Threading Products

Partial Profile 60° & 55°

Round (DIN 405)

Whitworth

ISO Metric

BSPT

NPT

UN

M.A. FORD
High Performance Cutting Tools

*Where **high performance** is the **standard***



Insert Catalogue

M.A. FORDMAX RANGE

Performance, Precision, Economy

ISO 9001:2008 Certified

Threading Inserts Identification System

16 E R 1.50 ISO

① ② ③ ④ ⑤

① Insert Size	
Size	IC(mm)
11	6.35
16	9.525
22	12.7

② Thread Style
E=External
I=Internal

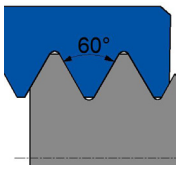
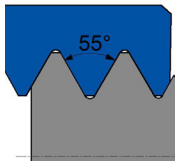
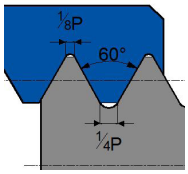
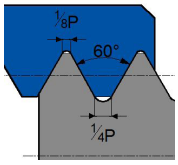
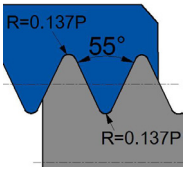
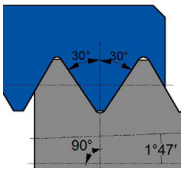
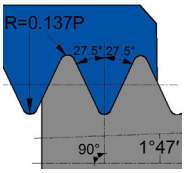
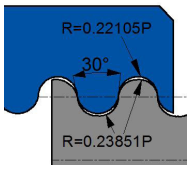
③ Hand of Insert
R=Right
L=Left

④ Pitch		
Full Profile		
mm	TPI	
0.35-5.0	72-5	
Partial Profile		
Size	mm	TPI
A	0.5-1.5	48-16
AG	0.5-3.0	48-8
G	1.75-3.0	14-8
N	3.5-5.0	7-5

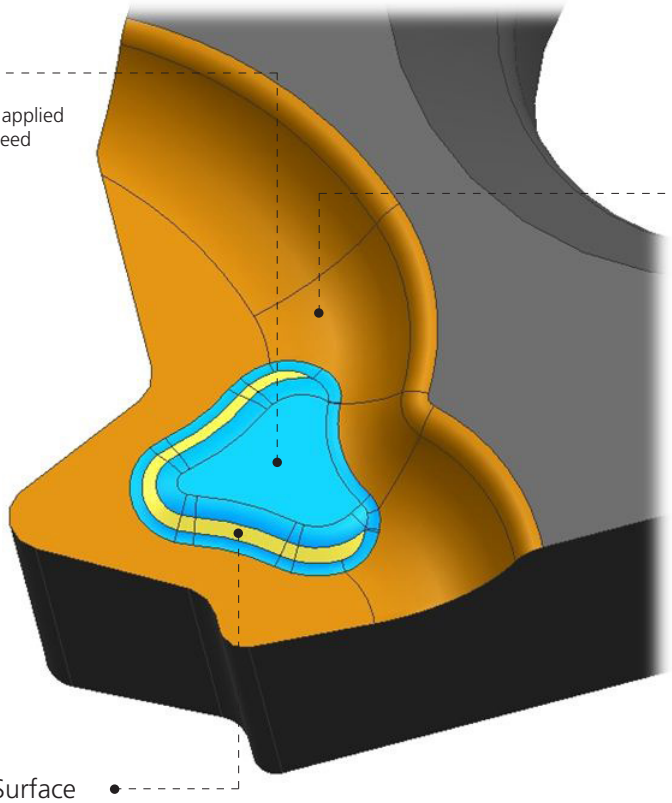
⑤ Thread Standard
60=Partial Profile 60°
55=Partial Profile 55°
ISO=ISO Metric
UN=American UN
W=Whitworth
NPT=National Pipe Thread
BSPT=British BSPT
ACME=American ACME
STACME=American Stub ACME
ABUT=American ABUT
API=API Thread
UNJ=American Aerospace Thread

