47	4		6.35€
16 ER3.00ISO	3.00	1.2	1.5	0.43	9.525	3.47	4		6.35€
22 ER3.50ISO	3.50	1.6	2.3	0.45	12.7	4.71	5		9.46€
22 ER4.00ISO	4.00	1.6	2.3	0.52	12.7	4.71	5		9.64€
22 ER4.50ISO	4.50	1.7	2.4	0.58	12.7	4.71	5		9.64€
22 ER5.00ISO	5.00	1.7	2.5	0.63	12.7	4.71	5		9.64€



Metric 60°

► INTERIOR

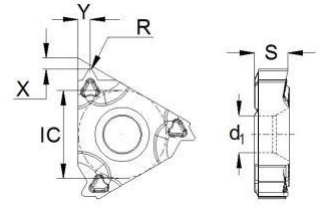
Ordering Code	Pitch (mm)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
11 IR1.00ISO	1.00	0.8	0.7	0.07	6.35	3	3.2	6.21€	
11 IR1.25ISO	1.25	0.8	0.9	0.09	6.35	3	3.2	6.21€	
11 IR1.50ISO	1.50	0.8	1.0	0.11	6.35	3	3.2	6.21€	
11 IR1.75ISO	1.75	0.9	1.1	0.13	6.35	3	3.2	6.21€	
11 IR2.00ISO	2.00	0.9	1.1	0.15	6.35	3	3.2	6.21€	
16 IR1.00ISO	1.00	0.8	0.7	0.07	9.525	3.47	4	6.53€	
16 IR1.25ISO	1.25	0.8	0.9	0.09	9.525	3.47	4	6.53€	
16 IR1.50ISO	1.50	0.8	1.0	0.11	9.525	3.47	4	6.35€	
16 IR1.75ISO	1.75	1.2	1.2	0.13	9.525	3.47	4	6.35€	
16 IR2.00ISO	2.00	1.2	1.3	0.15	9.525	3.47	4	6.35€	
16 IR2.50ISO	2.50	1.2	1.5	0.18	9.525	3.47	4	6.35€	
16 IR3.00ISO	3.00	1.2	1.5	0.22	9.525	3.47	4	6.35€	
22 IR3.50ISO	3.50	1.6	2.3	0.22	12.7	4.71	5	9.46€	
22 IR4.00ISO	4.00	1.6	2.3	0.25	12.7	4.71	5	9.46€	
22 IR4.50ISO	4.50	1.6	2.4	0.28	12.7	4.71	5	9.46€	
22 IR5.00ISO	5.00	1.6	2.3	0.32	12.7	4.71	5	9.46€	



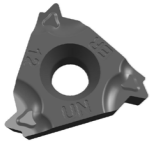


UN 60°

► EXTERIOR



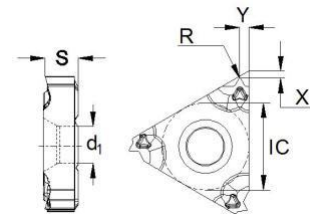
Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
16 ER24UN	24	0.8	0.8	0.15	9.525	3.47	4	6.35€	
16 ER20UN	20	0.8	0.9	0.18	9.525	3.47	4	6.35€	
16 ER18UN	18	0.8	1.0	0.20	9.525	3.47	4	6.35€	
16 ER16UN	16	0.9	1.1	0.23	9.525	3.47	4	6.35€	
16 ER14UN	14	1.2	1.5	0.26	9.525	3.47	4	6.35€	
16 ER12UN	12	1.2	1.5	0.31	9.525	3.47	4	6.35€	
16 ER10UN	10	1.2	1.5	0.37	9.525	3.47	4	6.35€	
16 ER8UN	8	1.3	1.7	0.46	9.525	3.47	4	6.35€	



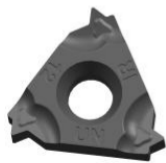
● Stock ○ Available on request

UN 60°

► INTERIOR



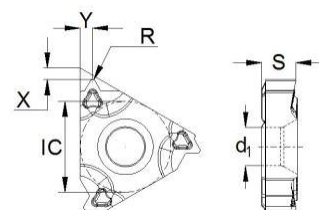
Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
11 IR20UN	20	0.8	0.9	0.09	6.35	3	3.2	6.21€	
11 IR18UN	18	0.8	1.0	0.10	6.35	3	3.2	6.21€	
16 IR24UN	24	0.8	0.8	0.08	9.525	3.47	4	6.53€	
16 IR20UN	20	0.8	0.9	0.09	9.525	3.47	4	6.35€	
16 IR18UN	18	0.8	1.0	0.10	9.525	3.47	4	6.35€	
16 IR16UN	16	0.9	1.1	0.12	9.525	3.47	4	6.35€	
16 IR14UN	14	1.2	1.5	0.13	9.525	3.47	4	6.35€	
16 IR12UN	12	1.2	1.5	0.16	9.525	3.47	4	6.35€	
16 IR10UN	10	1.2	1.5	0.19	9.525	3.47	4	6.35€	
16 IR8UN	8	1.3	1.7	0.23	9.525	3.47	4	6.35€	

