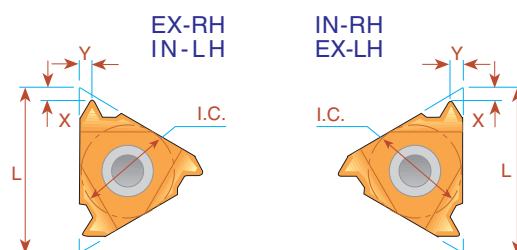
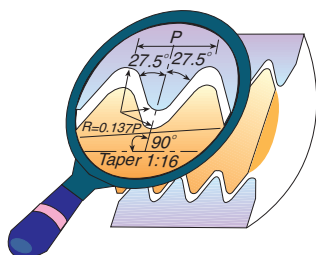


BSPT



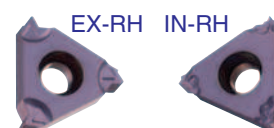
Pitch TPI	L	I.C. in	EXTERNAL Ordering Code		INTERNAL Ordering Code		X	Y
			Right Hand	Left Hand	Right Hand	Left Hand		
28	6	5/32	ULTRA MINIATURE →		* 06 IR 28 BSPT	* 06 IL 28 BSPT	0.7	0.6
28	8	3/16	MINIATURE →		* 08 IR 28 BSPT	* 08 IL 28 BSPT	0.6	0.6
19	8	3/16			* 08 IR 19 BSPT	* 08 IL 19 BSPT	0.6	0.6
28	11	1/4			11 IR 28 BSPT	11 IL 28 BSPT	0.6	0.6
19	11	1/4			11 IR 19 BSPT	11 IL 19 BSPT	0.8	0.9
14	11	1/4			11 IR 14 BSPT	11 IL 14 BSPT	0.9	1.0
28	16	3/8	16 ER 28 BSPT	16 EL 28 BSPT	16 IR 28 BSPT	16 IL 28 BSPT	0.6	0.6
19	16	3/8	16 ER 19 BSPT	16 EL 19 BSPT	16 IR 19 BSPT	16 IL 19 BSPT	0.8	0.9
14	16	3/8	16 ER 14 BSPT	16 EL 14 BSPT	16 IR 14 BSPT	16 IL 14 BSPT	1.0	1.2
11	16	3/8	16 ER 11 BSPT	16 EL 11 BSPT	16 IR 11 BSPT	16 IL 11 BSPT	1.1	1.5

Order example: 11 IR 14 BSPT BMA

* Available only in BXC grade

Type B

Ground Profile with Sintered Chip-breaker



Pitch TPI	L	I.C. in	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y
19	16	3/8	16 ER B 19 BSPT		1.0	1.1
14	16	3/8	16 ER B 14 BSPT	16 IR B 14 BSPT	1.2	1.0
11	16	3/8	16 ER B 11 BSPT	16 IR B 11 BSPT	1.5	1.1

Order example: 16 ER B 11 BSPT BMA

Carbide Grade Selection

Choose the C.P.T. grade specifically formulated for your application from the following list:

Uncoated Grades

P30*
(P20-P30) Carbide grade for carbon and cast steels, works well at medium to low cutting speeds.

K20*
(K10-K30) Carbide grade for non ferrous metals, aluminum and cast iron.

Coated Grades

P25C
(P15-P35) PVD TiN coated grade for treated and hard alloy steels (25 HRC & up) at medium to low cutting speeds.

MXC
(K10-K20)
(P10-P25) PVD TiN coated micrograin for free cutting untreated alloy steels (below 30 HRC), for stainless steels and cast iron.

BMA
(P20-P40)
(K20-K30) PVD TiAlN coated sub-micrograin grade for stainless steels and exotic materials at medium to high cutting speeds.

BXC**
(P30-P50)
(K25-K40) PVD TiN coated grade for low cutting speed. Works well with wide range of stainless steels.

Note: Due to our unique and specialized production techniques, C.P.T. coated inserts provide superior cutting performance and exceptionally long tool life.