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Overview of Threading Tools

Application	Thread Type	Thread Sketch	Thread Code	Pitch	Page
For general industry	Partial Profile 60°		60	0.5-5.0 (mm)	5
	Partial Profile 55°		55	48-5 (TPI)	6
	ISO Metric		ISO	1.0-5.0 (mm)	7
	UN		UN	24-8 (TPI)	9
Thread for pipe fittings and couplings for gas, water and sewage	Whitworth		W	19-11 (TPI)	10
	NPT		NPT	27-8 (TPI)	12
Thread for pipe fittings and couplings for gas, steam and water lines	BSPT		BSPT	28-11 (TPI)	11
Thread for pipe couplings in food and firefighting industry	Round (DIN 405)		RD	10-4 (TPI)	13

Advanced Geometry



Raised Platform

Excellent chip control, when applied to the radial infeed, flank infeed and incremental infeed

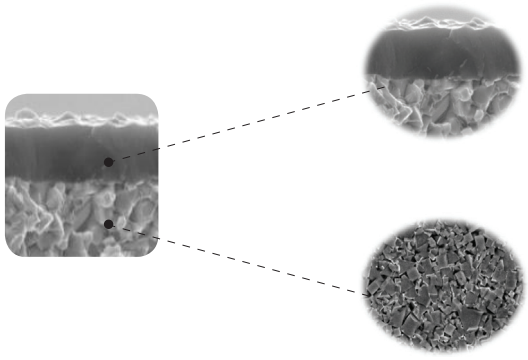
Wide Chip Area

Smooth chip discharge due to wide chip space

Curved Surface

Increased cooling area to reduce crater wear

FT325M-General Grade for Thread Turning



New TiAlN nano-structure coating

New TiAlN nano-structure coating with excellent heat resistance and bonding resistance

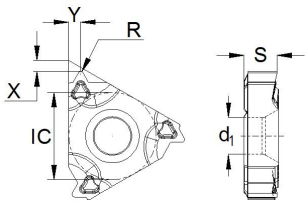
Micro-grain carbide substrate

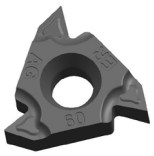
Micro-grain carbide substrate with high wear resistance and good toughness, suitable for thread turning a wide range of materials.

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Partial Profile 60°

▶ External

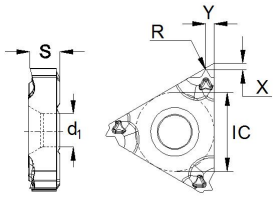


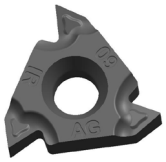
Ordering Code		Pitch (mm)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	16 ERA60	0.5-1.5	0.8	0.9	0.08	9.525	3.47	4	●
	16 ERAG60	0.5-3.0	1.1	1.5	0.08	9.525	3.47	4	●
	16 ERG60	1.75-3.0	1.2	1.7	0.25	9.525	3.47	4	●
	22 ERN60	3.5-5.0	1.7	2.5	0.51	12.7	4.71	5	●

● Stock ○ Available on request

Partial Profile 60°

▶ Internal

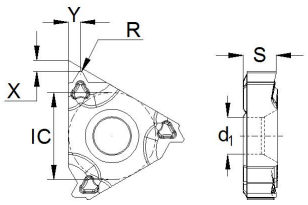


Ordering Code		Pitch (mm)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	11 IRA60	0.5-1.5	0.8	0.9	0.08	6.35	3	3.2	●
	16 IRA60	0.5-1.5	0.8	0.9	0.08	9.525	3.47	4	●
	16 IRAG60	0.5-3.0	1.1	1.5	0.08	9.525	3.47	4	●
	16 IRG60	1.75-3.0	1.2	1.7	0.13	9.525	3.47	4	●
	22 IRN60	3.5-5.0	1.7	2.5	0.25	12.7	4.71	5	●

● Stock ○ Available on request

Partial Profile 55°

▶ External

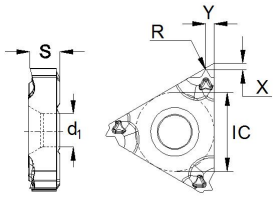


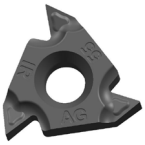
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	16 ERA55	48-16	0.8	0.9	0.08	9.525	3.47	4	●
	16 ERAG55	48-8	1.1	1.5	0.08	9.525	3.47	4	●
	16 ERG55	14-8	1.2	1.7	0.21	9.525	3.47	4	●
	22 ERN55	7-5	1.7	2.5	0.44	12.7	4.71	5	●

