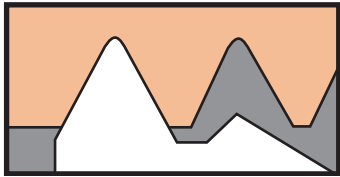


LAYDOWN *THREADING* INSERTS

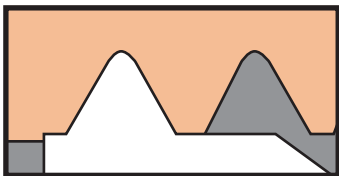
We offer a comprehensive range of laydown style inserts, which includes partial profile inserts, full profile inserts and chipbreaker "TD" style inserts.

Partial Profile



- Thread profile with universal profile shape of 60° without cutting edges for the thread crest.
- Reduced inventory.
- For various pitches within a specified range.
- Preferably one-off production.
- Outside/core diameters must be accurately pre-turned.

Full Profile



- Thread profile with full profile shape including thread height.
- For burr-free, precise threads for a specific thread dimension.
- General application.
- Machining allowance for outside/core diameter around .004" - .006" or 0.1 - 0.15 mm per surface.



- Tear Drop chipbreaker for improved chip control, time saving and increased tool life and productivity

INSERT DESIGNATIONS

(L) shown in one mm increments

06 = 5/32 I.C.
08 = 3/16 I.C.
11 = 1/4 I.C.
16 = 3/8 I.C.
22 = 1/2 I.C.
27 = 5/8 I.C.

1 - Edge Length

L - Left Hand
R - Right Hand

External left hand
Internal right hand

External right hand
Internal left hand

3 - Hand of Insert

60 = 60° partial profile

ACME = Am. Acme
ISO = ISO metric
NPT = Am. National Pipe Thread
STACME = Am. Stub Acme
UN = Unified National

5 - Thread Standard

16	E	R	20	UN	TD
1	2	3	4	5	6

2 - Internal / External

E - External

N - Internal

4 - Pitch

Partial Profile:
A = 16-48 MR= 24-11
AG = 8-48 N = 5-7
G = 8-14 S = 4.5-4

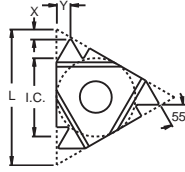
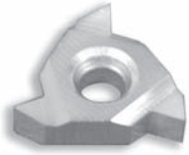
Full Profile:
Metric: Pitch in mm
Inches: Threads per inch

6 - Special Feature

TD - Tear Drop Chipbreaker

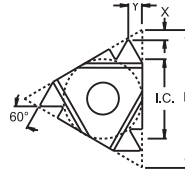
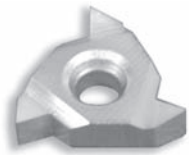
THREADING INSERTS

PARTIAL PROFILE 60°



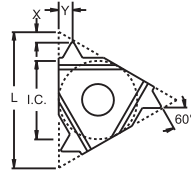
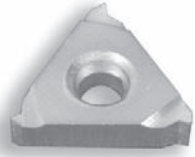
60° PP External

DESIGNATION	d	l	x	y	PITCH		COATED				UNCOATED						
					t.p.i.	mm	PTC2	PTC2E	STC2E			P10	P30	K20	HSS		
11ERA60	1/4	.43	.028	.031	48 - 16	0.5 - 1.5	●						●	●			
16ERA60	3/8	.63	.028	.031	48 - 16	0.5 - 1.5	●						●	●			
16ERAG60			.051	.059	48 - 8	0.5 - 3.0	●		●				●	●	●		
16ERG60			.051	.059	14 - 8	1.75 - 3.0	●		●				●	●			
22ERN60	1/2	.87	.071	.098	7 - 5	3.5 - 5.0	●		●				●	●			
22EU60	1/2U	.87U	.071	.433	4½ - 3¼	5.5 - 6.0	●						●	●			
27ERS60	5/8	1.06	.098	.157	4½ - 4	5.5 - 8.0	●						●	●	●		

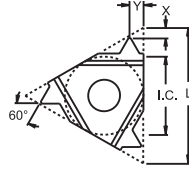
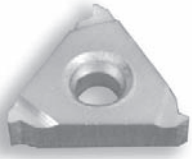


60° PP Internal

DESIGNATION	d	l	x	y	PITCH		COATED				UNCOATED						
					t.p.i.	mm	PTC2	PTC2E	STC2E			P10	P30	K20	HSS		
06NRA60	5/32	.24	.024	.024	48 - 20	0.5 - 1.25	●										
08NRA60	3/16	.32	.024	.028	48 - 16	0.5 - 1.5	●										
11NRA60	1/4	.43	.028	.031	48 - 16	0.5 - 1.5	●		●				●	●			
16NRA60	3/8	.63	.028	.031	48 - 16	0.5 - 1.5	●						●	●			
16NRAG60			.051	.059	24 - 11	1.0 - 2.5	●		●				●	●	●		
16NRG60			.051	.059	14 - 8	1.75 - 3.0	●		●				●	●	●		
16NRM60			.051	.059	14 - 8	1.75 - 3.0	●						●	●	●		
22NRN60	1/2	.87	.071	.098	7 - 5	3.5 - 5.0	●						●	●			
22NU60	1/2U	.87U	.031	.433	4½ - 3¼	5.5 - 6.0	●						●	●			