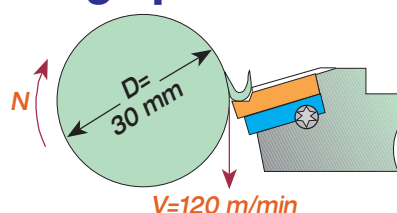
Recommended cutting speed (m/min) for thread turning inserts

ISO Standard	Materials	Coated				Uncoated	
		P25C*	MXC	BMA	BXC**	P30*	K20*
P	Steel: Low & Medium Carbon Steels	80-160	90-160	100-180	20-100	70-120	
	High Carbon Steels	80-120	80-150	90-160	30-80	60-100	
	Alloy Steels, Treated Steels	50-100	80-120	90-120	40-90	50-80	
	Cast Steel	80-140	100-140	120-160	30-80	50-100	
M	Stainless steel: Cast steels Stainless austenitic and austenitic ferritic steel and cast steel		70-120	90-130	30-90	70-100	80-100
K	Cast iron: Grey cast iron, cast iron with spherical graphite, malleable cast iron		80-130	80-150	30-90		60-100
N	Nonferrous Metal: Aluminium and other nonferrous metals, copper alloys non metallic		300-600		20-200		120-200
S	Super-alloys and Titanium: Heat resistant special alloys based on iron, nickel and cobalt, titanium and titanium alloys		40-80	50-100	15-30		
H	Hard Materials: Hardened steel, hardened cast iron materials, chilled cast iron		20-40	30-50	15-30		

- Upon request
- For miniature and ultra miniature insert

Conversion of Cutting Speed to Rotational Speed

Conversion of a selected cutting speed to rotational speed is calculated by the following formula:

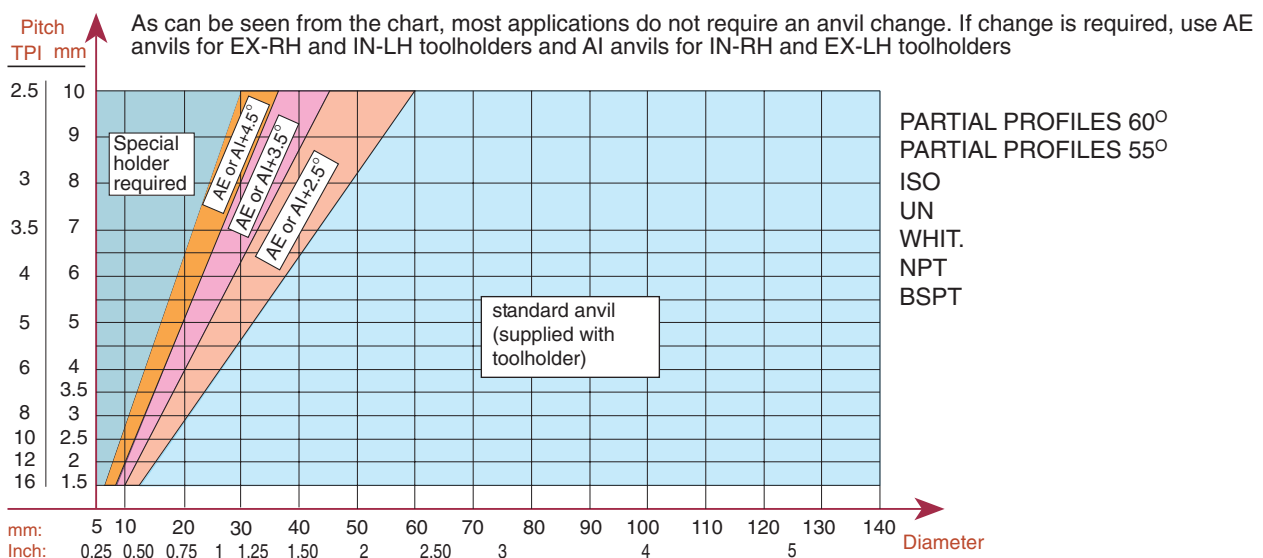
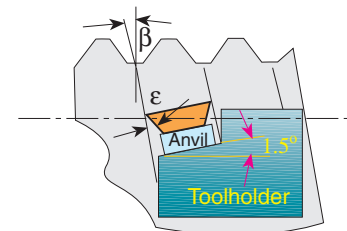
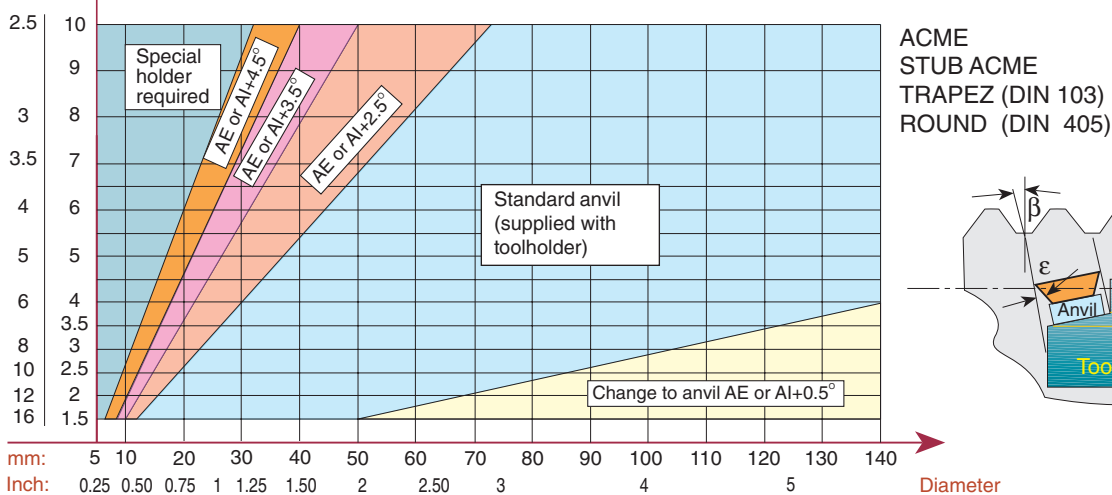


