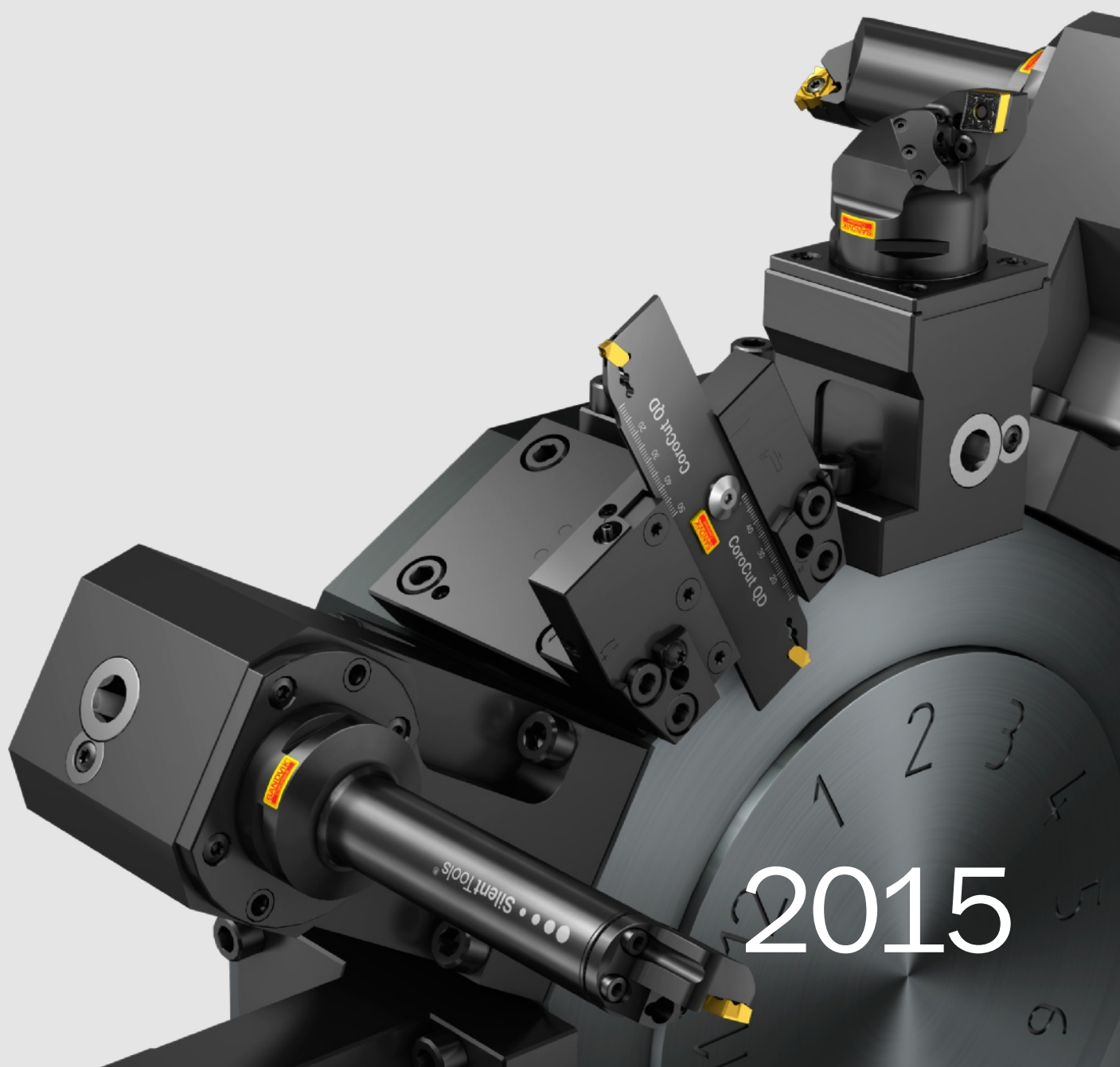


Turning tools

GENERAL TURNING
PARTING AND GROOVING
THREAD TURNING
MULTIFUNCTIONAL TOOLS
TOOL HOLDING
TURNING TOOL ADAPTORS



2015



CoroThread® 266

Indexable insert tool with 3 cutting edges

Ultra-rigid thread turning for all types of threads



Tailor Made
See page 15

Application



- First choice for all thread turning operations
- Minimum hole size: 12 mm (0.472 inch)

P M K N S H
ISO application area

Three different threading insert types



Full profile
High productivity



V-profile
Minimum tool inventory



Multi-point
Economical mass production

Geometries and grades for all materials



Standard
A-geometry



Sharp
F-geometry



Chip-breaking
C-geometry

- Pitches: 0.5-8 mm (0.02-0.315 threads/in)
- Minimum internal hole: 12 mm (0.472 inch)
- Tailor Made inserts for almost any thread form or pitch

Tool holding

- Coromant Capto®
- Rectangular shank holders
- Cylindrical boring bars for use with Easyfix
- Cylindrical boring bars with flats
- Carbide boring bars
- Cartridges for built-in tools
- CoroTurn® SL cutting heads



iLock™
ingenious locking interface
See page 37

Secure iLock™ clamping

The slotted insert sits rigidly on the T-rails in the pocket eliminating any insert movement caused by cutting force variations.



T-Max® Twin-Lock

System with multi-tooth inserts

For external and internal oil pipe threading

Application



- Tubes, casings and couplings
- Tool joint and rotary shouldered connection threads
- Minimum hole size 60 mm (2.36 inch)
- Optimized for steel



ISO application area

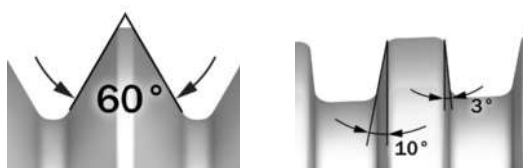


Inserts

- Inserts in versatile grades GC1125 and GC4215 - optimized for steel
- One all-round geometry

Tool holding

- CoroTurn® SL cutting heads size 40
- Rectangular and cylindrical shanks
- Cartridge with lever design



Thread profiles for API Round Vee and API Buttress

Multi-tooth inserts

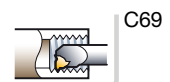
Multi-toothed inserts with sharp cutting edges for high quality threads



C66



C68



C69

How to choose threading tool

1 Define your type of operation

- External or internal threading
- Right hand threads or left hand threads
- Select the thread type

2 Select insert size, grade, geometry and type of infeed

Choose your pitch and size of insert. If possible choose a multi-point insert for better productivity.

Choose your geometry, grade and type of infeed. Detailed recommendations on page C101

Multi-point inserts are similar to full profile-, but have more than one insert point (two pointed inserts give double productivity, three pointed insert give triple etc.). Stable conditions are needed due to increased cutting forces as the cutting edge has a longer contact length.

- Requires fewer passes, giving better tool life, productivity and lower tool costs.
- Requires longer passes beyond the workpiece thread to accommodate the extra points.

3 Select tooling system and type of holder

Choose Coromant Capto or shank tool, depending on clamping possibilities in turret/spindle.

Choose type of holder and coupling size or shank.

The insert seat must correspond to the size of the insert.

4 Select suitable shim

Choose correct shim for your pitch/workpiece diameter. See page C89.

Shims are used to give different tilts to the insert and are available in 1° steps from -2° to +4°.

Threading holders are supplied as standard with a shim giving +1° inclination angle.

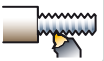
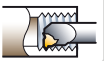
Note: No shims for smaller diameter bars as the angle is fixed at +2°.

See page C89

5 Select size, number of passes and speed

The recommendations are intended as starting values. (Page C91)

Cutting speed recommendations, page C85.

	Grade descriptions		Inserts		Cutting data
	External holders		Internal holders		Code key
	Explanation of ISO 13399 parameters		Coolant supply information		Tailor Made options

Threading profiles

	V-profile 60° Non-topping		V-profile 55° Non-topping		Metric 60° Full form		UN 60° Full form		Whitworth 55° (BSW, BSF, BSP) Full form	
					ISO 965-1998 Tolerance class 6		ISO 5864-1978 Tolerance class 2A, ext. Tolerance class 2B, int.		ISO 228-1982 BS 2779-1973 BS 84-1956 Class A tolerance	
	Internal	External	Internal	External	Internal	External	Internal	External	Internal	External
CoroThread® 266	C7	C6	C9	C8	C13	C10	C17	C15	C21	C19
T-Max U-Lock®	C56		C57		C58		C59		C60	
CoroTurn® XS	C72				C73		C74		C75	
CoroCut® XS		C71				C70				
CoroCut® MB	C78				C79		C80		C81	
T-Max® Twin-Lock										
	NPT 60° NPSC, NPTR, LINE PIPE Full form		BSPT 55° Full form		NPTF 60° Full form		Round 30° Full form		MJ 60° Full form	
	ANSI B.1.20.1-1983		ISO 7/1 BS21:1985		ANSI B1.20.3-1976 Tolerance class 2		DIN 405. Tolerance class 7 on effective dia. Tolerance class 6 on major (external) and minor (internal) dia.		ISO 5855-1983 Tolerance class 4 on pitch diameter. Tolerance class 6 on major (external) and minor (internal) dia.	
	Internal	External	Internal	External	Internal	External	Internal	External	Internal	External
CoroThread® 266	C23	C22	C25	C24	C26	C26	C28	C27		C29
T-Max U-Lock®	C61									
CoroTurn® XS	C82									
CoroCut® XS										
CoroCut® MB	C82									
T-Max® Twin-Lock										
	UNJ 60° Full form		ISO Trapezoidal 30° Chamfered crest form		ACME 29° Chamfered crest form		STUB-ACME 29° Chamfered crest form		API 60° Full form for shouldered connections	
	ISO 3161-1977 BS 4084-1978 Tolerance class 3A		ISO 2901-2904 DIN 103-1977 Tolerance class 7		ANSI B1.20.3-1976 Tolerance class 2G		ANSI B1.20.3-1976 Tolerance class 2G		API spec.7	
	Internal	External	Internal	External	Internal	External	Internal	External	Internal	External
CoroThread® 266		C30	C32	C31	C34	C33	C36	C35	C37	C37
T-Max U-Lock®										
CoroTurn® XS			C77							
CoroCut® XS										
CoroCut® MB					C83		C84			
T-Max® Twin-Lock										
	API Round 60° Full form		API Full form for tubes and casings							
	API spec.5B		API spec.5B							
	Internal	External	Internal	External						
CoroThread® 266	C38	C38	C39	C39						
T-Max U-Lock®										
CoroTurn® XS										
CoroCut® XS										
CoroCut® MB										
T-Max® Twin-Lock	C67	C67	C66	C66						

