## THREADING Indexable inserts

## nixkotools

|   | <b>CARBIDE</b><br>Internal threading  |   |  
   
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| GRADE APPLICATION AREA Stable machining, continuous cut + - |   |   |  
   
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   |   |   | ING  |
| E main application General machining, light interrup        |   |   |  
   
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   |   |   | THREADING  |
| applicable  | Unstable machining, interrupted cut – +   |   |  
   
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| BSPT P M K S<br>BSPT CANDARD DIPE TAPERED 55°               | 16IR  | 28BSPT-TPN  | <b>1</b> RE 0.11   
   
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|   | 19BSPT-TPM  |   | RE 0.17  
   
   | . pitc  
   
   | h: 19 TPI  |  
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|   |   | 14BSPT-TPN  | N RE 0.24  
   
   | pitch: 14 TPI   
   
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| BRITISH STANDARD PIPE TAPERED 55°                           |   | 11BSPT-TPN  | N RE 0.30  
   
   | pitc  
   
   | h: 11 TPI  |  
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|   |   | A60-TPM BE 0.0  |  
   
   | pitch: 0.50÷1.50  
   
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   |   | _   | GROOVING   |
|   | 16IR  | A60-TPM   | RE 0.08  
   
   | 48÷16 TPI   
   
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|   |   | <b>G60-TPM</b> RE 0.  |  
   
   | 14  
   
   | 1÷8 TPI  |  
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| METRIC AND UNIFIED THREADS                                  |   | AG60-TPM  | RE 0.08  
   
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| THE ADD UNIFIED THREADS                                     | 11IR  | R A55-TPM RE 0.08   |  
   
   | pitch:  
   
   | 48÷16 TPI  |  
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|   | 16IR  | A55-TPM   | RE 0.08  
   
   | RE 0.08 pitch: 48÷  
   
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| SP  | TOIN  | G55-TPM   | RE 0.21  
   
   | pitch:  
   
