

## UN

Pitch TPI	Ordering Code	Thread Size
20	<b>H32 I 20 UN</b>	≥1 3/8"
18	<b>H32 I 18 UN</b>	≥1 3/8"
16	<b>H32 I 16 UN</b>	≥1 3/8"
12	<b>H32 I 12 UN</b>	≥1 7/16"
8	<b>H32 I 8 UN</b>	≥1 1/2"
6	<b>H32 I 6 UN</b>	≥1 9/16"

For internal thread

## Whitworth

Pitch TPI	Ordering Code	Thread Size
11	<b>H32-11 W</b>	Internal ≥ G 1 1/8" External ≥ G 1"

Same insert for internal and external thread

## BSPT

Pitch TPI	Ordering Code	Thread Size
11	<b>H32-11 BSPT</b>	Internal ≥ 1 1/8" BSPT External ≥ 1" BSPT

Same insert for internal and external thread

## NPT

Pitch TPI	Ordering Code	Thread Size
11.5	<b>H32-11.5 NPT</b>	Internal 1 1/4"-2" NPT External 1"-2" NPT

Same insert for internal and external thread

## NPTF

Pitch TPI	Ordering Code	Thread Size
11.5	<b>H32-11.5 NPTF</b>	Internal 1 1/4"-2" NPTF External 1"-2" NPTF

Same insert for internal and external 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.