CoroThread® 266

External tools

	CoroThread® 266 cutting unit for thread turning	Page C41
	CoroThread® 266 QS shank tool for thread turning	Page C44
	CoroThread® 266 shank tool for thread turning	Page C46
	CoroThread® 266 head for thread turning	Page C49

Internal tools

	CoroThread® 266 cutting unit for thread turning	Page C50
	CoroThread® 266 boring bar for thread turning	Page C52
	CoroThread® 266 head for thread turning	Page C54

T-Max® U-Lock

Internal tools

	T-Max® U-Lock cutting unit for thread turning	Page C62
	T-Max® U-Lock boring bar for thread turning	Page C63
	T-Max® U-Lock head for thread turning	Page C65

T-Max® Twin-Lock

External tools

	T-Max® Twin-Lock shank tool for thread turning	Page C68
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Internal tools

	T-Max® Twin-Lock head for thread turning	Page C69
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CoroCut® XS

	CoroCut® XS	Page B9
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CoroTurn® XS

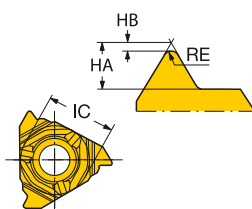
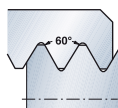
	CoroTurn® XS adaptor	Page G2
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CoroCut® MB

	CoroCut® MB adaptor	Page G2
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V-profile 60° Non-topping

NT 1

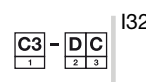
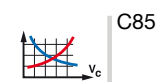
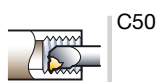


																		Dimensions, mm, inch																
							P			M			K			N			S			H	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"		
TPN	TPX	TPIN	TPIX	NT	Ordering code	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	7015													
16	3/8	1.00	2.00	24	12	1	266RG-16VM01A001M																0.13	.005	1.68	.0661	0.14	.0055	1.00	.039	1.03	.040		
						1	266RG-16VM01A001EE																0.13	.005	1.68	.0661	0.14	.0055	1.00	.039	1.03	.040		
						1	266RG-16VM01C001M																0.13	.005	1.68	.0661	0.14	.0055	1.00	.039	1.03	.040		
						1	266RG-16VM01F001E																0.13	.005	1.68	.0661	0.14	.0055	1.00	.039				
1.50	3.00	16	8			1	266RG-16VM01A002M																0.20	.008	2.64	.1039	0.20	.0079	1.50	.059	1.03	.040		
						1	266RG-16VM01A002EE																0.20	.008	2.64	.1039	0.20	.0079	1.50	.059	1.03	.040		
						1	266RG-16VM01C002M																0.20	.008	2.64	.1039	0.20	.0079	1.50	.059	1.03	.040		
						1	266RG-16VM01F002E																0.20	.008	2.64	.1039	0.20	.0079	1.50	.059				
22	1/2	3.50	6.00	7	4	1	266RG-22VM01A001M																0.48	.019	4.92	.1937	0.48	.0189	2.90	.114	0.39	.015		
						1	266RG-22VM01F001E																0.48	.019	4.92	.1937	0.48	.0189	2.90	.114	0.39	.015		

							P					M			K			N			S			Dimensions, mm, inch									
							1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	RE	RE*	HA	HA*	HB	HB*	PDX	PDX*	PDY	PDY*		
		TPN	TPX	TPIN	TPIX	NT	Ordering code																										
16	3/8	1.00	2.00	24	12	1	266LG-16VM01A001M										0.13	.005	1.68	.0661	0.14	.0055	1.00	.039	1.03	.040							
		1.50	3.00	16	8	1	266LG-16VM01A002M										0.20	.008	2.64	.1039	0.20	.0079	1.50	.059	0.99	.038							
22	1/2	3.50	6.00	7	4	1	266LG-22VM01A001M										0.48	.019	4.92	.1937	0.48	.0189	2.90	.114	0.39	.015							

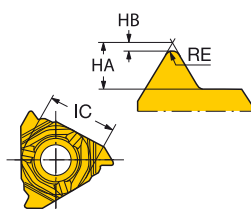
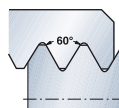


C41



V-profile 60° Non-topping

NT 1



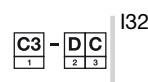
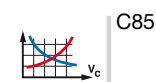
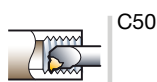
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TPN	TPX	TPI	TPIX	NT	Ordering code	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	7015																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							

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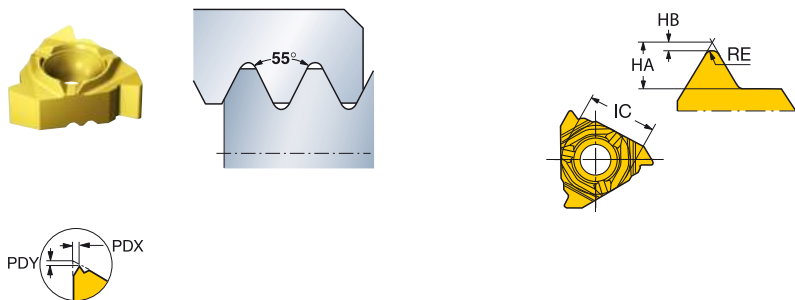


CoroThread® 266 insert for thread turning

V-profile 55° Non-topping

NT

1



External right-hand threads

						P	M	K	N	S	Dimensions, mm, inch																		
		TPIN	TPIX	NT	Ordering code	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"		
16	3/8	28	14	1	266RG-16VW01A001M		☆											0.11	.004	1.68	.0661	0.14	.0055	1.00	.039	1.03	.040		
				1	266RG-16VW01C001M		☆												0.11	.004	1.68	.0661	0.13	.0051	1.00	.039	1.03	.040	
				1	266RG-16VW01F001E															0.11	.004	1.68	.0661	0.14	.0055	1.00	.039		
	14	8	1	1	266RG-16VW01A002M		☆	☆					☆	☆			☆	☆	0.23	.009	2.79	.1098	0.26	.0102	1.50	.059	1.03	.040	
				1	266RG-16VW01C002M		☆					☆				☆				0.23	.009	2.79	.1098	0.26	.0102	1.50	.059	1.03	.040
				1	266RG-16VW01F002E			☆								☆				0.23	.009	2.79	.1098	0.26	.0102	1.50	.059		
22	1/2	7	4	1	266RG-22VW01A001M	☆	☆		☆	☆		☆	☆		☆	☆		0.48	.019	5.23	.2059	0.53	.0209	2.75	.108	0.10	.003		
				1	266RG-22VW01F001E	☆			☆				☆			☆				0.48	.019	5.23	.2059	0.53	.0209	2.75	.108	0.10	.003

External left-hand threads

						P	M	K	N	S	Dimensions, mm, inch													
	TPIN	TPIX	NT	Ordering code	P		M		K		N		S		RE	RE"	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
					1020	1125	1020	1125	1020	1125	1020	1125	1020	1125										
16	3/8	28	14	1	266LG-16VW01A001M										0.11	.004	1.68	.0661	0.13	.0051	1.00	.039	1.03	.040
		14	8	1	266LG-16VW01A002M		☆		☆		☆		☆		0.23	.009	2.79	.1098	0.26	.0102	1.50	.059	1.03	.040
22	1/2	7	4	1	266LG-22VW01A001M	☆			☆		☆		☆		0.48	.019	5.23	.2059	0.53	.0209	2.75	.108	0.10	.003

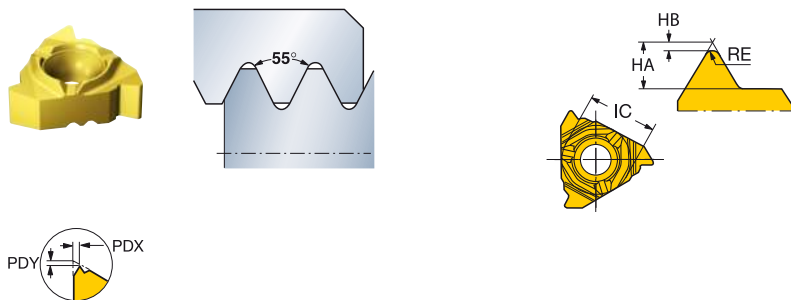
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

V-profile 55° Non-topping

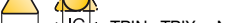
NT 1



Internal right-hand threads

						P	M	K	N	S	Dimensions, mm, inch																
						1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
	16	3/8	28	14	1	Ordering code																					
						266RL-16VW01A001M																					
						266RL-16VW01C001M																					
						266RL-16VW01F001E																					
						266RL-16VW01A002M																					
						266RL-16VW01C002M																					
	16	3/8	28	14	1	Ordering code																					
						266RL-16VW01A001M																					
						266RL-16VW01C001M																					
						266RL-16VW01F001E																					
						266RL-16VW01A002M																					
						266RL-16VW01C002M																					
	16	3/8	28	14	1	Ordering code																					
						266RL-16VW01A001M																					
						266RL-16VW01C001M																					
						266RL-16VW01F001E																					
						266RL-16VW01A002M																					
						266RL-16VW01C002M																					
	22	1/2	7	4	1	Ordering code																					
						266RL-22VW01A001M																					
						266RL-22VW01C001M																					
						266RL-22VW01F001E																					
						266RL-22VW01A002M																					
						266RL-22VW01C002M																					

Internal left-hand threads

						P	M	K	N	S	Dimensions, mm, inch																			
						1020	1125	1020	1125	1020	1125	1020	1125	1020	1125	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"					
	16	3/8	28	14	1	Ordering code																								
						266LL-16VW01A001M																								
						266LL-16VW01A002M																								
	22	1/2	7	4	1	266LL-22VW01A001M																								
						266LL-22VW01A001M																								
						266LL-22VW01A001M																								

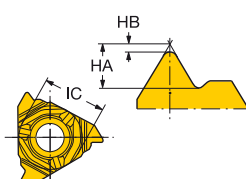
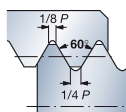
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