   | : 14÷8 TPI   |  
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|   | 3 edges   3 edges   GRADE APPLICATION AREA   Imain application   applicable   BSPT P M KS   BRITISH STANDARD PIPE TAPERED 55°   60° P M KS   GO° P M KS | Size         1        < | Size       IC         Image: Size       IC         Image: Size       IC         3 edges       IC         GRADE APPLICATION AREA       Stable methining, co         Image: Size       Image: Size         Image: Size       Image: Size <t< td=""><td>Size       IC       S         I       6.35       3.18         I       6.35       3.18         I       9.525       3.65         I       9.525       3.65         I       9.525       3.65         I       9.525       3.65         I       I       I       I         I       I       I       I         I       I       I       I       I         I       I       I       I       I         I       I       I       I       I         I       I       I       I       I       I         I       I       I       I       I       I       I         I       I       I       I       I       I       I       I         I<!--</td--><td>Size         IC         S         D1           I         6.35         3.18         3.20         I           I         6.35         3.18         3.20         I         I           I         6.35         3.18         3.20         I         I         I           I         6.35         3.18         3.20         I</td><td>Size         IC         S         D1         Image: Size         <t< td=""><td>CARBIDE<br/>Internal threadingSizeICSD1PImage: SizeICSD1PPImage: SizeICSD1PPImage: SizeICSJPPImage: SizeICSJPPImage: SizeImage: Size&lt;</td><td>Size         IC         S         D1         P         80<br/>180<br/>180<br/>180<br/>140           i         6.35         3.18         3.20         M         60<br/>140           i         6.35         3.18         3.20         M         60<br/>140           i         9.525         3.65         4.00         K         50<br/>120           i         i         i         i         K         50<br/>120           i         i         i         i         K         50<br/>120           i         i         i         i         i         K         50<br/>120           i         i         i         i         i         K         50<br/>120           i         i         i         i         i         i         K         50<br/>40           i</td><td><math display="block">\begin{tabular}{ c c c c } \hline \begin{tabular}{ c c c c c } \hline \begin{tabular}{ c c c c c c c } \hline \begin{tabular}{ c c c c c c c c c c c c c c c c c c c</math></td><td><math display="block"> \begin{tabular}{ c c c c c } \hline \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ </math></td><td><math display="block"> \begin{tabular}{ c c c c c } \hline First Standard PIPE TAPERE For the form of passes 5+8 for the form of passes 5+12 form of</math></td><td><math display="block"> \begin{array}{ c c c c c } \hline TPM &amp; \hline Size &amp; IC &amp; S &amp; D1 &amp; P &amp; B0 &amp; S &amp; D1 &amp; P &amp; B0 &amp; S &amp; IC </math></td><td>Size       Ic       S       D1       P       880<br/>880<br/>880       C       C       C         Image: Size       Ic       S       D1       P       880<br/>880       Image: Size       Image:</td><td>Size       CCARBIDE<br/>Internal threating.       P       80       I       <thi< th=""> <thi< th="">       I</thi<></thi<></td><td>Size       Ic       S       D1       P       80       0<!--</td--><td>Size       Ic       S       D1       P       80<br/>100       <th< td=""><td>Size       Ic       S       D1       P       800<br/>100       S       D1       P       800<br/>100       S</td><td>Size       Ic       S       D1       P       800<br/>180       S       <t< td=""><td>Size       C       Size       C       Size       P       800       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       P       800       Size       S</td><td>Size       CarBBIDE       Size       P       800       Size       P       800       Size       <th< td=""><td><math display="block"> \begin{array}{ c c c c c c c c c c c c c c c c c c c</math></td><td>Size       Ic       Size       Ic       Size       Ic       P       880<br/>880       P       P       890<br/>880       P       P       890<br/>890       P       P       990<br/>890       P       P       P       990<br/>800       P       P       900<br/>800       P       P       990<br/>800       P       P       900<br/>800       P       P       P       P       P       P       P       P       P       P       P       P</td></th<></td></t<><td>Size       Ic       S       D1       P       800<br/>1800       10       10       10       10</td></td></th<></td></td></t<></td></td></t<> | Size       IC       S         I       6.35       3.18         I       6.35       3.18         I       9.525       3.65         I       9.525       3.65         I       9.525       3.65         I       9.525       3.65         I       I       I       I         I       I       I       I         I       I       I       I       I         I       I       I       I       I         I       I       I       I       I         I       I       I       I       I       I         I       I       I       I       I       I       I         I       I       I       I       I       I       I       I         I </td <td>Size         IC         S         D1           I         6.35         3.18         3.20         I           I         6.35         3.18         3.20         I         I           I         6.35         3.18         3.20         I         I         I           I         6.35         3.18         3.20         I</td> <td>Size         IC         S         D1         Image: Size         <t< td=""><td>CARBIDE<br/>Internal threadingSizeICSD1PImage: SizeICSD1PPImage: SizeICSD1PPImage: SizeICSJPPImage: SizeICSJPPImage: SizeImage: Size&lt;</td><td>Size         IC         S         D1         P         80<br/>180<br/>180<br/>180<br/>140           i         6.35         3.18         3.20         M         60<br/>140           i         6.35         3.18         3.20         M         60<br/>140           i         9.525         3.65         4.00         K         50<br/>120           i         i         i         i         K         50<br/>120           i         i         i         i         K         50<br/>120           i         i         i         i         i         K         50<br/>120           