Example

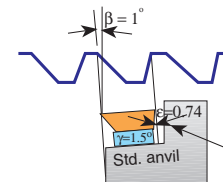
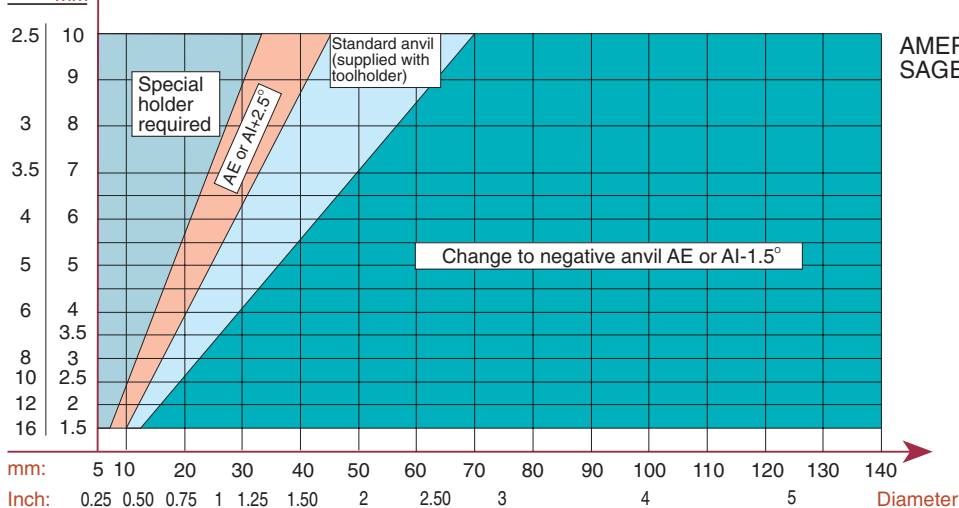
$$N = \frac{V \times 1000}{\pi \times D} = \frac{120 \times 1000}{3.14 \times 30} = 1274 \text{ RPM}$$

Anvil Change Recommendation

As can be seen from the chart, some Pitch to Diameter combinations require an anvil change. If change is required, use AE anvils for EX-RH and IN-LH toolholders and AI anvils for IN-RH and EX-LH toolholders.

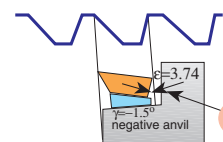


As can be seen from the chart, most applications require an anvil change. In most cases a negative anvil is required. use AE anvils for EX-RH



Before Anvil change

Replacing the standard anvil with an anvil with negative angle, will eliminate side rubbing



After Anvil Change