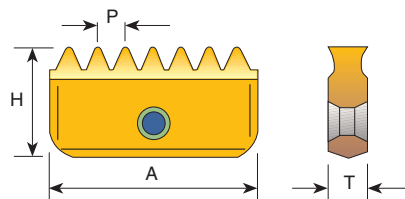
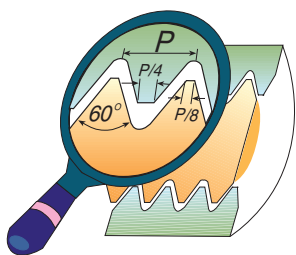


UN UNC, UNF, UNEF, UNS



Pitch TPI		Insert Size = A				
		12	14	21	30	40
32	Ext.		14 E 32 UN			
32	Int.	*12 I 32 UN	14 I 32 UN			
28	Ext.		14 E 28 UN			
28	Int.	*12 I 28 UN	14 I 28 UN			
27	Ext.					
27	Int.		14 I 27 UN			
24	Ext.		14 E 24 UN	21 E 24 UN		
24	Int.	*12 I 24 UN	14 I 24 UN	21 I 24 UN		
20	Ext.		14 E 20 UN	21 E 20 UN	30 E 20 UN	
20	Int.	*12 I 20 UN	14 I 20 UN	21 I 20 UN	30 I 20 UN	
18	Ext.		14 E 18 UN	21 E 18 UN	30 E 18 UN	
18	Int.	*12 I 18 UN	14 I 18 UN	21 I 18 UN	30 I 18 UN	
16	Ext.		14 E 16 UN	21 E 16 UN	30 E 16 UN	40 E 16 UN
16	Int.	*12 I 16 UN	14 I 16 UN	21 I 16 UN	30 I 16 UN	40 I 16 UN
14	Ext.		14 E 14 UN	21 E 14 UN	30 E 14 UN	40 E 14 UN
14	Int.		14 I 14 UN	21 I 14 UN	30 I 14 UN	40 I 14 UN
12	Ext.		14 E 12 UN	21 E 12 UN	30 E 12 UN	40 E 12 UN
12	Int.		14 I 12 UN	21 I 12 UN	30 I 12 UN	40 I 12 UN
11	Ext.					
11	Int.		14 I 11 UN			
10	Ext.			21 E 10 UN	30 E 10 UN	40 E 10 UN
10	Int.		14 I 10 UN	21 I 10 UN	30 I 10 UN	40 I 10 UN
8	Ext.				30 E 8 UN	40 E 8 UN
8	Int.			21 I 8 UN	30 I 8 UN	40 I 8 UN
7	Ext.					
7	Int.			21 I 7 UN		
6	Ext.				30 E 6 UN	40 E 6 UN
6	Int.				30 I 6 UN	40 I 6 UN
5	Ext.					
5	Int.				30 I 5 UN	
4.5	Ext.					
4.5	Int.					40 I 4.5UN
4	Ext.					
4	Int.					40 I 4 UN
H		.248	.295	.472	.630	.787
T		.114	.122	.185	.217	.248

* One cutting edge

Order example: 21 E 18 UN 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.