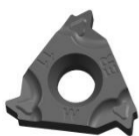




Whitworth 55°

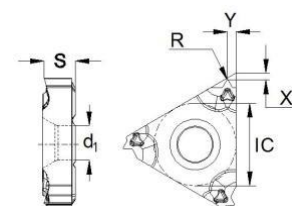
► EXTERIOR

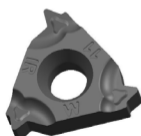


Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	16 ER19W	19	0.8	1.0	0.17	9.525	3.47	4	6.35€
	16 ER14W	14	1.2	1.5	0.24	9.525	3.47	4	6.35€
	16 ER11W	11	1.2	1.5	0.30	9.525	3.47	4	6.35€

Whitworth 55°

► INTERIOR

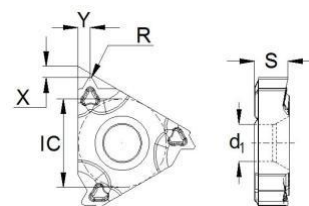


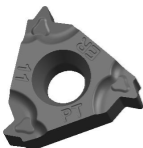
Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	16 IR19W	19	0.8	1.0	0.17	9.525	3.47	4	6.35€
	16 IR14W	14	1.2	1.5	0.24	9.525	3.47	4	6.35€
	16 IR11W	11	1.2	1.5	0.30	9.525	3.47	4	6.35€



BSPT 55°

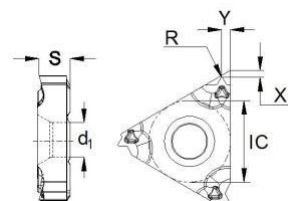
► EXTERIOR

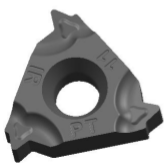


Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	16 ER28BSPT	28	0.7	0.8	0.11	9.525	3.47	4	6.35€
	16 ER19BSPT	19	0.8	1.0	0.17	9.525	3.47	4	6.35€
	16 ER14BSPT	14	1.2	1.5	0.24	9.525	3.47	4	6.35€
	16 ER11BSPT	11	1.2	1.5	0.30	9.525	3.47	4	6.35€

BSPT 55°

► INTERIOR



Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	11 IR19BSPT	19	0.8	1.0	0.18	6.35	3	3.2	6.21€
	11 IR14BSPT	14	0.9	1.1	0.24	6.35	3	3.2	6.21€
	16 IR28BSPT	28	0.7	0.8	0.11	9.525	3.47	4	6.53€
	16 IR19BSPT	19	0.8	1.0	0.17	9.525	3.47	4	6.35€
	16 IR14BSPT	14	1.2	1.5	0.24	9.525	3.47	4	6.35€
	16 IR11BSPT	11	1.2	1.5	0.30	9.525	3.47	4	6.35€

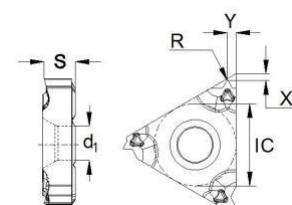
NPT 60°

► EXTERIOR

Ordering Code		Pitch (TPI)	Dimensions (mm)						Preço
			X	Y	R	IC	S	d1	FT325M
	16 ER27NPT	27	0.7	0.8	0.13	9.525	3.47	4	6.53€
	16 ER18NPT	18	0.8	1.0	0.20	9.525	3.47	4	6.53€
	16 ER14NPT	14	1.2	1.5	0.22	9.525	3.47	4	6.53€
	16 ER11.5NPT	11.5	1.2	1.5	0.25	9.525	3.47	4	6.53€
	16 ER8NPT	8	1.3	1.8	0.30	9.525	3.47	4	6.53€

NPT 60°

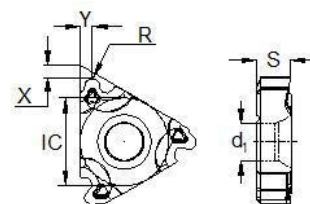
► INTERIOR



Ordering Code		Pitch (TPI)	Dimensions (mm)						Preço
			X	Y	R	IC	S	d1	FT325M
	11 IR18NPT	18	0.8	1.0	0.20	6.35	3	3.2	6.21€
	16 IR27NPT	27	0.7	0.8	0.13	9.525	3.47	4	6.53€
	16 IR18NPT	18	0.8	1.0	0.20	9.525	3.47	4	6.53€
	16 IR14NPT	14	1.2	1.5	0.22	9.525	3.47	4	6.53€
	16 IR11.5NPT	11.5	1.2	1.5	0.25	9.525	3.47	4	6.53€
	16 IR8NPT	8	1.3	1.8	0.30	9.525	3.47	4	6.53€