DESIGNATION	d	l	x	y	UN External								
					t.p.i	COATED				UNCOATED			
						PTC2	PTC2E	STC2E	STC2	P10	P30	K20	HSS
11ER72UN	1/4	.43	.028	.019	72	●						●	●
11ER64UN			.028	.019	64	●						●	●
11ER56UN			.028	.019	56	●						●	●
11ER36UN			.028	.019	36	●						●	●
11ER28UN			.028	.031	28	●						●	●
11ER24UN			.028	.031	24	●						●	●
11ER20UN			.028	.031	20	●						●	●
11ER18UN			.028	.031	18	●						●	●
11ER16UN			.028	.035	16	●						●	●
11ER14UN			.028	.039	14	●						●	●
16ER72UN	3/8	.63	.028	.019	72	●						●	●
16ER64UN			.028	.019	64	●						●	●
16ER56UN			.028	.019	56	●						●	●
16ER44UN			.028	.019	44	●						●	●
16ER40UN			.028	.019	40	●						●	●
16ER36UN			.028	.019	36	●						●	●
16ER32UN			.028	.019	32	●						●	●
16ER28UN			.028	.031	28	●	●					●	●
16ER27UN			.028	.031	27	●	●	●				●	●
16ER24UN			.028	.031	24	●	●	●	●			●	●
16ER20UN			.028	.031	20	●	●	●	●			●	●
16ER18UN			.028	.031	18	●	●	●				●	●
16ER16UN			.028	0.9	16	●	●	●	●			●	●
16ER14UN			.051	.059	14	●	●					●	●
16ER13UN			.051	.059	13	●	●					●	●
16ER12UN			.051	.059	12	●	●	●				●	●
16ER11.5UN			.051	.059	11½	●	●					●	●
16ER11UN			.051	.059	11	●	●	●				●	●
16ER10UN			.051	.059	10	●	●					●	●
16ER9UN			.051	.059	9	●	●					●	●
16ER8UN			.051	.062	8	●	●	●				●	●
16ER7UN			.051	.071	7	●						●	●
22ER7UN	1/2	.87	.071	.098	7	●						●	●
22ER6UN			.071	.098	6	●						●	●
22ER5UN			.071	.098	5	●						●	●
22EU4.5UN	1/2U	.87U	.079	.433	4½U	●						●	●
22EU4UN			.079	.433	4U	●						●	●
27ER4.5UN	5/8	1.06	.087	1.25	4½	●						●	●
27ER4UN			.087	1.25	4	●						●	●



UN Internal

DESIGNATION	d	l	x	y	PITCH t.p.i.	COATED			UNCOATED								
						PTC2	PTC2E	STC2E	P10	P30	K20	HSS					
06NR32UN	5/32	.24	.019	.019	32	●											
06NR24UN			.024	.024	24	●											
08NR24UN	3/16	.32	.024	.024	24	●											
08NR20UN			.024	.028	20	●											
08NR18UN			.028	.031	18	●											
11NR72UN	1/4	.43	.028	.019	72	●					●	●					
11NR64UN			.028	.019	64	●					●	●					
11NR56UN			.028	.019	56	●					●	●					
11NR36UN			.028	.019	36	●					●	●					
11NR28UN			.028	.031	28	●		●			●	●					
11NR24UN			.028	.031	24	●					●	●					
11NR20UN			.028	.031	20	●					●	●					
11NR18UN			.028	.031	18	●		●			●	●					
11NR16UN			.028	.035	16	●		●			●	●					
11NR14UN			.028	.035	14	●		●			●	●					
11NR12UN			.035	.039	12	●					●	●					
11NR11UN			.035	.043	11						●						
16NR72UN	3/8	.63	.028	.019	72	●					●	●					
16NR64UN			.028	.019	64	●					●	●					
16NR56UN			.028	.019	56	●					●	●					
16NR44UN			.028	.019	44	●					●	●					
16NR40UN			.028	.019	40	●					●	●					
16NR36UN			.028	.019	36	●					●	●					
16NR32UN			.028	.019	32	●					●	●					
16NR28UN			.028	.031	28	●					●	●					
16NR27UN			.028	.031	27	●					●	●					
16NR24UN			.028	.031	24	●					●	●					
16NR20UN			.028	.031	20	●	●	●			●	●					
16NR18UN			.028	.031	18	●					●	●					
16NR16UN			.028	.035	16	●	●	●		●	●	●					
16NR14UN			.051	.059	14	●	●	●			●	●					
16NR13UN			.051	.059	13	●					●	●					
16NR12UN			.051	.059	12	●	●	●		●	●	●					
16NR11.5UN			.051	.059	11½	●					●	●					
16NR11UN			.051	.059	11	●					●	●					
16NR10UN			.051	.059	10	●					●	●					
16NR9UN			.051	.059	9	●					●	●					
16NR8UN			.051	.062	8	●	●	●			●	●					●
22NR7UN	1/2	.87	.031	.098	7	●	●				●	●					
22NR6UN			.031	.098	6	●					●	●					
22NR5UN			.031	.098	5	●					●	●					
22NU4.5UN	1/2U	.87U	.079	.433	4½U	●					●						
22NU4UN			.079	.433	4U	●					●						
27NR4.5UN	5/8	1.06	.087	1.25	4½	●					●	●					
27NR4UN			.087	1.25	4	●					●	●					

