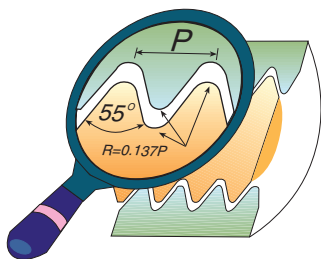
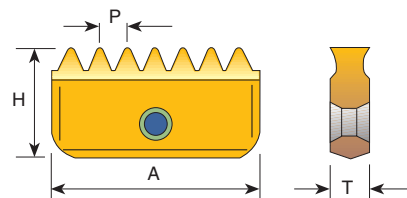


WHIT BSW, BSF, BSP



Same Insert for External and Internal thread.

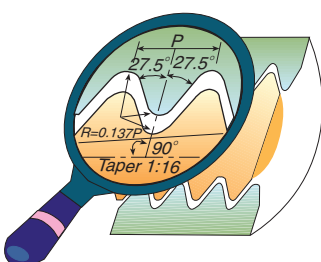


Pitch TPI	12	14	Insert Size = A 21	30	40
24		14-24 W			
20		14-20 W	21-20 W		
19	* 12-19 W	14-19 W	21-19 W		
16		14-16 W	21-16 W	30-16 W	
14		14-14 W	21-14 W	30-14 W	
11			21-11 W	30-11 W	40-11 W
8					40- 8 W
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

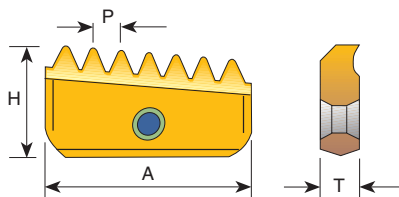
* One cutting edge

Order example: 21-11 W MT7

BSPT



Conical pipe thread inserts are one-sided and may be used for both External and Internal threading.



Pitch TPI	12	14	Insert Size = A 21	30	40
19	12-19 BSPT	14-19 BSPT			
14		14-14 BSPT	21-14 BSPT		
11			21-11 BSPT	30-11 BSPT	40-11 BSPT
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

Order example: 14-19 BSPT MT7

For conical preparation end mills see page 100

Mill Thread Inserts Speed and Feed Selection

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed m/min MT7
P	Low and Medium Carbon Steels	115-280
	High Carbon Steels	130-200
	Alloy Steels, Treated Steels	105-180
M	Stainless Steels	130-190
	Cast Steels	150-190
K	Cast Iron	80-170
N	Non- Ferrous and Aluminum	180-340
	Synthetics, Duroplastics, Thermoplastics	115-460
S	Nickel Alloys, Titanium Alloys	25- 90

Recommended FEED RATE : 0.05 - 0.15 mm

Spiral Mill Thread Inserts Speed and Feed Selection

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed m/min MT7
P	Low and Medium Carbon Steels	145-360
	High Carbon Steels	165-255
	Alloy Steels, Treated Steels	135-230
M	Stainless Steels	165-245
	Cast Steels	190-245
K	Cast Iron	100-220
N	Non- Ferrous and Aluminum	230-440
	Synthetics, Duroplastics, Thermoplastics	145-590
S	Nickel Alloys, Titanium Alloys	30-115

Recommended FEED RATE : 0.05 - 0.15 mm

As you may note, cutting speed is shown in range terms. In most standard cases choosing a speed in the middle of the range would be a good choice for a start.

For hard metals reduce cutting speed.