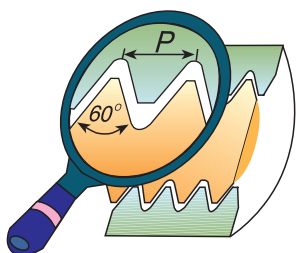
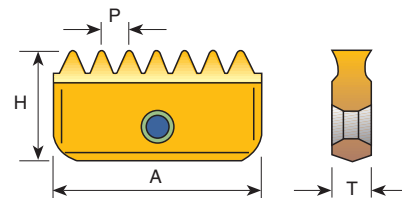


NPS



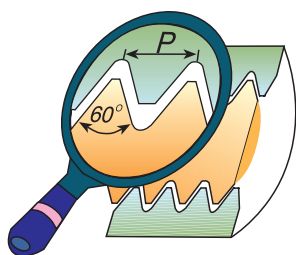
Same Insert for External and Internal thread



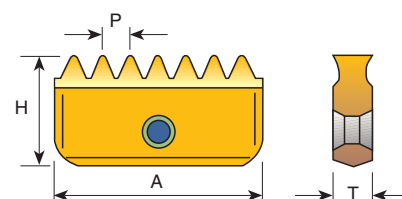
Pitch TPI	12	14	Insert Size = A 21	30	40
18	12-18 NPS	14-18 NPS			
14		14-14 NPS	21-14 NPS		
11.5			21-11.5 NPS	30-11.5 NPS	40-11.5 NPS
8				30- 8 NPS	40- 8 NPS
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

Order example: 30-11.5 NPS MT7

NPSF



Same Insert for External and Internal thread



Pitch TPI	12	14	Insert Size = A 21	30	40
18	12-18 NPSF	14-18 NPSF			
14		14-14 NPSF	21-14 NPSF		
11.5			21-11.5 NPSF	30-11.5 NPSF	40-11.5 NPSF
8				30- 8 NPSF	40- 8 NPSF
H	6.3	7.5	12	16	20
T	2.9	3.1	4.7	5.5	6.3

Order example: 21-14 NPSF MT7

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.