Round 30°

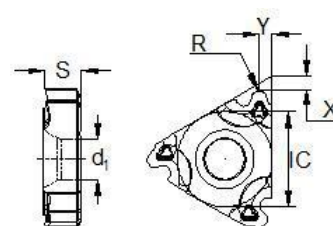
► EXTERIOR

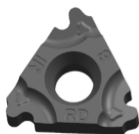


Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	16 ER10RD	10	1.1	1.2	0.60	9.525	3.47	4	○
	16 ER8RD	8	1.4	1.3	0.75	9.525	3.47	4	7.52€
	16 ER6RD	6	1.4	1.5	1.00	9.525	3.47	4	7.52€
	22 ER4RD	4	2.2	2.3	1.51	12.7	4.71	5	○

Round 30°

► INTERIOR



Ordering Code	Pitch (TPI)	Dimensions (mm)						Preço	
		X	Y	R	IC	S	d1	FT325M	
	16 IR10RD	10	1.1	1.2	0.55	9.525	3.47	4	○
	16 IR8RD	8	1.4	1.3	0.70	9.525	3.47	4	7.52€
	16 IR6RD	6	1.4	1.5	0.936	9.525	3.47	4	7.52€
	22 IR4RD	4	2.2	2.3	1.40	12.7	4.71	5	○



Cutting Speed Recommendation Table

Workpiece Material		Material Hardness	Cutting Speed Vc(m/min) Grade FT325M
Carbon Steel	Low-carbon (C=0.1-0.25%)	HB125	160 (120-230)
	Medium-carbon (C=0.25-0.55%)	HB150	150 (100-195)
	High-carbon (C=0.55-0.80%)	HB170	140 (90-180)
Low-alloy Steel	Non-hardened	HB180	130 (100-180)
	Hardened and tempered	HB275	100(75-140)
	Hardened and tempered	HB350	80 (60-130)
High-alloy Steel	Annealed	HB200	110 (80-140)
	Hardened and tempered	HB325	90 (70-115)
	Unalloyed	HB180	200 (180-220)
Cast Steel	Low-alloy	HB200	110 (70-150)
	High-alloy	HB225	100 (60-120)
	Manganese steel (12-14% Mn)	HB250	40 (40-50)
Stainless Steel	Austenitic	HB180	120 (90-140)
	Ferrite/Martensite	HB200	140 (70-170)
	Duplex stainless steel	HB230	90 (60-120)
Malleable Cast Iron	Ferrite	HB130	130 (110-170)
	Pearlite	HB230	100 (85-145)
Gray Cast Iron	Low tensile strength	HB180	120 (100-160)
	High tensile strength	HB260	100 (80-140)
Nodular Cast Iron	Ferrite	HB160	125 (110-160)
	Pearlite	HB250	100 (80-120)
Wrought Aluminum Alloys	Non aging	HB60	500 (350-700)
	Aged	HB100	400 (300-500)
Cast Aluminum Alloys	Non aging	HB75	450 (300-500)
	Aged	HB90	290 (200-400)
Copper and Copper Alloys	Containing silicon (13-22% Si)	HB130	200 (100-300)
	Brass	HB90	220 (100-300)
	Bronze and non-lead copper	HB100	180 (80-255)
Heat-resistant Alloys	Iron base	Annealed	45 (35-60)
		Aged	35 (25-50)
	Nickel base and cobalt base	Annealed	25 (15-30)
		Aged	15 (10-25)
		Cast	13 (10-20)
Titanium Alloys	Commercial pure (99.5% Ti)	400Rm	150 (140-170)
	(+) alloys	1050Rm	60 (50-70)
High Hardness Materials	Hardened steel	HRC55	45 (40-50)
	Chilled cast iron	HB400	40 (30-50)