Metric 60° Full form

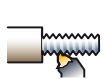
THFTSR	ISO 965-1998
TCTR	6
NT	1



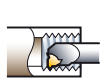
External right-hand threads

																			Dimensions, mm, inch								
				P			M			K			N			S											
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135									
		TP	NT	Ordering code														HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"		
16	3/8	0.50	1	266RG-16MM01A050M		☆	☆					☆	☆		☆	☆		0.37	.0146	0.08	.0032	0.50	.019	1.32	.051		
			0.75	1	266RG-16MM01A075M		☆	☆					☆	☆		☆	☆		0.56	.0220	0.11	.0043	0.50	.019	1.32	.051	
		0.80	1	266RG-16MM01F080E			☆					☆			☆			☆		0.60	.0236	0.11	.0043	0.60	.023	1.32	.051
			1.00	1	266RG-16MM01A100M		☆	☆				☆	☆			☆	☆		0.75	.0295	0.15	.0059	0.80	.031	1.32	.051	
		1	1	266RG-16MM01C100M				☆				☆				☆			2.88	.1134	1.80	.0709	1.20	.047	1.30	.051	
			1	266RG-16MM01F100E			☆					☆				☆			0.75	.0295	0.15	.0059	0.80	.031	1.32	.051	
		1.25	1	266RG-16MM01A125M		☆	☆					☆	☆			☆	☆		0.93	.0366	0.19	.0075	0.80	.031	1.32	.051	
			1	266RG-16MM01C125M		☆			☆				☆				☆			0.93	.0366	0.19	.0075	0.80	.031	1.32	.051
		1	1	266RG-16MM01F125E			☆			☆			☆				☆			0.93	.0366	0.19	.0075	0.80	.031	1.32	.051
			1.50	1	266RG-16MM01A150M		☆	☆					☆	☆			☆	☆		1.12	.0441	0.22	.0087	1.00	.039	1.32	.051
		1		266RG-16MM01C150M		☆			☆				☆				☆			1.12	.0441	0.22	.0087	1.00	.039	1.33	.052
		1	1	266RG-16MM01F150E			☆			☆			☆				☆			1.12	.0441	0.22	.0087	1.00	.039	1.32	.051
			1.75	1	266RG-16MM01A175M		☆	☆					☆	☆			☆	☆		1.31	.0516	0.25	.0098	1.20	.047	1.32	.051
		1		266RG-16MM01C175M		☆			☆				☆				☆			1.31	.0516	0.25	.0098	1.20	.047	1.32	.052
		1	1	266RG-16MM01F175E				☆					☆				☆			1.31	.0516	0.25	.0098	1.20	.047	1.32	.051
			2.00	1	266RG-16MM01A200M		☆	☆					☆	☆			☆	☆		1.50	.0591	0.29	.0114	1.40	.055	1.32	.051
1	266RG-16MM01C200M			☆			☆				☆				☆			1.50	.0591	0.29	.0114	1.40	.055	1.33	.052		
1	1	266RG-16MM01F200E			☆			☆			☆				☆			1.50	.0591	0.29	.0114	1.40	.055	1.32	.051		
	2.50	1	266RG-16MM01A250M		☆	☆					☆	☆			☆	☆		1.87	.0736	0.36	.0142	1.40	.055	1.32	.051		
1		266RG-16MM01C250M		☆			☆				☆				☆			1.87	.0736	0.36	.0142	1.40	.055	1.33	.052		
1	1	266RG-16MM01F250E					☆				☆				☆			1.87	.0736	0.36	.0142	1.40	.055	1.32	.051		
	3.00	1	266RG-16MM01A300M		☆	☆					☆	☆			☆	☆		2.25	.0886	0.42	.0165	1.80	.070	1.32	.051		
1		266RG-16MM01C300M		☆			☆				☆				☆			2.25	.0886	0.42	.0165	1.80	.070	1.33	.052		
1	1	266RG-16MM01F300E			☆			☆			☆				☆			2.25	.0886	0.42	.0165	1.80	.070	1.32	.051		
	22	1/2	3.50	1	266RG-22MM01A350M	☆	☆				☆	☆			☆	☆		2.62	.1032	0.49	.0193	2.50	.098	1.67	.065		
1				266RG-22MM01F350E	☆			☆			☆			☆			☆		2.62	.1032	0.49	.0193	2.50	.098	1.67	.065	
4.00	1	1	266RG-22MM01A400M	☆	☆					☆	☆			☆	☆		3.00	.1181	0.56	.0220	2.50	.098	1.67	.065			
		1	266RG-22MM01F400E	☆			☆			☆			☆			☆		3.00	.1181	0.56	.0220	2.50	.098	1.67	.065		
4.50	1	266RG-22MM01A450M	☆	☆						☆	☆			☆	☆		3.37	.1327	0.63	.0248	2.50	.098	1.67	.065			
5.00	1	266RG-22MM01A500M	☆	☆						☆	☆			☆	☆		3.76	.1480	0.71	.0280	2.50	.098	1.38	.054			
5.50	1	266RG-22MM01A550M	☆	☆						☆	☆			☆	☆		4.13	.1626	0.79	.0311	2.50	.098	1.08	.042			
6.00	1	266RG-22MM01A600M	☆	☆						☆	☆			☆	☆		4.51	.1776	0.86	.0339	2.80	.110	0.88	.034			

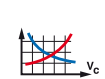
N = Neutral, R = Right hand, L = Left hand



C41



C50



C85



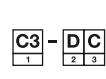
C102



15



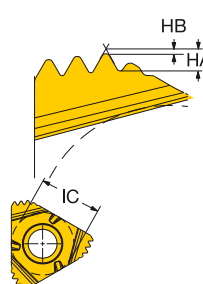
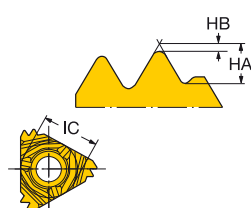
11



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Metric 60° Full form

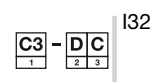
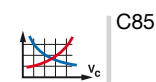
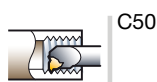
ISO 965-1998
6
3



C

		TPNT		Ordering code	P M K N S												Dimensions, mm, inch																		
					1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135									1020	1125	1135								
16	3/8	1.00	3	266RG-16MM03A100M		☆					☆				☆												0.75	.0295	0.15	.0059	2.50	.098	1.62	.063	
		1.25	2	266RG-16MM02A125M		☆					☆				☆												0.96	.0378	0.09	.0035	2.25	.088	1.41	.055	
		1.50	2	266RG-16MM02A150M		☆	☆				☆	☆			☆	☆											1.12	.0441	0.22	.0087	2.20	.086	1.42	.055	
		1.75	2	266RG-16MM02A175M		☆					☆				☆													0.93	.0366	0.19	.0075	1.90	.074	1.33	.052
		2.00	2	266RG-16MM02A200M		☆					☆				☆													1.50	.0591	0.29	.0114	2.90	.114	1.91	.075
22	1/2	2.50	2	266RG-22MM02A250E	☆						☆				☆												1.87	.0736	0.36	.0142	3.75	.147	1.96	.077	
		3.00	2	266RG-22MM02A300E	☆						☆				☆												2.25	.0886	0.42	.0165	4.40	.173	2.75	.108	

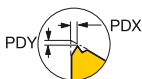
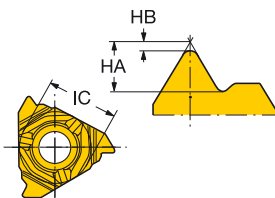
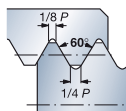
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

Metric 60° Full form

THFTSR	ISO 965-1998
TCTR	6
NT	1



External left-hand threads

[illegible]

N = Neutral, R = Right hand, L = Left hand

CoroThread® 266 insert for thread turning

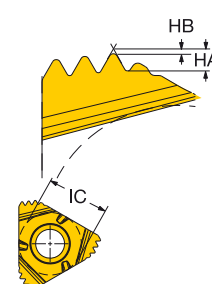
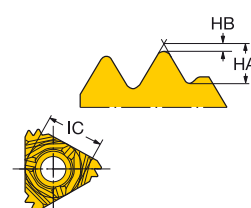
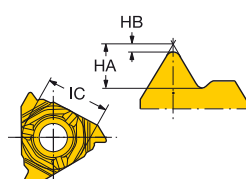
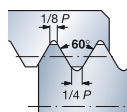
Metric 60 ° Full form

THFTSR
TCTR
NT

ISO 965-1998
6
1

ISO 965-1998
6
2

ISO 965-1998
6
3



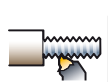
Internal right-hand threads

																Dimensions, mm, inch														
				P			M			K			N			S														
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135												
Ordering code																														
	TP	NT	16	3/8	0.50	1	266RL-16MM01A050M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"				
					0.75	1	266RL-16MM01A075M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.47	.0185	0.04	.0016	0.50	.019	1.30	.051			
		1.00	1	266RL-16MM01A100M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.64	.0252	0.06	.0024	0.80	.031	1.30	.051				
			1	266RL-16MM01C100M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.00	.0394	0.09	.0035	1.00	.039	1.30	.051				
			1	266RL-16MM01F100E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.64	.0252	0.06	.0024	0.80	.031	1.30	.051				
		1.25	1	266RL-16MM01A125M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.79	.0311	0.07	.0028	0.80	.031	1.30	.051				
			1	266RL-16MM01C125M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.13	.0445	0.11	.0043	1.20	.047	1.30	.051				
			1	266RL-16MM01F125E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.79	.0311	0.07	.0028	0.80	.031	1.30	.051				
		1.50	1	266RL-16MM01A150M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.96	.0378	0.09	.0035	1.00	.039	1.30	.051				
			1	266RL-16MM01C150M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.98	.1961	2.86	.1126	1.50	.059	1.43	.056				
			1	266RL-16MM01F150E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.96	.0378	0.09	.0035	1.00	.039	1.30	.051				
		1.75	1	266RL-16MM01A175M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.11	.0437	0.11	.0043	1.20	.047	1.30	.051				
			1	266LL-16MM01A175M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.11	.0437	0.11	.0043	1.20	.047	1.30	.051				
			1	266RL-16MM01C175M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.80	.0315	0.07	.0028	0.80	.031	1.30	.051				
			1	266RL-16MM01F175E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.11	.0437	0.11	.0043	1.20	.047	1.30	.051				
		2.00	1	266RL-16MM01A200M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.27	.0500	0.12	.0047	1.40	.055	1.30	.051				
			1	266RL-16MM01C200M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.33	.0524	0.13	.0051	1.40	.055	1.30	.051				
			1	266RL-16MM01F200E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.27	.0500	0.12	.0047	1.40	.055	1.30	.051				
		2.50	1	266RL-16MM01A250M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.59	.0626	0.16	.0063	1.40	.055	1.30	.051				
			1	266RL-16MM01C250M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.83	.0720	0.33	.0130	1.40	.055	1.30	.051				
			1	266RL-16MM01F250E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.59	.0626	0.16	.0063	1.40	.055	1.30	.051				
		3.00	1	266RL-16MM01A300M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.92	.0756	0.19	.0075	1.80	.070	1.30	.051				
			1	266RL-16MM01C300M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.89	.0350	0.08	.0032	1.00	.039	1.30	.051				
			1	266RL-16MM01F300E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.92	.0756	0.19	.0075	1.80	.070	1.30	.051				
	1/2	3.50	1	266RL-22MM01A350M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.24	.0882	0.26	.0102	2.50	.098	1.64	.064				
		4.00	1	266RL-22MM01A400M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.56	.1008	0.30	.0118	2.50	.098	1.64	.064				
		4.50	1	266RL-22MM01A450M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.89	.1138	0.33	.0130	2.50	.098	1.64	.064				
		5.00	1	266RL-22MM01A500M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.21	.1264	0.38	.0150	2.50	.098	1.35	.053			
		5.50	1	266RL-22MM01A550M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.54	.1394	0.40	.0157	2.50	.098	1.06	.041			
		6.00	1	266RL-22MM01A600M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.86	.1520	0.47	.0185	2.40	.094	0.87	.034				