● Stock ○ Available on request

Partial Profile 55°

▶ Internal



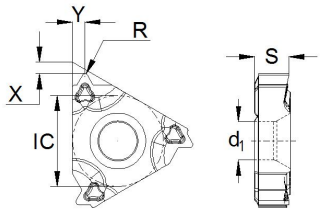
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	11 IRA55	48-16	0.8	0.9	0.08	6.35	3	3.2	●
	16 IRA55	48-16	0.8	0.9	0.08	9.525	3.47	4	●
	16 IRAG55	48-8	1.1	1.5	0.08	9.525	3.47	4	●
	16 IRG55	14-8	1.2	1.7	0.21	9.525	3.47	4	●
	22 IRN55	7-5	1.7	2.5	0.44	12.7	4.71	5	●

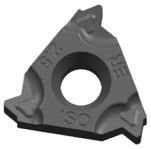
● Stock ○ Available on request

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Metric 60°

▶ External



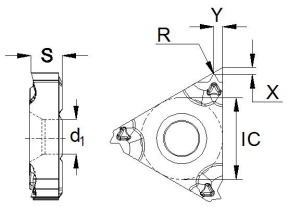


Ordering Code	Pitch (mm)	Dimensions (mm)						Stock
		X	Y	R	IC	S	d1	FT325M
16 ER1.00ISO	1.00	0.8	0.7	0.14	9.525	3.47	4	●
16 ER1.25ISO	1.25	0.8	0.9	0.18	9.525	3.47	4	●
16 ER1.50ISO	1.50	0.8	1.0	0.22	9.525	3.47	4	●
16 ER1.75ISO	1.75	1.2	1.2	0.25	9.525	3.47	4	●
16 ER2.00ISO	2.00	1.2	1.3	0.29	9.525	3.47	4	●
16 ER2.50ISO	2.50	1.2	1.5	0.36	9.525	3.47	4	●
16 ER3.00ISO	3.00	1.2	1.5	0.43	9.525	3.47	4	●
22 ER3.50ISO	3.50	1.6	2.3	0.45	12.7	4.71	5	●
22 ER4.00ISO	4.00	1.6	2.3	0.52	12.7	4.71	5	●
22 ER4.50ISO	4.50	1.7	2.4	0.58	12.7	4.71	5	●
22 ER5.00ISO	5.00	1.7	2.5	0.63	12.7	4.71	5	●

● Stock ○ Available on request

Metric 60°

▶ Internal



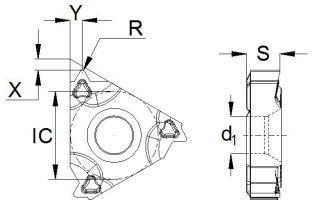
Ordering Code	Pitch (mm)	Dimensions (mm)						Stock
		X	Y	R	IC	S	d1	FT325M
11 IR1.00ISO	1.00	0.8	0.7	0.07	6.35	3	3.2	●
11 IR1.25ISO	1.25	0.8	0.9	0.09	6.35	3	3.2	●
11 IR1.50ISO	1.50	0.8	1.0	0.11	6.35	3	3.2	●
11 IR1.75ISO	1.75	0.9	1.1	0.13	6.35	3	3.2	●
11 IR2.00ISO	2.00	0.9	1.1	0.15	6.35	3	3.2	●
16 IR1.00ISO	1.00	0.8	0.7	0.07	9.525	3.47	4	●
16 IR1.25ISO	1.25	0.8	0.9	0.09	9.525	3.47	4	●
16 IR1.50ISO	1.50	0.8	1.0	0.11	9.525	3.47	4	●
16 IR1.75ISO	1.75	1.2	1.2	0.13	9.525	3.47	4	●
16 IR2.00ISO	2.00	1.2	1.3	0.15	9.525	3.47	4	●
16 IR2.50ISO	2.50	1.2	1.5	0.18	9.525	3.47	4	●
16 IR3.00ISO	3.00	1.2	1.5	0.22	9.525	3.47	4	●
22 IR3.50ISO	3.50	1.6	2.3	0.22	12.7	4.71	5	●
22 IR4.00ISO	4.00	1.6	2.3	0.25	12.7	4.71	5	●
22 IR4.50ISO	4.50	1.6	2.4	0.28	12.7	4.71	5	●
22 IR5.00ISO	5.00	1.6	2.3	0.32	12.7	4.71	5	●