S					
H					

Cutting Passes and Radial Infeed Recommendation Table

► ISO Metric / External

Pitch (mm)	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00
Total infeed(mm)	0.65	0.79	0.95	1.11	1.26	1.56	1.88	2.18	2.49	2.79	3.10
Total passes	5	6	6	8	8	10	12	12	13	14	14
No. of infeed	Radial infeed per pass (mm)										
1	0.16	0.17	0.20	0.17	0.20	0.20	0.20	0.24	0.24	0.27	0.29
2	0.15	0.15	0.19	0.17	0.19	0.19	0.19	0.23	0.22	0.25	0.28
3	0.14	0.14	0.18	0.16	0.18	0.18	0.19	0.22	0.22	0.24	0.27
4	0.12	0.13	0.16	0.15	0.17	0.17	0.18	0.21	0.21	0.23	0.26
5	0.08	0.12	0.14	0.14	0.16	0.17	0.17	0.21	0.21	0.23	0.25
6	-	0.08	0.08	0.13	0.15	0.16	0.17	0.20	0.20	0.22	0.25
7	-	-	-	0.11	0.13	0.15	0.16	0.18	0.19	0.21	0.24
8	-	-	-	0.08	0.08	0.14	0.15	0.17	0.18	0.20	0.23
9	-	-	-	-	-	0.12	0.14	0.16	0.17	0.19	0.22
10	-	-	-	-	-	0.08	0.13	0.15	0.16	0.18	0.20
11	-	-	-	-	-	-	0.12	0.13	0.15	0.17	0.19
12	-	-	-	-	-	-	0.08	0.08	0.14	0.16	0.17
13	-	-	-	-	-	-	-	-	0.12	0.14	0.15
14	-	-	-	-	-	-	-	-	0.18	0.10	0.10

► ISO Metric / External

Pitch (mm)	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00
Total infeed(mm)	0.63	0.77	0.92	1.05	1.20	1.48	1.78	2.03	2.31	2.61	2.88
Total passes	5	6	6	8	8	10	12	12	13	14	14
No. of infeed	Radial infeed per pass (mm)										
1	0.15	0.16	0.20	0.16	0.19	0.19	0.19	0.22	0.21	0.23	0.26
2	0.14	0.15	0.18	0.15	0.18	0.18	0.18	0.21	0.21	0.23	0.26
3	0.13	0.14	0.17	0.15	0.17	0.17	0.18	0.20	0.20	0.22	0.25
4	0.12	0.13	0.15	0.14	0.16	0.17	0.17	0.20	0.19	0.22	0.24
5	0.08	0.11	0.13	0.13	0.15	0.16	0.16	0.19	0.19	0.21	0.24
6	-	0.08	0.08	0.12	0.14	0.15	0.16	0.18	0.18	0.20	0.23
7	-	-	-	0.11	0.12	0.14	0.15	0.17	0.18	0.20	0.22
8	-	-	-	0.08	0.08	0.13	0.14	0.16	0.17	0.19	0.21
9	-	-	-	-	-	0.12	0.14	0.15	0.16	0.18	0.20
10	-	-	-	-	-	0.08	0.12	0.14	0.15	0.17	0.19
11	-	-	-	-	-	-	0.11	0.12	0.14	0.16	0.18
12	-	-	-	-	-	-	0.08	0.08	0.13	0.15	0.16
13	-	-	-	-	-	-	-	-	0.12	0.14	0.15
14	-	-	-	-	-	-	-	-	0.08	0.10	0.10



► 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	14	11
Total infeed(mm)	0.90	1.20	1.51
Total passes	6	8	9
No. of infeed	Radial infeed per pass (mm)		
1	0.19	0.19	0.22
2	0.18	0.18	0.21
3	0.17	0.17	0.20
4	0.15	0.16	0.19
5	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

► 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



► 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

► Round / External

Pitch (TPI)	10	8	6	4
Total infeed(mm)	1.30	1.63	2.17	2.95
Total passes	8	10	12	14
No. of infeed	Radial infeed per pass (mm)			
1	0.21	0.21	0.24	0.30
2	0.20	0.20	0.23	0.29
3	0.19	0.19	0.22	0.28
4	0.18	0.19	0.21	0.27
5	0.16	0.18	0.20	0.26
6	0.15	0.17	0.19	0.25
7	0.13	0.15	0.18	0.24
8	0.08	0.14	0.17	0.23
9	-	0.12	0.16	0.22
10	-	0.08	0.15	0.21
11	-	-	0.13	0.19
12	-	-	0.08	0.18
13	-	-	-	0.15
14	-	-	-	0.10



► Round / Internal

Pitch (TPI)	10	8	6	4
Total infeed(mm)	1.34	1.64	2.18	2.98
Total passes	8	10	12	14
No. of infeed	Radial infeed per pass (mm)			
1	0.22	0.21	0.24	0.30
2	0.21	0.20	0.23	0.29
3	0.20	0.20	0.22	0.29
4	0.18	0.19	0.21	0.28
5	0.17	0.18	0.21	0.27
6	0.15	0.17	0.20	0.26
7	0.13	0.16	0.19	0.25
8	0.08	0.14	0.17	0.24
9	-	0.12	0.16	0.23
10	-	0.08	0.15	0.21
11	-	-	0.13	0.20
12	-	-	0.08	0.18
13	-	-	-	0.16
14	-	-	-	0.10

Attention: Generally, the radial feed shall not be less than 0.05mm. When machining austenitic stainless steel, the radial feed shall not be less than 0.08mm.