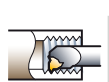
Internal right-hand threads - multipoint insert

						P			M			K			N			S			Dimensions, mm, inch							
		TP	NT	Ordering code	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	
16	3/8	1.00	3	266RL-16MM03A100M		☆			☆		☆			☆			☆		0.64	.0252	0.06	.0024	2.40	.094	1.59	.062		
		1.50	2	266RL-16MM02A150M		☆	☆		☆	☆		☆	☆		☆	☆		☆	☆	0.96	.0378	0.14	.0055	2.25	.088	1.41	.055	
		2.00	2	266RL-16MM02A200M		☆			☆			☆			☆			☆		1.27	.0500	0.12	.0047	2.85	.112	1.78	.070	
22	1/2	2.50	2	266RL-22MM02A250E	☆			☆		☆		☆		☆			☆		1.59	.0626	0.16	.0063	3.50	.137	1.93	.075		
		3.00	2	266RL-22MM02A300E	☆			☆		☆		☆			☆			☆		1.98	.0780	0.19	.0075	4.40	.173	2.70	.106	

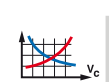
N = Neutral, R = Right hand, L = Left hand



C41



C50



C85



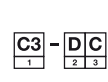
C102



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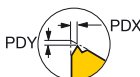
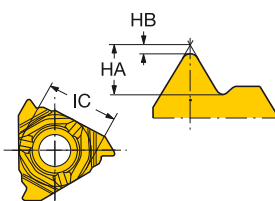
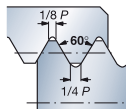


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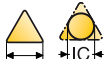
CoroThread® 266 insert for thread turning

Metric 60° Full form

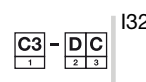
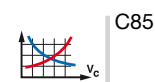
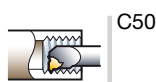
THFTSR ISO 965-1998
TCTR 6
NT 1



Internal left-hand threads

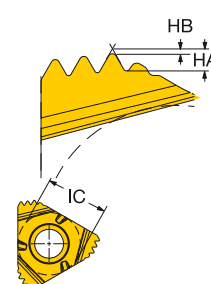
					P	M	K	N	S	Dimensions, mm, inch									
	TP	NT	Ordering code	1020	1125	1020	1125	1020	1125	1020	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	0.50	1	266LL-16MM01A050M	☆	☆	☆	☆	☆	☆	☆	0.32	.0126	0.03	.0012	0.50	.019	1.30	.051
		0.75	1	266LL-16MM01A075M	☆	☆	☆	☆	☆	☆	☆	0.47	.0185	0.04	.0016	0.50	.019	1.30	.051
		1.00	1	266LL-16MM01A100M	☆	☆	☆	☆	☆	☆	☆	0.64	.0252	0.06	.0024	0.80	.031	1.30	.051
		1.25	1	266LL-16MM01A125M	☆	☆	☆	☆	☆	☆	☆	0.79	.0311	0.07	.0028	0.80	.031	1.30	.051
		1.50	1	266LL-16MM01A150M	☆	☆	☆	☆	☆	☆	☆	0.96	.0378	0.09	.0035	1.00	.039	1.30	.051
		2.00	1	266LL-16MM01A200M	☆	☆	☆	☆	☆	☆	☆	1.27	.0500	0.12	.0047	1.40	.055	1.30	.051
22	1/2	2.50	1	266LL-16MM01A250M	☆	☆	☆	☆	☆	☆	☆	1.59	.0626	0.16	.0063	1.40	.055	1.30	.051
		3.00	1	266LL-16MM01A300M	☆	☆	☆	☆	☆	☆	☆	1.92	.0756	0.19	.0075	1.80	.070	1.30	.051
		3.50	1	266LL-22MM01A350M	☆	☆	☆	☆	☆	☆	☆	2.24	.0882	0.26	.0102	2.50	.098	1.64	.064
		4.00	1	266LL-22MM01A400M	☆	☆	☆	☆	☆	☆	☆	2.56	.1008	0.30	.0118	2.50	.098	1.64	.064
		4.50	1	266LL-22MM01A450M	☆	☆	☆	☆	☆	☆	☆	2.89	.1138	0.33	.0130	2.50	.098	1.64	.064
		5.00	1	266LL-22MM01A500M	☆	☆	☆	☆	☆	☆	☆	3.21	.1264	0.38	.0150	2.50	.098	1.35	.053
		5.50	1	266LL-22MM01A550M	☆	☆	☆	☆	☆	☆	☆	3.54	.1394	0.40	.0157	2.50	.098	1.06	.041
		6.00	1	266LL-22MM01A600M	☆	☆	☆	☆	☆	☆	☆	3.86	.1520	0.47	.0185	2.40	.094	0.87	.034

N = Neutral, R = Right hand, L = Left hand



UN 60° Full form

ISO 5864-1978
2A
3



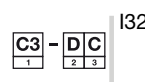
C

D

E

F

G



THREAD TURNING

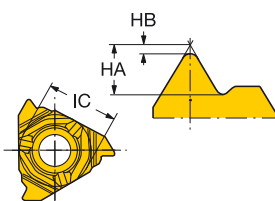
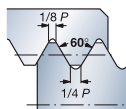
Inserts

CoroThread® 266 insert for thread turning

UN 60° Full form

THFTSR
TCTR
NT

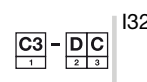
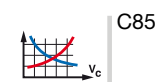
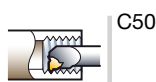
ISO 5864-1978
2A
1



External left-hand threads

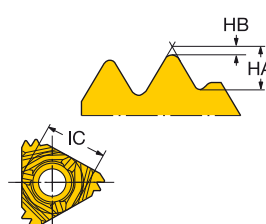
					P	M	K	N	S	Dimensions, mm, inch							
				Ordering code	1125	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
	16	3/8	32.0	1	266LG-16UN01A320M	☆	☆	☆	☆	0.59	.0232	0.10	.0039	0.50	.019	1.32	.051
			28.0	1	266LG-16UN01A280M	☆	☆	☆	☆	0.68	.0268	0.12	.0047	0.80	.031	1.32	.051
			24.0	1	266LG-16UN01A240M	☆	☆	☆	☆	0.79	.0311	0.14	.0055	0.80	.031	1.30	.051
			20.0	1	266LG-16UN01A200M	☆	☆	☆	☆	0.95	.0374	0.16	.0063	0.80	.031	1.30	.051
			18.0	1	266LG-16UN01A180M	☆	☆	☆	☆	1.05	.0413	0.18	.0071	1.00	.039	1.30	.051
			16.0	1	266LG-16UN01A160M	☆	☆	☆	☆	1.19	.0469	0.20	.0079	1.00	.039	1.30	.051
			14.0	1	266LG-16UN01A140M	☆	☆	☆	☆	1.35	.0532	0.23	.0091	1.20	.047	1.30	.051
			13.0	1	266LG-16UN01A130M	☆	☆	☆	☆	1.46	.0575	0.25	.0098	1.40	.055	1.32	.051
			12.0	1	266LG-16UN01A120M	☆	☆	☆	☆	1.58	.0622	0.28	.0110	1.40	.055	1.30	.051
			11.0	1	266LG-16UN01A110M	☆	☆	☆	☆	1.72	.0677	0.30	.0118	1.40	.055	1.30	.051
			10.0	1	266LG-16UN01A100M	☆	☆	☆	☆	1.90	.0748	0.33	.0130	1.40	.055	1.30	.051
			9.0	1	266LG-16UN01A090M	☆	☆	☆	☆	2.11	.0831	0.37	.0146	1.80	.070	1.32	.051
			8.0	1	266LG-16UN01A080M	☆	☆	☆	☆	2.38	.0937	0.41	.0161	1.80	.070	1.30	.051

N = Neutral, R = Right hand, L = Left hand



UN 60° Full form

ISO 5864-1978
2B
2



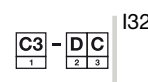
C

D

G

H

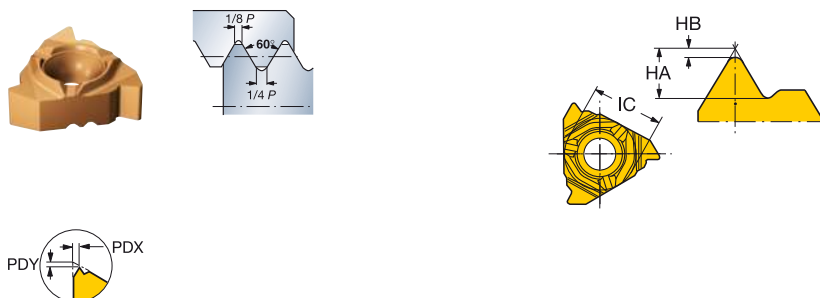
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