i         i         i         i         i         K         50<br/>120           i         i         i         i         i         i         K         50<br/>40           i</td><td><math display="block">\begin{tabular}{ c c c c } \hline \begin{tabular}{ c c c c c } \hline \begin{tabular}{ c c c c c c c } \hline \begin{tabular}{ c c c c c c c c c c c c c c c c c c c</math></td><td><math display="block"> \begin{tabular}{ c c c c c } \hline \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ </math></td><td><math display="block"> \begin{tabular}{ c c c c c } \hline First Standard PIPE TAPERE For the form of passes 5+8 for the form of passes 5+12 form of</math></td><td><math display="block"> \begin{array}{ c c c c c } \hline TPM &amp; \hline Size &amp; IC &amp; S &amp; D1 &amp; P &amp; B0 &amp; S &amp; D1 &amp; P &amp; B0 &amp; S &amp; IC </math></td><td>Size       Ic       S       D1       P       880<br/>880<br/>880       C       C       C         Image: Size       Ic       S       D1       P       880<br/>880       Image: Size       Image:</td><td>Size       CCARBIDE<br/>Internal threating.       P       80       I       <thi< th=""> <thi< th="">       I</thi<></thi<></td><td>Size       Ic       S       D1       P       80       0<!--</td--><td>Size       Ic       S       D1       P       80<br/>100       <th< td=""><td>Size       Ic       S       D1       P       800<br/>100       S       D1       P       800<br/>100       S</td><td>Size       Ic       S       D1       P       800<br/>180       S       <t< td=""><td>Size       C       Size       C       Size       P       800       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       P       800       Size       S</td><td>Size       CarBBIDE       Size       P       800       Size       P       800       Size       <th< td=""><td><math display="block"> \begin{array}{ c c c c c c c c c c c c c c c c c c c</math></td><td>Size       Ic       Size       Ic       Size       Ic       P       880<br/>880       P       P       890<br/>880       P       P       890<br/>890       P       P       990<br/>890       P       P       P       990<br/>800       P       P       900<br/>800       P       P       990<br/>800       P       P       900<br/>800       P       P       P       P       P       P       P       P       P       P       P       P</td></th<></td></t<><td>Size       Ic       S       D1       P       800<br/>1800       10       10       10       10</td></td></th<></td></td></t<></td> | Size         IC         S         D1           I         6.35         3.18         3.20         I           I         6.35         3.18         3.20         I         I           I         6.35         3.18         3.20         I         I         I           I         6.35         3.18         3.20         I | Size         IC         S         D1         Image: Size         Image: Size <t< td=""><td>CARBIDE<br/>Internal threadingSizeICSD1PImage: SizeICSD1PPImage: SizeICSD1PPImage: SizeICSJPPImage: SizeICSJPPImage: SizeImage: Size&lt;</td><td>Size         IC         S         D1         P         80<br/>180<br/>180<br/>180<br/>140           i         6.35         3.18         3.20         M         60<br/>140           i         6.35         3.18         3.20         M         60<br/>140           i         9.525         3.65         4.00         K         50<br/>120           i         i         i         i         K         50<br/>120           i         i         i         i         K         50<br/>120           i         i         i         i         i         K         50<br/>120           i         i         i         i         i         K         50<br/>120           i         i         i         i         i         i         K         50<br/>40           i</td><td><math display="block">\begin{tabular}{ c c c c } \hline \begin{tabular}{ c c c c c } \hline \begin{tabular}{ c c c c c c c } \hline \begin{tabular}{ c c c c c c c c c c c c c c c c c c c</math></td><td><math display="block"> \begin{tabular}{ c c c c c } \hline \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ \$ </math></td><td><math display="block"> \begin{tabular}{ c c c c c } \hline First Standard PIPE TAPERE For the form of passes 5+8 for the form of passes 5+12 form of</math></td><td><math display="block"> \begin{array}{ c c c c c } \hline TPM &amp; \hline Size &amp; IC &amp; S &amp; D1 &amp; P &amp; B0 &amp; S &amp; D1 &amp; P &amp; B0 &amp; S &amp; IC </math></td><td>Size       Ic       S       D1       P       880<br/>880<br/>880       C       C       C         Image: Size       Ic       S       D1       P       880<br/>880       Image: Size       Image:</td><td>Size       CCARBIDE<br/>Internal threating.       P       80       I       <thi< th=""> <thi< th="">       I</thi<></thi<></td><td>Size       Ic       S       D1       P       80       0<!--</td--><td>Size       Ic       S       D1       P       80<br/>100       <th< td=""><td>Size       Ic       S       D1       P       800<br/>100       S       D1       P       800<br/>100       S</td><td>Size       Ic       S       D1       P       800<br/>180       S       <t< td=""><td>Size       C       Size       C       Size       P       800       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       P       800       Size       S</td><td>Size       CarBBIDE       Size       P       800       Size       P       800       Size       <th< td=""><td><math display="block"> \begin{array}{ c c c c c c c c c c c c c c c c c c c</math></td><td>Size       Ic       Size       Ic       Size       Ic       P       880<br/>880       P       P       890<br/>880       P       P       890<br/>890       P       P       990<br/>890       P       P       P       990<br/>800       P       P       900<br/>800       P       P       990<br/>800       P       P       900<br/>800       P       P       P       P       P       P       P       P       P       P       P       P</td></th<></td></t<><td>Size       Ic       S       D1       P       800<br/>1800       10       10       10       10</td></td></th<></td></td></t<> | CARBIDE<br>Internal threadingSizeICSD1PImage: SizeICSD1PPImage: SizeICSD1PPImage: SizeICSJPPImage: SizeICSJPPImage: SizeImage: Size< | Size         IC         S         D1         P         80<br>180<br>180<br>180<br>140           i         6.35         3.18         3.20         M         60<br>140           i         6.35         3.18         