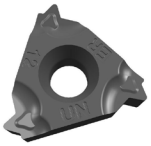


● Stock ○ Available on request

UN 60°

▶ External

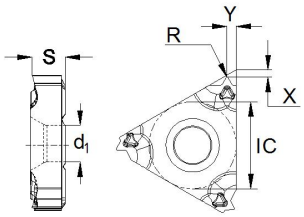


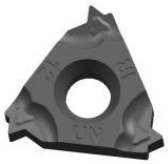
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	16 ER24UN	24	0.8	0.8	0.15	9.525	3.47	4	●
	16 ER20UN	20	0.8	0.9	0.18	9.525	3.47	4	●
	16 ER18UN	18	0.8	1.0	0.20	9.525	3.47	4	●
	16 ER16UN	16	0.9	1.1	0.23	9.525	3.47	4	●
	16 ER14UN	14	1.2	1.5	0.26	9.525	3.47	4	●
	16 ER12UN	12	1.2	1.5	0.31	9.525	3.47	4	●
	16 ER10UN	10	1.2	1.5	0.37	9.525	3.47	4	○
	16 ER8UN	8	1.3	1.7	0.46	9.525	3.47	4	●

● Stock ○ Available on request

UN 60°

▶ Internal

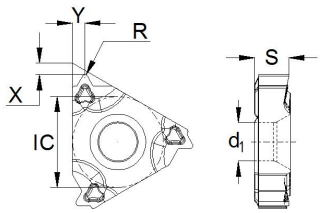


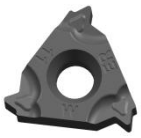
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	11 IR20UN	20	0.8	0.9	0.09	6.35	3	3.2	●
	11 IR18UN	18	0.8	1.0	0.10	6.35	3	3.2	●
	16 IR24UN	24	0.8	0.8	0.08	9.525	3.47	4	●
	16 IR20UN	20	0.8	0.9	0.09	9.525	3.47	4	●
	16 IR18UN	18	0.8	1.0	0.10	9.525	3.47	4	●
	16 IR16UN	16	0.9	1.1	0.12	9.525	3.47	4	●
	16 IR14UN	14	1.2	1.5	0.13	9.525	3.47	4	●
	16 IR12UN	12	1.2	1.5	0.16	9.525	3.47	4	●
	16 IR10UN	10	1.2	1.5	0.19	9.525	3.47	4	○
	16 IR8UN	8	1.3	1.7	0.23	9.525	3.47	4	●

● Stock ○ Available on request

Whitworth 55°

▶ External

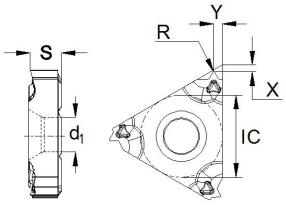


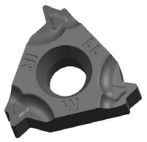
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	16 ER19W	19	0.8	1.0	0.17	9.525	3.47	4	●
	16 ER14W	14	1.2	1.5	0.24	9.525	3.47	4	●
	16 ER11W	11	1.2	1.5	0.30	9.525	3.47	4	●

● Stock ○ Available on request

Whitworth 55°

▶ Internal

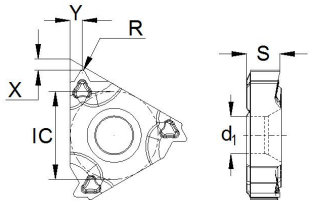


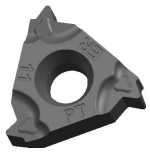
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	16 IR19W	19	0.8	1.0	0.17	9.525	3.47	4	●
	16 IR14W	14	1.2	1.5	0.24	9.525	3.47	4	●
	16 IR11W	11	1.2	1.5	0.30	9.525	3.47	4	●