UN 60° Full form

THFTSR ISO 5864-1978
TCTR 2B
NT 1



Internal left-hand threads

					P	M	K	N	S	Dimensions, mm, inch							
					1125	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
D		TPI	NT	Ordering code	☆	☆	☆	☆	☆	0.80	.0315	0.07	.0028	0.80	.031	1.30	.051
				16 3/8 20.0 1 266LL-16UN01A200M	☆	☆	☆	☆	☆	0.89	.0350	0.08	.0032	1.00	.039	1.30	.051
				18.0 1 266LL-16UN01A180M	☆	☆	☆	☆	☆	1.00	.0394	0.09	.0035	1.00	.039	1.30	.051
				16.0 1 266LL-16UN01A160M	☆	☆	☆	☆	☆	1.13	.0445	0.11	.0043	1.20	.047	1.30	.051
				14.0 1 266LL-16UN01A140M	☆	☆	☆	☆	☆	1.33	.0524	0.13	.0051	1.40	.055	1.30	.051
E		TPI	NT	Ordering code	☆	☆	☆	☆	☆	1.45	.0571	0.14	.0055	1.40	.055	1.30	.051
				12.0 1 266LL-16UN01A120M	☆	☆	☆	☆	☆	1.59	.0626	0.16	.0063	1.40	.055	1.30	.051
				11.0 1 266LL-16UN01A110M	☆	☆	☆	☆	☆	1.77	.0697	0.18	.0071	1.80	.070	1.30	.051
				10.0 1 266LL-16UN01A100M	☆	☆	☆	☆	☆	2.00	.0787	0.20	.0079	1.80	.070	1.30	.051
				9.0 1 266LL-16UN01A090M	☆	☆	☆	☆	☆								
				8.0 1 266LL-16UN01A080M	☆	☆	☆	☆	☆								

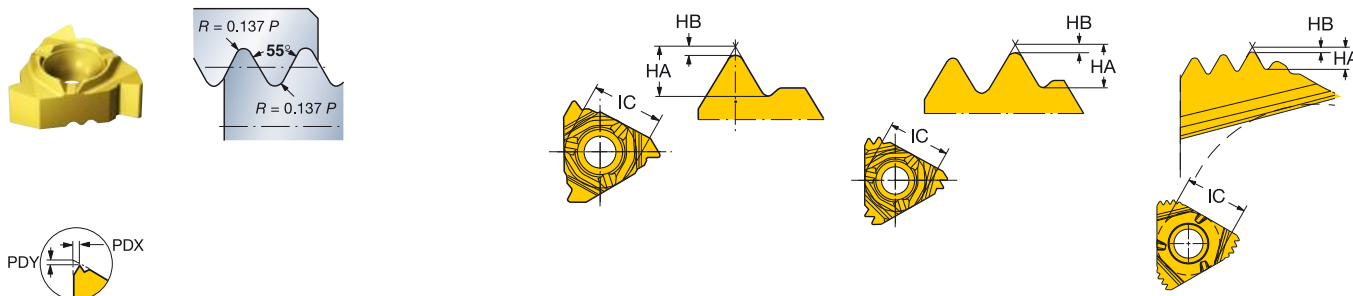
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

THFTSR	ISO 228-1982	ISO 228-1982	ISO 228-1982
THFTSR	BS-2779-1973	BS-2779-1973	BS-2779-1973
THFTSR	BS-84-1957	BS-84-1957	BS-84-1957
TCTR	A	A	A
NT	1	2	3



External right-hand threads

																			Dimensions, mm, inch							
				P			M			K			N			S										
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
	TPI	NT	Ordering code																							
16	3/8	28.0	1	266RG-16WH01A280M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.72	.0283	0.13	.0051	0.80	.031	1.32	.051	
		26.0	1	266RG-16WH01A260M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.00	.0394	0.09	.0035	2.30	.090	1.51	.059	
		20.0	1	266RG-16WH01A200M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.01	.0398	0.18	.0071	0.80	.031	1.32	.051	
		19.0	1	266RG-16WH01A190M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.06	.0417	0.19	.0075	0.80	.031	1.32	.051	
			1	266RG-16WH01C190M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.06	.0417	0.19	.0075	0.80	.031	1.33	.052	
			1	266RG-16WH01F190E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.06	.0417	0.19	.0075	0.80	.031	1.32	.051	
		18.0	1	266RG-16WH01A180M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.12	.0441	0.20	.0079	1.00	.039	1.32	.051	
		16.0	1	266RG-16WH01A160M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.26	.0496	0.23	.0091	1.00	.039	1.32	.051	
		14.0	1	266RG-16WH01A140M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.44	.0567	0.26	.0102	1.20	.047	1.32	.051	
			1	266RG-16WH01C140M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.44	.0567	0.26	.0102	1.20	.047	1.33	.052	
			1	266RG-16WH01F140E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.44	.0567	0.26	.0102	1.20	.047	1.32	.051	
		12.0	1	266RG-16WH01A120M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.68	.0661	0.31	.0122	1.40	.055	1.32	.051	
		11.0	1	266RG-16WH01A110M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.83	.0720	0.34	.0134	1.40	.055	1.32	.051	
			1	266RG-16WH01C110M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.83	.0720	0.34	.0134	1.40	.055	1.33	.052	
			1	266RG-16WH01F110E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.83	.0720	0.34	.0134	1.40	.055	1.32	.051	
		10.0	1	266RG-16WH01A100M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.02	.0795	0.37	.0146	1.40	.055	1.32	.051	
		9.0	1	266RG-16WH01A090M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.24	.0882	0.42	.0165	1.80	.070	1.32	.051	
		8.0	1	266RG-16WH01A080M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.52	.0992	0.47	.0185	1.80	.070	1.32	.051	
22	1/2	7.0	1	266RG-22WH01A070M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.88	.1134	0.54	.0213	2.50	.098	1.67	.065	
		6.0	1	266RG-22WH01A060M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.37	.1327	0.64	.0252	2.50	.098	1.67	.065	
		5.0	1	266RG-22WH01A050M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.04	.1591	0.77	.0303	2.50	.098	1.38	.054	
		4.5	1	266RG-22WH01A045M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.49	.1768	0.85	.0335	2.65	.104	0.98	.038	
		4.0	1	266RG-22WH01A040M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	5.06	.1992	0.96	.0378	2.75	.108	0.59	.023	

External right-hand threads - multipoint insert

					P	M	K	N	S	Dimensions, mm, inch										
	IC	TPI	NT	Ordering code	1020	1125	1020	1125	1020	1125	1020	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	19.0	3	266RG-16WH03A190M		☆		☆		☆		☆	1.06	.0417	0.19	.0075	3.30	.129	2.01	.079
		14.0	2	266RG-16WH02A140M		☆		☆		☆		☆	1.44	.0567	0.26	.0102	2.70	.106	1.73	.068
22	1/2	11.0	2	266RG-22WH02A110E	☆		☆		☆		☆		1.83	.0720	0.34	.0134	3.40	.133	1.87	.073

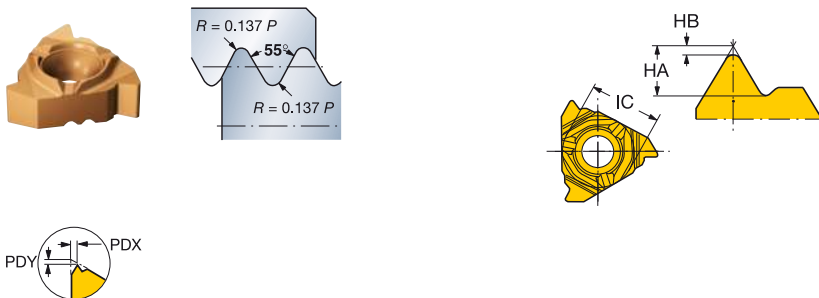
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

THFTSR ISO 228-1982
 THFTSR BS-2779-1973
 THFTSR BS-84-1957
 NT 1



External left-hand threads

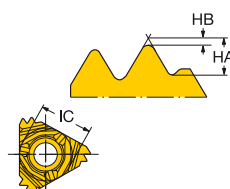
				P	M	K	N	S	Dimensions, mm, inch							
		TPI	NT	Ordering code	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	19.0	1	266LG-16WH01A190M	☆	☆	☆	☆	1.06	.0417	0.19	.0075	0.80	.031	1.32	.051
		14.0	1	266LG-16WH01A140M	☆	☆	☆	☆	1.44	.0567	0.26	.0102	1.20	.047	1.32	.051
		11.0	1	266LG-16WH01A110M	☆	☆	☆	☆	1.83	.0720	0.34	.0134	1.40	.055	1.32	.051

N = Neutral, R = Right hand, L = Left hand



Whitworth 55° (BSW, BSF, BSP) Full form

ISO 228-1982
BS-2779-1973
BS-84-1957
A
2



B

C

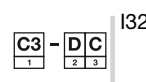
D

E

F

G

H



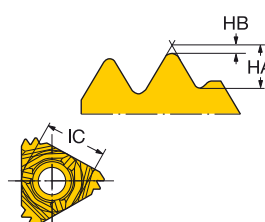
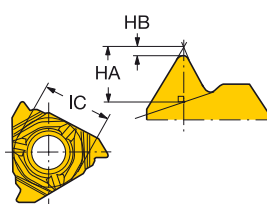
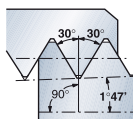
CoroThread® 266 insert for thread turning

NPT 60° NPSC, NPTR, LINE PIPE Full form

THFTSR
NT

ANSI B.1.20.1-1983
1

ANSI B.1.20.1-1983
2



External right-hand threads

				P	M	K	N	S	Dimensions, mm, inch									
				1125	1135	1125	1135	1125	1135	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG
	16	3/8	27.0	1	☆	☆	☆	☆	☆	0.76	.0299	0.05	.0020	0.80	.031	1.03	.040	0.06
			18.0	1	☆	☆	☆	☆	☆	1.14	.0449	0.08	.0032	1.00	.039	1.03	.040	0.06
	14.0	1	266RG-16NT01A140M	☆	☆	☆	☆	☆	☆	1.46	.0575	0.09	.0035	1.20	.047	1.03	.040	0.06
			266RG-16NT01C140M	☆	☆	☆	☆	☆	☆	1.46	.0575	0.09	.0035	1.20	.047	1.03	.040	0.06
	11.5	1	266RG-16NT01A115M	☆	☆	☆	☆	☆	☆	1.79	.0705	0.11	.0043	1.40	.055	1.03	.040	0.06
			266RG-16NT01C115M	☆	☆	☆	☆	☆	☆	1.79	.0705	0.11	.0043	1.40	.055	1.03	.040	0.06
	8.0	1	266RG-16NT01A080M	☆	☆	☆	☆	☆	☆	2.57	.1012	0.14	.0055	1.60	.062	1.03	.040	0.06
			266RG-16NT01C080M	☆	☆	☆	☆	☆	☆	1.11	.0437	0.19	.0075	1.00	.039	1.30	.051	0.06