3.20         M         60<br>140           i         9.525         3.65         4.00         K         50<br>120           i         i         i         i         K         50<br>120           i         i         i         i         K         50<br>120           i         i         i         i         i         K         50<br>120           i         i         i         i         i         K         50<br>120           i         i         i         i         i         i         K         50<br>40           i | $\begin{tabular}{ c c c c } \hline \begin{tabular}{ c c c c c } \hline \begin{tabular}{ c c c c c c c } \hline \begin{tabular}{ c c c c c c c c c c c c c c c c c c c$ | $ \begin{tabular}{ c c c c c } \hline $ $ $ $ $ $ $ $ $ $ $ $ $ $ $ $ $ $ $ | $ \begin{tabular}{ c c c c c } \hline First Standard PIPE TAPERE For the form of passes 5+8 for the form of passes 5+12 form of$ | $ \begin{array}{ c c c c c } \hline TPM & \hline Size & IC & S & D1 & P & B0 & S & D1 & P & B0 & S & IC $ | Size       Ic       S       D1       P       880<br>880<br>880       C       C       C         Image: Size       Ic       S       D1       P       880<br>880       Image: Size       Image: | Size       CCARBIDE<br>Internal threating.       P       80       I <thi< th=""> <thi< th="">       I</thi<></thi<> | Size       Ic       S       D1       P       80       0 </td <td>Size       Ic       S       D1       P       80<br/>100       <th< td=""><td>Size       Ic       S       D1       P       800<br/>100       S       D1       P       800<br/>100       S</td><td>Size       Ic       S       D1       P       800<br/>180       S       <t< td=""><td>Size       C       Size       C       Size       P       800       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       P       800       Size       S</td><td>Size       CarBBIDE       Size       P       800       Size       P       800       Size       <th< td=""><td><math display="block"> \begin{array}{ c c c c c c c c c c c c c c c c c c c</math></td><td>Size       Ic       Size       Ic       Size       Ic       P       880<br/>880       P       P       890<br/>880       P       P       890<br/>890       P       P       990<br/>890       P       P       P       990<br/>800       P       P       900<br/>800       P       P       990<br/>800       P       P       900<br/>800       P       P       P       P       P       P       P       P       P       P       P       P</td></th<></td></t<><td>Size       Ic       S       D1       P       800<br/>1800       10       10       10       10</td></td></th<></td> | Size       Ic       S       D1       P       80<br>100       0 <th< td=""><td>Size       Ic       S       D1       P       800<br/>100       S       D1       P       800<br/>100       S</td><td>Size       Ic       S       D1       P       800<br/>180       S       <t< td=""><td>Size       C       Size       C       Size       P       800       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       P       800       Size       S</td><td>Size       CarBBIDE       Size       P       800       Size       P       800       Size       <th< td=""><td><math display="block"> \begin{array}{ c c c c c c c c c c c c c c c c c c c</math></td><td>Size       Ic       Size       Ic       Size       Ic       P       880<br/>880       P       P       890<br/>880       P       P       890<br/>890       P       P       990<br/>890       P       P       P       990<br/>800       P       P       900<br/>800       P       P       990<br/>800       P       P       900<br/>800       P       P       P       P       P       P       P       P       P       P       P       P</td></th<></td></t<><td>Size       Ic       S       D1       P       800<br/>1800       10       10       10       10</td></td></th<> | Size       Ic       S       D1       P       800<br>100       S       D1       P       800<br>100       S | Size       Ic       S       D1       P       800<br>180       S <t< td=""><td>Size       C       Size       C       Size       P       800       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       P       800       Size       S</td><td>Size       CarBBIDE       Size       P       800       Size       P       800       Size       <th< td=""><td><math display="block"> \begin{array}{ c c c c c c c c c c c c c c c c c c c</math></td><td>Size       Ic       Size       Ic       Size       Ic       P       880<br/>880       P       P       890<br/>880       P       P       890<br/>890       P       P       990<br/>890       P       P       P       990<br/>800       P       P       900<br/>800       P       P       990<br/>800       P       P       900<br/>800       P       P       P       P       P       P       P       P       P       P       P       P</td></th<></td></t<> <td>Size       Ic       S       D1       P       800<br/>1800       10       10       10       10</td> | Size       C       Size       C       Size       P       800       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       Size       P       800       Size       Size       Size       Size       Size       P       800       Size       S | Size       CarBBIDE       Size       P       800       Size       P       800       Size       Size <th< td=""><td><math display="block"> \begin{array}{ c c c c c c c c c c c c c c c c c c c</math></td><td>Size       Ic       Size       Ic       Size       Ic       P       880<br/>880       P       P       890<br/>880       P       P       890<br/>890       P       P       990<br/>890       P       P       P       990<br/>800       P       P       900<br/>800       P       P       990<br/>800       P       P       900<br/>800       P       P       P       P       P       P       P       P       P       P       P       P</td></th<> | $ \begin{array}{ c c c c c c c c c c c c c c c c c c c$ | Size       Ic       Size       Ic       Size       Ic       P       880<br>880       P       P       890<br>880       P       P       890<br>890       P       P       990<br>890       P       P       P       990<br>800       P       P       900<br>800       P       P       990<br>800       P       P       900<br>800       P       P       P       P       P       P       P       P       P       P       P       P | Size       Ic       S       D1       P       800<br>1800       10       10       10       10 |

stock standard

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DRILLING

ACCESSORIES