● Stock ○ Available on request

BSPT 55°

▶ External

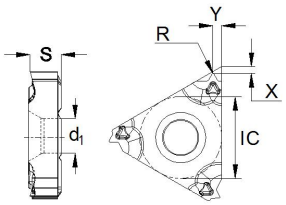


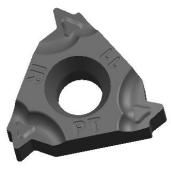
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	16 ER28BSPT	28	0.7	0.8	0.11	9.525	3.47	4	●
	16 ER19BSPT	19	0.8	1.0	0.17	9.525	3.47	4	●
	16 ER14BSPT	14	1.2	1.5	0.24	9.525	3.47	4	●
	16 ER11BSPT	11	1.2	1.5	0.30	9.525	3.47	4	●

● Stock ○ Available on request

BSPT 55°

▶ Internal

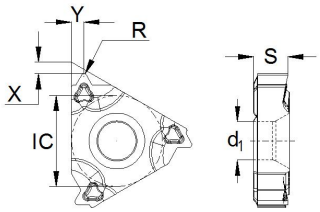


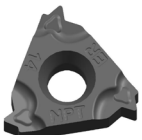
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	11 IR19BSPT	19	0.8	1.0	0.18	6.35	3	3.2	●
	11 IR14BSPT	14	0.9	1.1	0.24	6.35	3	3.2	●
	16 IR28BSPT	28	0.7	0.8	0.11	9.525	3.47	4	●
	16 IR19BSPT	19	0.8	1.0	0.17	9.525	3.47	4	●
	16 IR14BSPT	14	1.2	1.5	0.24	9.525	3.47	4	●
	16 IR11BSPT	11	1.2	1.5	0.30	9.525	3.47	4	●

● Stock ○ Available on request

NPT 60°

▶ External

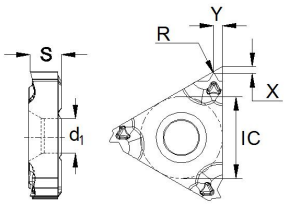


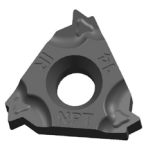
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	16 ER27NPT	27	0.7	0.8	0.13	9.525	3.47	4	●
	16 ER18NPT	18	0.8	1.0	0.20	9.525	3.47	4	●
	16 ER14NPT	14	1.2	1.5	0.22	9.525	3.47	4	●
	16 ER11.5NPT	11.5	1.2	1.5	0.25	9.525	3.47	4	●
	16 ER8NPT	8	1.3	1.8	0.30	9.525	3.47	4	●

● Stock ○ Available on request

NPT 60°

▶ Internal

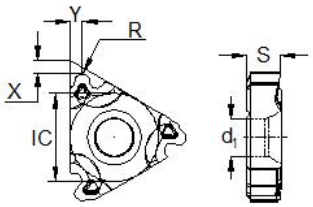


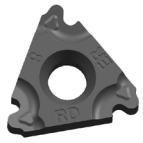
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	11 IR18NPT	18	0.8	1.0	0.20	6.35	3	3.2	●
	16 IR27NPT	27	0.7	0.8	0.13	9.525	3.47	4	●
	16 IR18NPT	18	0.8	1.0	0.20	9.525	3.47	4	●
	16 IR14NPT	14	1.2	1.5	0.22	9.525	3.47	4	●
	16 IR11.5NPT	11.5	1.2	1.5	0.25	9.525	3.47	4	●
	16 IR8NPT	8	1.3	1.8	0.30	9.525	3.47	4	●

● Stock ○ Available on request

Round 30°

▶ External

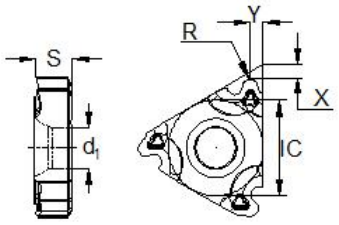


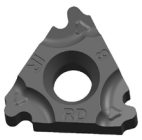
Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	16 ER10RD	10	1.1	1.2	0.60	9.525	3.47	4	○
	16 ER8RD	8	1.4	1.3	0.75	9.525	3.47	4	●
	16 ER6RD	6	1.4	1.5	1.00	9.525	3.47	4	●
	22 ER4RD	4	2.2	2.3	1.51	12.7	4.71	5	○

● Stock ○ Available on request

Round 30°

▶ Internal



Ordering Code		Pitch (TPI)	Dimensions (mm)						Stock
			X	Y	R	IC	S	d1	FT325M
	16 IR10RD	10	1.1	1.2	0.55	9.525	3.47	4	○
	16 IR8RD	8	1.4	1.3	0.70	9.525	3.47	4	●
	16 IR6RD	6	1.4	1.5	0.936	9.525	3.47	4	●
	22 IR4RD	4	2.2	2.3	1.40	12.7	4.71	5	○