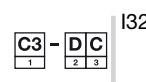
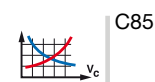
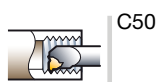
External right-hand threads - multipoint insert

									Dimensions, mm, inch													
				P	M	K	N	S														
				1020	1020	1020	1020	1020														
				☆	☆	☆	☆	☆	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG					
				22	1/2	11.5	2	266RG-22NT02A115E	☆	☆	☆	☆	☆	1.79	.0705	0.11	.0043	3.40	.133	1.67	.065	0.06

External left-hand threads

					P	M	K	N	S	Dimensions, mm, inch									
	TPI	NT	Ordering code	1125	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG		
				1125	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG		
	16	3/8	27.0	1	266LG-16NT01A270M	☆	☆	☆	☆	☆	0.76	.0299	0.05	.0020	0.80	.031	1.03	.040	0.06
			18.0	1	266LG-16NT01A180M	☆	☆	☆	☆	☆	1.14	.0449	0.08	.0032	1.00	.039	1.03	.040	0.06
	14.0	1	266LG-16NT01A140M	☆	☆	☆	☆	☆	1.46	.0575	0.09	.0035	1.20	.047	1.03	.040	0.06		
			266LG-16NT01A115M	☆	☆	☆	☆	☆	1.79	.0705	0.11	.0043	1.40	.055	1.03	.040	0.06		
	8.0	1	266LG-16NT01A080M	☆	☆	☆	☆	☆	2.57	.1012	0.14	.0055	1.60	.062	1.03	.040	0.06		

N = Neutral, R = Right hand, L = Left hand



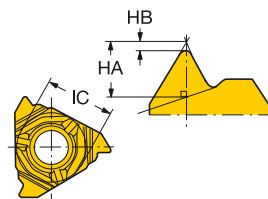
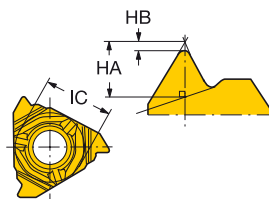
CoroThread® 266 insert for thread turning

NPT 60° NPSC, NPTR, LINE PIPE Full form

THFTSR
NT

ANSI B.1.20.1-1983
1

ANSI B.1.20.1-1983
2



Internal right-hand threads

				P	M	K	N	S	Dimensions, mm, inch									
HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG										
16	3/8	14.0	1	266RL-16NT01A140M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
				266RL-16NT01C140M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
				266RL-16NT01F140E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
				266RL-16NT01A115M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
				266RL-16NT01C115M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
				266RL-16NT01F115E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
				266RL-16NT01A080M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
				266RL-16NT01C080M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆

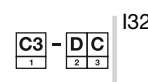
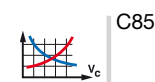
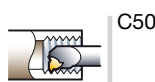
Internal right-hand threads - multipoint insert

				P	M	K	N	S	Dimensions, mm, inch									
HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG										
22	1/2	11.5	2	266RL-22NT02A115E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
					☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆

Internal left-hand threads

				P	M	K	N	S	Dimensions, mm, inch									
HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG										
16	3/8	14.0	1	266LL-16NT01A140M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
				11.5	1	266LL-16NT01A115M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
				8.0	1	266LL-16NT01A080M	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆

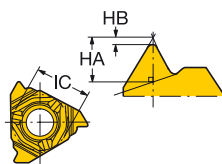
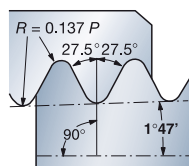
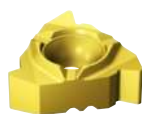
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

BSPT 55° Full form

THFTSR	ISO 7/1
THFTSR	BS21:1985
NT	1



External right-hand threads

		TPI NT		Ordering code	P		M		K		N		S		Dimensions, mm, inch								
					1125	1135	1125	1135	1125	1135	1125	1135	1125	1135									
16	3/8	28.0	1	266RG-16PT01A280E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG
		19.0	1	266RG-16PT01A190E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.04	.0409	0.19	.0075	0.80	.031	1.32	.051	0.06
		14.0	1	266RG-16PT01A140E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.41	.0555	0.26	.0102	1.20	.047	1.32	.051	0.06
		11.0	1	266RG-16PT01A110E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.80	.0709	0.34	.0134	1.40	.055	1.32	.051	0.06
		8.0	1	266RG-16PT01A080E	☆	☆		☆		☆		☆		☆	2.47	.0972	0.47	.0185	1.80	.070	1.32	.051	0.06

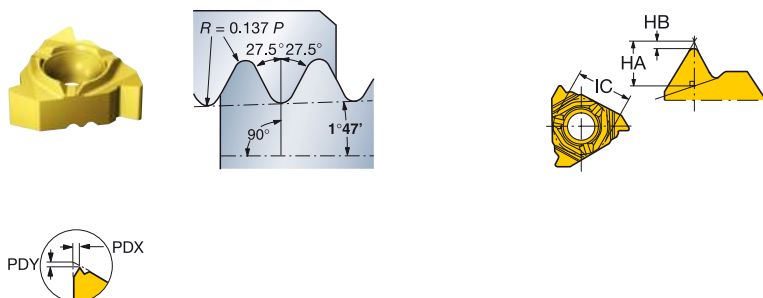
External left-hand threads

				P	M	K	N	S	Dimensions, mm, inch																		
				1125	1125	1125	1125	1125																			
		TPI	NT	Ordering code					HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG										
16	3/8	19.0	1	266LG-16PT01A190E					☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.04	.0409	0.19	.0075	0.80	.031	1.32	.051	0.06
		14.0	1	266LG-16PT01A140E					☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.41	.0555	0.26	.0102	1.20	.047	1.32	.051	0.06
		11.0	1	266LG-16PT01A110E					☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.80	.0709	0.34	.0134	1.40	.055	1.32	.051	0.06

N = Neutral, R = Right hand, L = Left hand

BSPT 55° Full form

THFTSR	ISO 7/1
THFTSR	BS21:1985
NT	1



Internal right-hand threads

					PMSN										Dimensions, mm, inch								
		TPI	NT	Ordering code	1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG
16	3/8	28.0	1	266RL-16PT01A280E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.71	.0280	0.12	.0047	0.80	.031	1.30	.051	0.06
		19.0	1	266RL-16PT01A190E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.03	.0406	0.18	.0071	0.80	.031	1.30	.051	0.06
		14.0	1	266RL-16PT01A140E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.40	.0551	0.25	.0098	1.20	.047	1.30	.051	0.06
		11.0	1	266RL-16PT01A110E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.80	.0709	0.33	.0130	1.40	.055	1.30	.051	0.06
		8.0	1	266RL-16PT01A080E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.48	.0976	0.47	.0185	1.80	.070	1.30	.051	0.06

Internal left-hand threads

					P	M	K	N	S	Dimensions, mm, inch								
					1125	1125	1125	1125	1125									
		TPI	NT	Ordering code						HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG
16	3/8	19.0	1	266LL-16PT01A190E	☆	☆	☆	☆	☆	1.03	.0406	0.18	.0071	0.80	.031	1.30	.051	0.06
		14.0	1	266LL-16PT01A140E	☆	☆	☆	☆	☆	1.40	.0551	0.25	.0098	1.20	.047	1.30	.051	0.06
		11.0	1	266LL-16PT01A110E	☆	☆	☆	☆	☆	1.80	.0709	0.33	.0130	1.40	.055	1.30	.051	0.06

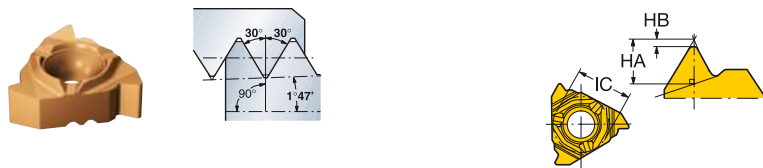
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

NPTF 60° Full form

THFTSR ANSI B1.20.3-1976
TCTR 2
NT 1



External right-hand threads

		P M K N S					Dimensions, mm, inch									
IC	TPI	NT	Ordering code	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG
16	3/8	27.0	1 266RG-16NF01A270E	☆	☆	☆	☆	0.75	.0295	0.11	.0043	0.80	.031	1.03	.040	0.06
		18.0	1 266RG-16NF01A180E	☆	☆	☆	☆	1.14	.0449	0.13	.0051	1.00	.039	1.03	.040	0.06
		14.0	1 266RG-16NF01A140E	☆	☆	☆	☆	1.49	.0587	0.13	.0051	1.20	.047	1.03	.040	0.06
		11.5	1 266RG-16NF01A115E	☆	☆	☆	☆	1.81	.0713	0.17	.0067	1.40	.055	1.03	.040	0.06
		8.0	1 266RG-16NF01A080E	☆	☆	☆	☆	2.60	.1024	0.21	.0083	1.60	.062	1.03	.040	0.06

Internal right-hand threads

		P M K N S					Dimensions, mm, inch									
IC	TPI	NT	Ordering code	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG
16	3/8	14.0	1 266RL-16NF01A140E	☆	☆	☆	☆	1.49	.0587	0.13	.0051	1.20	.047	1.01	.039	0.06
		11.5	1 266RL-16NF01A115E	☆	☆	☆	☆	1.81	.0713	0.17	.0067	1.40	.055	1.01	.039	0.06
		8.0	1 266RL-16NF01A080E	☆	☆	☆	☆	2.60	.1024	0.21	.0083	1.60	.062	1.01	.039	0.06

