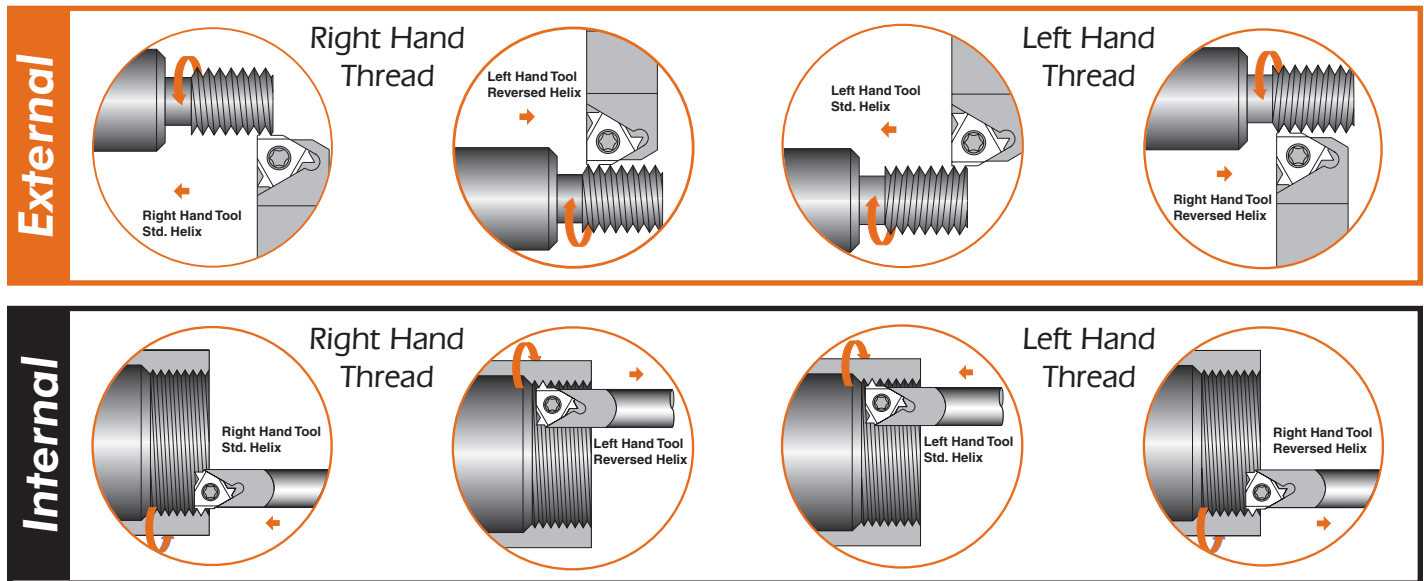


THREAD TURNING METHODS & ANVIL SELECTION

THREAD TURNING METHODS



ANVILS FOR SCREW TYPE TOOLS (Helix in Toolholder +1.5°)

Insert Size mm (I.C.)	Helix Required	Typical Application	Standard Toolholder +1.5°							
			-1.5°	-0.5°	0°	+0.5°	+2.5°	+3.5°	+4.5°	
			Reverse Threading	Grooving	Fine Threads	Normal Threading Applications	Positive Helix due to Coarse Pitch or Small Diameters			
16 (3/8" IC)	Ext. R.H.		SE16-3N	SE16-2N	SE16-1.5N	SE16-1N	SE16	SE16-1P	SE16-2P	SE16-3P
	Int. R.H.		SN16-3N	SN16-2N	SN16-1.5N	SN16-1N	SN16	SN16-1P	SN16-2P	SN16-3P
22 (1/2" IC)	Ext. R.H.		SE22-3N	SE22-2N	SE22-1.5N	SE22-1N	SE22	SE22-1P	SE22-2P	SE22-3P
	Int. R.H.		SN22-3N	SN22-2N	SN22-1.5N	SN22-1N	SN22	SN22-1P	SN22-2P	SN22-3P
27 (5/8" IC)	Ext. R.H.		SE27-3N	SE27-2N	SE27-1.5N	SE27-1N	SE27	SE27-1P	SE27-2P	SE27-3P
	Int. R.H.		SN27-3N	SN27-2N	SN27-1.5N	SN27-1N	SN27	SN27-1P	SN27-2P	SN27-3P

RECOMMENDED NUMBER OF PASSES FOR THREADING

TPI	48	32	24	20	16	14	12	10	8	7	6	5.5	5	4.5	4	3
P - mm	0.5	0.75	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0	8.0
No. of Passes	4-6	4-7	4-8	5-9	6-10	7-12	7-12	8-14	9-16	10-18	11-18	11-19	12-20	12-20	12-20	15-24