● Stock ○ Available on request

Cutting Speed Recommendation Table

Workpiece Material				Material Hardness	Cutting Speed Vc(m/min)
					Grade
					FT325M
P	Carbon Steel	Low-carbon (C=0.1-0.25%)		HB125	160 (120-230)
		Medium-carbon (C=0.25-0.55%)		HB150	150 (100-195)
		High-carbon (C=0.55-0.80%)		HB170	140 (90-180)
	Low-alloy Steel	Non-hardened		HB180	130 (100-180)
		Hardened and tempered		HB275	100(75-140)
		Hardened and tempered		HB350	80 (60-130)
	High-alloy Steel	Annealed		HB200	110 (80-140)
		Hardened and tempered		HB325	90 (70-115)
	Cast Steel	Unalloyed		HB180	200 (180-220)
		Low-alloy		HB200	110 (70-150)
		High-alloy		HB225	100 (60-120)
		Manganese steel (12-14% Mn)		HB250	40 (40-50)
M	Stainless Steel	Austenitic		HB180	120 (90-140)
		Ferrite/Martensite		HB200	140 (70-170)
		Duplex stainless steel		HB230	90 (60-120)
K	Malleable Cast Iron	Ferrite		HB130	130 (110-170)
		Pearlite		HB230	100 (85-145)
	Gray Cast Iron	Low tensile strength		HB180	120 (100-160)
		High tensile strength		HB260	100 (80-140)
	Nodular Cast Iron	Ferrite		HB160	125 (110-160)
		Pearlite		HB250	100 (80-120)
N	Wrought Aluminum Alloys	Non aging		HB60	500 (350-700)
		Aged		HB100	400 (300-500)
	Cast Aluminum Alloys	Non aging		HB75	450 (300-500)
		Aged		HB90	290 (200-400)
		Containing silicon (13-22% Si)		HB130	200 (100-300)
	Copper and Copper Alloys	Brass		HB90	220 (100-300)
		Bronze and non-leaded copper		HB100	180 (80-255)
S	Heat-resistant Alloys	Iron base	Annealed	HB200	45 (35-60)
			Aged	HB280	35 (25-50)
		Nickel base and cobalt base	Annealed	HB250	25 (15-30)
			Aged	HB350	15 (10-25)
			Cast	HB320	13 (10-20)
	Titanium Alloys	Commercial pure (99.5% Ti)		400Rm	150 (140-170)
		(+) alloys		1050Rm	60 (50-70)
H	High Hardness Materials	Hardened steel		HRC55	45 (40-50)
		Chilled cast iron		HB400	40 (30-50)

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Cutting Passes and Radial Infeed Recommendation Table

▶ ISO Metric / External

Pitch (mm)	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00
Total infeed(mm)	0.65	0.79	0.95	1.11	1.26	1.56	1.88	2.18	2.49	2.79	3.10
Total passes	5	6	6	8	8	10	12	12	13	14	14
No. of infeed	Radial infeed per pass (mm)										
1	0.16	0.17	0.20	0.17	0.20	0.20	0.20	0.24	0.24	0.27	0.29
2	0.15	0.15	0.19	0.17	0.19	0.19	0.19	0.23	0.22	0.25	0.28
3	0.14	0.14	0.18	0.16	0.18	0.18	0.19	0.22	0.22	0.24	0.27
4	0.12	0.13	0.16	0.15	0.17	0.17	0.18	0.21	0.21	0.23	0.26
5	0.08	0.12	0.14	0.14	0.16	0.17	0.17	0.21	0.21	0.23	0.25
6	-	0.08	0.08	0.13	0.15	0.16	0.17	0.20	0.20	0.22	0.25
7	-	-	-	0.11	0.13	0.15	0.16	0.18	0.19	0.21	0.24
8	-	-	-	0.08	0.08	0.14	0.15	0.17	0.18	0.20	0.23
9	-	-	-	-	-	0.12	0.14	0.16	0.17	0.19	0.22
10	-	-	-	-	-	0.08	0.13	0.15	0.16	0.18	0.20
11	-	-	-	-	-	-	0.12	0.13	0.15	0.17	0.19
12	-	-	-	-	-	-	0.08	0.08	0.14	0.16	0.17
13	-	-	-	-	-	-	-	-	0.12	0.14	0.15
14	-	-	-	-	-	-	-	-	0.18	0.10	0.10