N = Neutral, R = Right hand, L = Left hand



Round 30° Full form

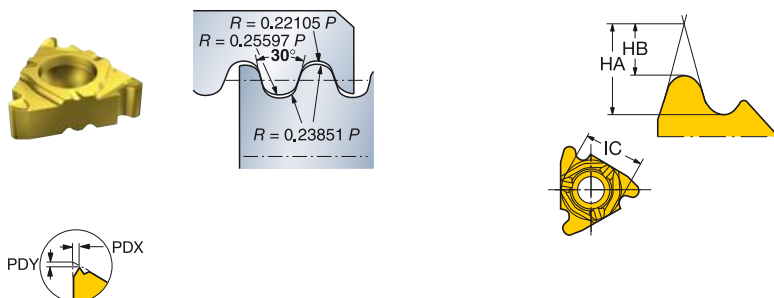
				P		M		K		N		S		Dimensions, mm, inch										
					1020	1125	1020	1125	1020	1125	1020	1125	1020	1125	1135	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	
16	3/8	10.0	1	266RG-16RN01A100M	☆											2.97	.1169	1.72	.0677	0.85	.033	1.33	.052	
			1	266RG-16RN01F100E		☆		☆	☆		☆		☆		☆		1.79	.0705	0.11	.0043	1.40	.055	1.01	.039
		8.0	1	266RG-16RN01A080M		☆		☆		☆		☆		☆		3.72	.1465	2.14	.0843	1.05	.041	1.37	.054	
			1	266RG-16RN01F080E		☆		☆		☆		☆		☆		0.96	.0378	0.09	.0035	1.00	.039	1.30	.051	
22	1/2	6.0	1	266RG-16RN01A060M		☆		☆		☆		☆		☆		4.98	.1961	2.86	.1126	1.50	.059	1.43	.056	
			1	266RG-16RN01F060E		☆		☆		☆		☆		☆		2.97	.1169	1.72	.0677	0.85	.033	1.33	.052	
		4.0	1	266RG-22RN01A040M	☆		☆		☆		☆		☆		☆		7.45	.2933	4.30	.1693	2.60	.102	1.37	.054
			1	266RG-22RN01F040E	☆		☆		☆		☆		☆		☆		7.45	.2933	4.30	.1693	2.60	.102	1.37	.054

					P	M	K	N	S	Dimensions, mm, inch												
		TPI	NT	Ordering code	1020	1125	1020	1125	1020	1125	1020	1125	1020	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	10.0	1	266LG-16RN01A100M		☆		☆		☆		☆		☆	2.97	.1169	1.72	.0677	0.85	.033	1.32	.051
		8.0	1	266LG-16RN01A080M		☆		☆		☆		☆		☆	3.72	.1465	2.14	.0843	1.05	.041	1.32	.051
		6.0	1	266LG-16RN01A060M		☆		☆		☆		☆		☆	4.98	.1961	2.86	.1126	1.50	.059	1.43	.056
22	1/2	4.0	1	266LG-22RN01A040M	☆		☆		☆		☆		☆		7.45	.2933	4.30	.1693	2.60	.102	1.37	.054

CoroThread® 266 insert for thread turning

Round 30° Full form

THFTSR DIN 405
TCTR 7-6
NT 1



Internal right-hand threads

					P		M		K		N		S		Dimensions, mm, inch									
		TPI	NT	Ordering code	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	10.0	1	266RL-16RN01A100M		☆			☆			☆			☆		2.87	.1130	1.58	.0622	1.85	.072	1.30	.051
			1	266RL-16RN01F100E			☆		☆		☆		☆		☆		3.90	.1535	2.00	.0787	1.50	.059	1.20	.047
	8.0	1	1	266RL-16RN01A080M		☆			☆			☆			☆		3.59	.1413	2.00	.0787	1.05	.041	1.30	.051
			1	266RL-16RN01F080E			☆		☆		☆		☆		☆		2.12	.0835	1.40	.0551	1.00	.039	1.32	.051
	6.0	1	1	266RL-16RN01A060M		☆			☆			☆			☆		4.79	.1886	2.66	.1047	1.35	.053	1.45	.057
			1	266RL-16RN01F060E			☆		☆		☆		☆		☆		2.64	.1039	1.43	.0563	1.20	.047	1.32	.051
22	1/2	4.0	1	266RL-22RN01A040M	☆			☆			☆			☆		☆	7.17	.2823	3.98	.1567	2.60	.102	1.35	.053
			1	266RL-22RN01F040E	☆			☆		☆		☆		☆		☆	7.17	.2823	3.98	.1567	2.60	.102	1.35	.053

Internal left-hand threads

					P	M	K	N	S	Dimensions, mm, inch										
					1020	1125	1020	1125	1020	1125	1020	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
	TPI	NT	Ordering code																	
16	3/8	10.0	1	266LL-16RN01A100M		☆		☆		☆		☆	2.87	.1130	1.58	.0622	0.85	.033	1.30	.051
		8.0	1	266LL-16RN01A080M		☆		☆		☆		☆	3.59	.1413	2.00	.0787	1.05	.041	1.30	.051
		6.0	1	266LL-16RN01A060M		☆		☆		☆		☆	4.79	.1886	2.66	.1047	1.35	.053	1.45	.057
22	1/2	4.0	1	266LL-22RN01A040M	☆		☆		☆		☆		7.17	.2823	3.98	.1567	2.60	.102	1.35	.053

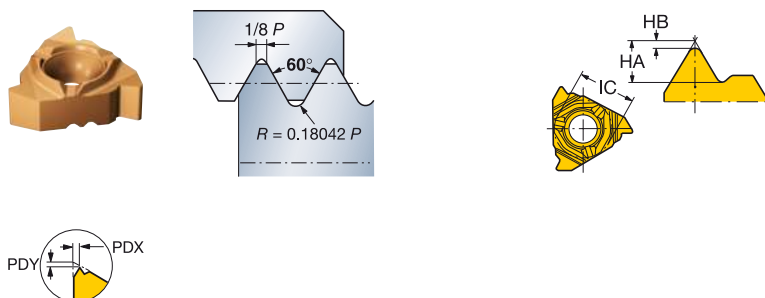
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

MJ 60° Full form

THFTSR ISO 5855-1983
TCTR 4-6
NT 1



External right-hand threads

				Dimensions, mm, inch											
					P	M	K	N	S						
16	3/8	1.50	1	Ordering code	1125	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"
		2.00	1	266RG-16MJ01A150E	☆	☆	☆	☆	☆	1.12	.0441	0.25	.0098	1.00	.039
				266RG-16MJ01A200E	☆	☆	☆	☆	☆	1.50	.0591	0.34	.0134	1.40	.055

External left-hand threads

				Dimensions, mm, inch											
					P	M	K	N	S						
16	3/8	1.50	1	Ordering code	1125	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"
		2.00	1	266LG-16MJ01A150E	☆	☆	☆	☆	☆	1.12	.0441	0.25	.0098	1.00	.039
				266LG-16MJ01A200E	☆	☆	☆	☆	☆	1.50	.0591	0.34	.0134	1.40	.055

N = Neutral, R = Right hand, L = Left hand

Internal threads

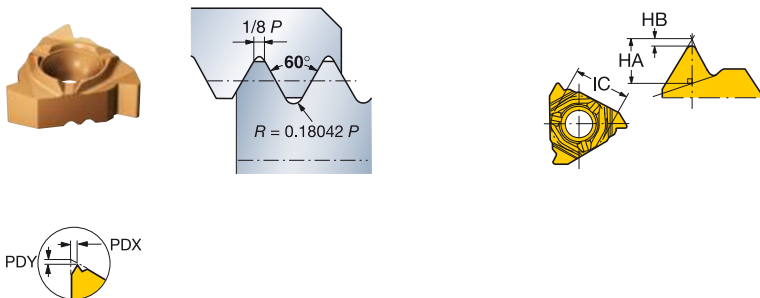
Note: To turn an internal MJ thread, use a CoroTurn 107 boring bar and insert to turn correct internal diameter and then produce the thread with a corresponding ISO metric 60° (MM) insert.



CoroThread® 266 insert for thread turning

UNJ 60° Full form

THFTSR ISO 3161-1977
THFTSR BS 4084-1977
TCTR 3A
NT 1



External right-hand threads

				P	M	K	N	S	Dimensions, mm, inch							
		TPI	NT	Ordering code	1125	1125	1125	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	32.0	1	266RG-16NJ01A320E	☆	☆	☆	☆	0.59	.0232	0.13	.0051	0.50	.019	1.32	.051
		28.0	1	266RG-16NJ01A280E	☆	☆	☆	☆	0.67	.0264	0.15	.0059	0.80	.031	1.32	.051
		24.0	1	266RG-16NJ01A240E	☆	☆	☆	☆	0.79	.0311	0.18	.0071	0.80	.031	1.32	.051
		20.0	1	266RG-16NJ01A200E	☆	☆	☆	☆	0.94	.0370	0.21	.0083	1.00	.039	1.32	.051
		18.0	1	266RG-16NJ01A180E	☆	☆	☆	☆	1.05	.0413	0.23	.0091	1.00	.039	1.32	.051
		16.0	1	266RG-16NJ01A160E	☆	☆	☆	☆	1.18	.0465	0.26	.0102	1.00	.039	1.32	.051
		14.0	1	266RG-16NJ01A140E	☆	☆	☆	☆	1.35	.0532	0.30	.0118	1.20	.047	1.32	.051
		12.0	1	266RG-16NJ01A120E	☆	☆	☆	☆	1.58	.0622	0.36	.0142	1.40	.055	1.32	.051
		10.0	1	266RG-16NJ01A100E	☆	☆	☆	☆	1.89	.0744	0.42	.0165	1.40	.055	1.32	.051
		8.0	1	266RG-16NJ01A080E	☆	☆	☆	☆	2.38	.0937	0.53	.0209	1.80	.070	1.32	.051

N = Neutral, R = Right hand, L = Left hand

Internal threads

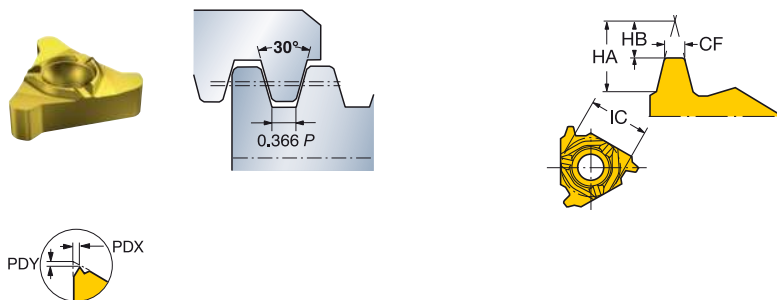
Note: To turn an internal UNJ thread use a CoroTurn 107 boring bar and insert to turn correct internal diameter and then produce the thread with a corresponding UN 60° insert.



