

## BSPT

Pitch TPI	Ordering Code	Thread Size
11	<b>H23-11 BSPT</b>	≥ 1" BSPT

Same insert for internal and external thread

## NPT

Pitch TPI	Ordering Code	Thread Size
11.5	<b>H23-11.5 NPT</b>	1"-2" NPT

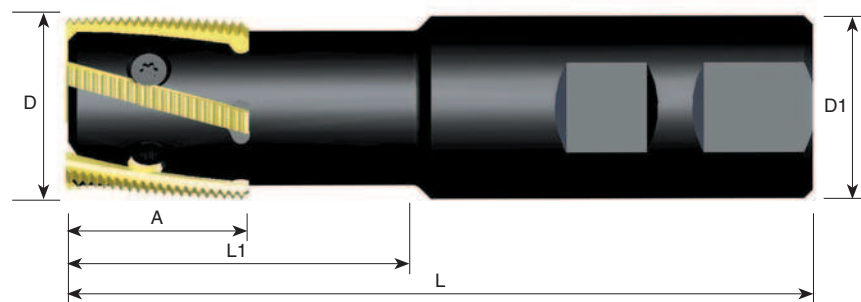
Same insert for internal and external thread

## NPTF

Pitch TPI	Ordering Code	Thread Size
11.5	<b>H23-11.5 NPTF</b>	1"-2" NPTF

Same insert for internal and external thread

## H32 Toolholder



Ordering Code	Insert Size A	D	D1	L	L1	No. of Inserts	Screw	Key
<b>SRH32-5</b>	32	32	32	130	60	5	S32	K22

## H32 Threading Inserts

Spiral inserts have one cutting edge



## ISO

Pitch mm	Ordering Code	Thread Size
1.5	<b>H32 I 1.5 ISO</b>	≥ M35
2.0	<b>H32 I 2.0 ISO</b>	≥ M36
3.0	<b>H32 I 3.0 ISO</b>	≥ M38
4.0	<b>H32 I 4.0 ISO</b>	≥ M40

For internal thread

## 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
<b>P</b>	Low and Medium Carbon Steels	115-280
	High Carbon Steels	130-200
	Alloy Steels, Treated Steels	105-180
<b>M</b>	Stainless Steels	130-190
	Cast Steels	150-190
<b>K</b>	Cast Iron	80-170
<b>N</b>	Non- Ferrous and Aluminum	180-340
	Synthetics, Duroplastics, Thermoplastics	115-460
<b>S</b>	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
<b>P</b>	Low and Medium Carbon Steels	145-360
	High Carbon Steels	165-255
	Alloy Steels, Treated Steels	135-230
<b>M</b>	Stainless Steels	165-245
	Cast Steels	190-245
<b>K</b>	Cast Iron	100-220
<b>N</b>	Non- Ferrous and Aluminum	230-440
	Synthetics, Duroplastics, Thermoplastics	145-590
<b>S</b>	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.