▶ ISO Metric / External

Pitch (mm)	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00
Total infeed(mm)	0.63	0.77	0.92	1.05	1.20	1.48	1.78	2.03	2.31	2.61	2.88
Total passes	5	6	6	8	8	10	12	12	13	14	14
No. of infeed	Radial infeed per pass (mm)										
1	0.15	0.16	0.20	0.16	0.19	0.19	0.19	0.22	0.21	0.23	0.26
2	0.14	0.15	0.18	0.15	0.18	0.18	0.18	0.21	0.21	0.23	0.26
3	0.13	0.14	0.17	0.15	0.17	0.17	0.18	0.20	0.20	0.22	0.25
4	0.12	0.13	0.15	0.14	0.16	0.17	0.17	0.20	0.19	0.22	0.24
5	0.08	0.11	0.13	0.13	0.15	0.16	0.16	0.19	0.19	0.21	0.24
6	-	0.08	0.08	0.12	0.14	0.15	0.16	0.18	0.18	0.20	0.23
7	-	-	-	0.11	0.12	0.14	0.15	0.17	0.18	0.20	0.22
8	-	-	-	0.08	0.08	0.13	0.14	0.16	0.17	0.19	0.21
9	-	-	-	-	-	0.12	0.14	0.15	0.16	0.18	0.20
10	-	-	-	-	-	0.08	0.12	0.14	0.15	0.17	0.19
11	-	-	-	-	-	-	0.11	0.12	0.14	0.16	0.18
12	-	-	-	-	-	-	0.08	0.08	0.13	0.15	0.16
13	-	-	-	-	-	-	-	-	0.12	0.14	0.15
14	-	-	-	-	-	-	-	-	0.08	0.10	0.10

▶ UN / External

Pitch (TPI)	24	20	18	16	14	12	10	8
Total infeed(mm)	0.70	0.84	0.92	1.04	1.17	1.35	1.62	2.02
Total passes	5	6	6	7	8	8	10	12
No. of infeed	Radial infeed per pass (mm)							
1	0.18	0.18	0.20	0.19	0.18	0.22	0.21	0.22
2	0.16	0.17	0.18	0.18	0.18	0.21	0.20	0.21
3	0.15	0.15	0.17	0.17	0.17	0.20	0.19	0.20
4	0.13	0.14	0.15	0.16	0.16	0.19	0.18	0.20
5	0.08	0.12	0.13	0.14	0.15	0.17	0.17	0.19
6	-	0.08	0.08	0.12	0.14	0.15	0.16	0.18
7	-	-	-	0.08	0.12	0.13	0.15	0.17
8	-	-	-	-	0.08	0.08	0.14	0.16
9	-	-	-	-	-	-	0.12	0.15
10	-	-	-	-	-	-	0.08	0.14
11	-	-	-	-	-	-	-	0.12
12	-	-	-	-	-	-	-	0.08

▶ UN / Internal

Pitch (TPI)	24	20	18	16	14	12	10	8
Total infeed(mm)	0.66	0.78	0.86	0.96	1.07	1.25	1.48	2.03
Total passes	5	6	6	7	8	8	10	12
No. of infeed	Radial infeed per pass (mm)							
1	0.16	0.16	0.18	0.17	0.16	0.20	0.19	0.22
2	0.15	0.16	0.17	0.16	0.16	0.19	0.18	0.21
3	0.14	0.14	0.16	0.15	0.15	0.18	0.17	0.20
4	0.12	0.13	0.14	0.14	0.14	0.17	0.17	0.20
5	0.08	0.12	0.13	0.13	0.14	0.16	0.16	0.19
6	-	0.08	0.08	0.12	0.13	0.14	0.15	0.18
7	-	-	-	0.08	0.11	0.13	0.14	0.17
8	-	-	-	-	0.08	0.08	0.13	0.16
9	-	-	-	-	-	-	0.12	0.15
10	-	-	-	-	-	-	0.08	0.14
11	-	-	-	-	-	-	-	0.12
12	-	-	-	-	-	-	-	0.08

