

UN

Pitch TPI	Ordering Code	Thread Size
16	H63 I 16 UN	≥ 2 3/4"
12	H63 I 12 UN	≥ 2 3/4"
8	H63 I 8 UN	≥ 3"
6	H63 I 6 UN	≥ 3"

For internal thread

Whitworth

Pitch TPI	Ordering Code	Thread Size
11	H63 - 11 W	Internal ≥ G 2 1/2" External ≥ G 1"

Same insert for internal and external thread

BSPT

Pitch TPI	Ordering Code	Thread Size
11	H63 - 11 BSPT	Internal ≥ 2 1/2" BSPT External ≥ 1" BSPT

Same insert for internal and external thread

NPT

Pitch TPI	Ordering Code	Thread Size
11.5	H63 - 11.5 NPT	External ≥ 1" NPT

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
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.