▶ Whitworth / External & Internal

Pitch (TPI)	19	14	11
Total infeed(mm)	0.90	1.20	1.51
Total passes	6	8	9
No. of infeed	Radial infeed per pass (mm)		
1	0.19	0.19	0.22
2	0.18	0.18	0.21
3	0.17	0.17	0.20
4	0.15	0.16	0.19
5	0.13	0.15	0.18
6	0.08	0.14	0.16
7	-	0.12	0.15
8	-	0.08	0.13
9	-	-	0.08

▶ BSPT / External & Internal

Pitch (TPI)	28	19	14	11
Total infeed(mm)	0.62	0.90	1.20	1.51
Total passes	5	6	8	9
No. of infeed	Radial infeed per pass (mm)			
1	0.15	0.19	0.19	0.22
2	0.14	0.18	0.18	0.21
3	0.13	0.17	0.17	0.20
4	0.12	0.15	0.16	0.19
5	0.08	0.13	0.15	0.18
6	-	0.08	0.14	0.16
7	-	-	0.12	0.15
8	-	-	0.08	0.13
9	-	-	-	0.08

▶ NPT /External& Internal

Pitch (TPI)	27	18	14	11.5	8
Total infeed(mm)	0.76	1.11	1.42	1.73	2.48
Total passes	6	8	10	12	15
No. of infeed	Radial infeed per pass (mm)				
1	0.15	0.17	0.18	0.18	0.21
2	0.15	0.17	0.17	0.17	0.21
3	0.14	0.16	0.16	0.17	0.20
4	0.13	0.15	0.16	0.16	0.20
5	0.11	0.14	0.15	0.16	0.19
6	0.08	0.13	0.14	0.15	0.18
7	-	0.11	0.14	0.15	0.18
8	-	0.08	0.13	0.14	0.17
9	-	-	0.11	0.13	0.17
10	-	-	0.08	0.12	0.16
11	-	-	-	0.11	0.15
12	-	-	-	0.08	0.14
13	-	-	-	-	0.13
14	-	-	-	-	0.11
15	-	-	-	-	0.08

▶ Round / External

Pitch (TPI)	10	8	6	4
Total infeed(mm)	1.30	1.63	2.17	2.95
Total passes	8	10	12	14
No. of infeed	Radial infeed per pass (mm)			
1	0.21	0.21	0.24	0.30
2	0.20	0.20	0.23	0.29
3	0.19	0.19	0.22	0.28
4	0.18	0.19	0.21	0.27
5	0.16	0.18	0.20	0.26
6	0.15	0.17	0.19	0.25
7	0.13	0.15	0.18	0.24
8	0.08	0.14	0.17	0.23
9	-	0.12	0.16	0.22
10	-	0.08	0.15	0.21
11	-	-	0.13	0.19
12	-	-	0.08	0.18
13	-	-	-	0.15
14	-	-	-	0.10

▶ Round / Internal

Pitch (TPI)	10	8	6	4
Total infeed(mm)	1.34	1.64	2.18	2.98
Total passes	8	10	12	14
No. of infeed	Radial infeed per pass (mm)			
1	0.22	0.21	0.24	0.30
2	0.21	0.20	0.23	0.29
3	0.20	0.20	0.22	0.29
4	0.18	0.19	0.21	0.28
5	0.17	0.18	0.21	0.27
6	0.15	0.17	0.20	0.26
7	0.13	0.16	0.19	0.25
8	0.08	0.14	0.17	0.24
9	-	0.12	0.16	0.23
10	-	0.08	0.15	0.21
11	-	-	0.13	0.20
12	-	-	0.08	0.18
13	-	-	-	0.16
14	-	-	-	0.10

Attention:Generally, the radial feed shall not be less than 0.05mm. When machining austenitic stainless steel, the radial feed shall not be less than 0.08mm.

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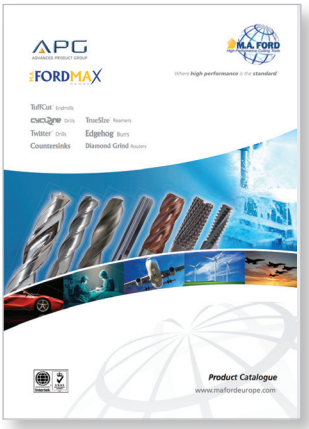
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