CoroThread® 266 insert for thread turning

ISO Trapezoidal 30° Chamfered crest form

THFTSR ISO 2901-2904
THFTSR DIN 103-1977
TCTR 7
NT 1



External right-hand threads

					P	M	K	N	S	Dimensions, mm, inch											
		TP	NT	Ordering code	1020	1135	1020	1135	1020	1135	1020	1135	CF	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	1.50	1	266RG-16TR01F150E	☆	☆	☆	☆	☆	☆	☆	☆	0.4	1.85	.0728	0.88	.0346	1.00	.039	1.32	.051
		2.00	1	266RG-16TR01F200E	☆	☆	☆	☆	☆	☆	☆	☆	0.6	2.44	.0961	1.13	.0445	1.10	.043	1.32	.051
		3.00	1	266RG-16TR01F300E	☆	☆	☆	☆	☆	☆	☆	☆	0.9	3.63	.1429	1.82	.0717	1.60	.062	1.23	.048
22	1/2	4.00	1	266RG-22TR01F400E	☆	☆	☆	☆	☆	☆	☆	☆	1.3	4.82	.1898	2.50	.0984	1.90	.074	1.37	.054
		5.00	1	266RG-22TR01F500E	☆	☆	☆	☆	☆	☆	☆	1.7	6.01	.2366	3.18	.1252	2.10	.082	1.37	.054	
		6.00	1	266RG-22TR01F600E	☆	☆	☆	☆	☆	☆	☆	1.9	7.20	.2835	3.62	.1425	2.40	.094	0.78	.030	
		7.00	1	266RG-22TR01F700E	☆	☆	☆	☆	☆	☆	☆	2.3	8.38	.3299	4.31	.1697	2.40	.094	0.78	.030	
27	5/8	8.00	1	266RG-27TR01F800E	☆	☆	☆	☆	☆	☆	☆	2.6	9.57	.3768	5.00	.1969	3.30	.129	0.54	.021	

External left-hand threads

					P	M	K	N	S	Dimensions, mm, inch													
		TP	NT	Ordering code	1020	1135	1020	1135	1020	1135	1020	1135	1020	1135	CF	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	1.50	1	266LG-16TR01F150E		☆		☆		☆		☆		☆	0.4	2.12	.0835	1.40	.0551	1.00	.039	1.32	.051
		2.00	1	266LG-16TR01F200E		☆		☆		☆		☆		☆	0.6	3.59	.1413	1.76	.0693	1.60	.062	1.20	.047
		3.00	1	266LG-16TR01F300E		☆		☆		☆		☆		☆	0.9	2.26	.0890	1.21	.0476	1.10	.043	1.32	.051
22	1/2	4.00	1	266LG-22TR01F400E	☆		☆		☆		☆		☆		1.3	4.82	.1898	2.50	.0984	1.90	.074	1.37	.054
		5.00	1	266LG-22TR01F500E	☆		☆		☆		☆		☆		1.7	6.01	.2366	3.18	.1252	2.10	.082	1.37	.054
		6.00	1	266LG-22TR01F600E	☆		☆		☆		☆		☆		1.9	7.20	.2835	3.62	.1425	2.40	.094	0.78	.030
		7.00	1	266LG-22TR01F700E	☆		☆		☆		☆		☆		2.3	8.38	.3299	4.31	.1697	2.40	.094	0.78	.030

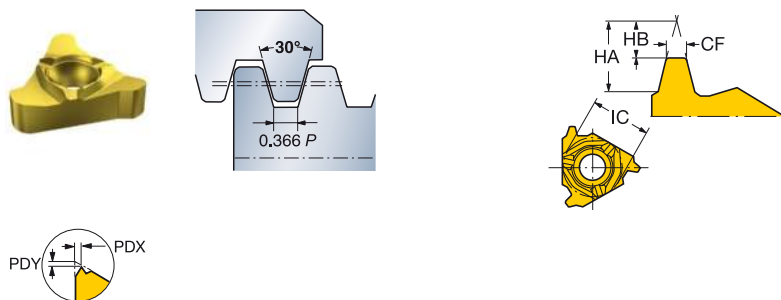
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

ISO Trapezoidal 30° Chamfered crest form

THFTSR ISO 2901-2904
THFTSR DIN 103-1977
TCTR 7
NT 1



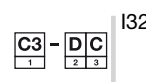
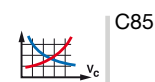
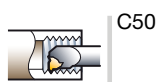
Internal right-hand threads

					P	M	K	N	S	Dimensions, mm, inch												
	TP	NT	Ordering code	1020	1135	1020	1135	1020	1135	1020	1135	1020	1135	CF	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
	16	3/8	2.00	1	266RL-16TR01F200E	☆	☆	☆	☆	☆	☆	☆	☆	0.5	2.41	.0949	1.08	.0425	1.10	.043	1.30	.051
			3.00	1	266RL-16TR01F300E	☆	☆	☆	☆	☆	☆	☆	☆	0.9	3.59	.1413	1.76	.0693	1.60	.062	1.20	.047
	22	1/2	4.00	1	266RL-22TR01F400E	☆	☆	☆	☆	☆	☆	☆	☆	1.3	4.77	.1878	2.45	.0965	1.90	.074	1.35	.053
			5.00	1	266RL-22TR01F500E	☆	☆	☆	☆	☆	☆	☆	☆	1.6	5.96	.2346	3.13	.1232	2.10	.082	1.35	.053
			6.00	1	266RL-22TR01F600E	☆	☆	☆	☆	☆	☆	☆	☆	1.9	7.14	.2811	3.56	.1402	2.40	.094	0.77	.030
			7.00	1	266RL-22TR01F700E	☆	☆	☆	☆	☆	☆	☆	☆	2.2	8.32	.3276	4.25	.1673	2.40	.094	0.96	.037
	27	5/8	8.00	1	266RL-27TR01F800E	☆	☆	☆	☆	☆	☆	☆	☆	2.6	9.49	.3736	4.93	.1941	3.30	.129	0.54	.021

Internal left-hand threads

		TP NT		Ordering code	P		M		K		N		S		Dimensions, mm, inch									
					1020	1135	1020	1135	1020	1135	1020	1135	1020	1135										
	3/8	2.00	1	266LL-16TR01F200E		☆			☆			☆		☆		CF	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
		3.00	1	266LL-16TR01F300E		☆		☆		☆		☆		☆		0.5	2.62	.1032	1.37	.0539	1.20	.047	1.30	.051
		5.00	1	266LL-16TR01F500E		☆		☆		☆		☆		☆		0.9	4.79	.1886	2.66	.1047	1.35	.053	1.45	.057
		6.00	1	266LL-16TR01F600E		☆		☆		☆		☆		☆		1.3	4.77	.1878	2.45	.0965	1.90	.074	1.35	.053
		7.00	1	266LL-16TR01F700E		☆		☆		☆		☆		☆		1.6	5.96	.2346	3.13	.1232	2.10	.082	1.35	.053
	1/2	4.00	1	266LL-22TR01F400E	☆		☆		☆		☆		☆		1.9	7.14	.2811	3.56	.1402	2.40	.094	0.77	.030	
		5.00	1	266LL-22TR01F500E	☆		☆		☆		☆		☆		2.2	8.32	.3276	4.25	.1673	2.40	.094	0.96	.037	
		6.00	1	266LL-22TR01F600E	☆		☆		☆		☆		☆											
		7.00	1	266LL-22TR01F700E	☆		☆		☆		☆		☆											

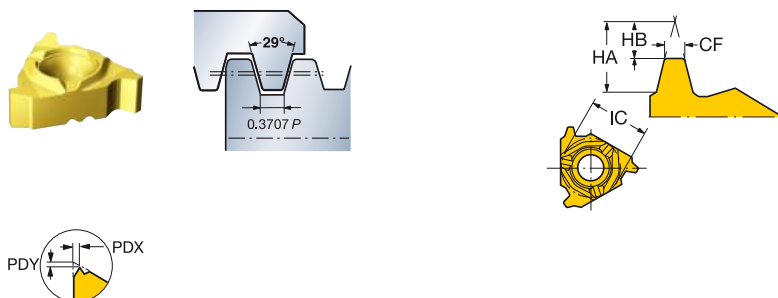
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

ACME 29° Chamfered crest form

THFTSR ANSI B1.5-1988
TCTR 2G
NT 1



External right-hand threads

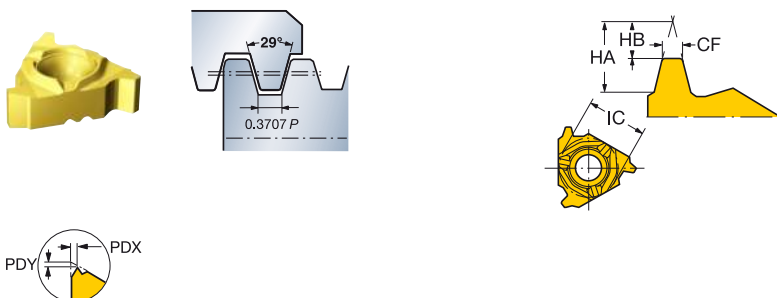
				P		M		K		N		S		Dimensions, mm, inch								
				1020	1135	1020	1135	1020	1135	1020	1135											
TPI	NT	Ordering code												CF	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	16.0	1	266RG-16AC01F160E	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.5	2.41	.0949	1.08	.0425	1.10	.043	1.30	.051
		14.0	1	266RG-16AC01F140E	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.6	1.85	.0728	0.88	.0346	1.00	.039	1.32	.051
		12.0	1	266RG-16AC01F120E	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.7	2.64	.1039	1.43	.0563	1.20	.047	1.32	.052
		10.0	1	266RG-16AC01F100E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.8	3.16	.1244	1.61	.0634	1.30	.051	1.32
22	1/2	8.0	1	266RG-16AC01F080E	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.0	3.94	.1551	2.08	.0819	1.50	.059	1.23	.048
		6.0	1	266RG-22AC01F060E	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.4	5.25	.2067	2.84	.1118	1.90	.074	1.37	.054
		5.0	1	266RG-22AC01F050E	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.7	6.29	.2476	3.47	.1366	2.10	.082	1.37	.054
		4.0	1	266RG-22AC01F040E	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.2	7.87	.3098	4.41	.1736	2.40	.094	0.78	.030
27	5/8	3.0	1	266RG-27AC01F030E	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.0	10.4	.4122	5.95	.2343	3.30	.129	0.54	.021

CoroThread® 266 insert for thread turning

ACME 29° Chamfered crest form

THFTSR
TCTR
NT

ANSI B1.5-1988
2G
1



Internal right-hand threads

				P		M		K		N		S		Dimensions, mm, inch										
		TPI	NT	Ordering code				1020	1135	1020	1135	1020	1135	1020	1135	CF	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
		16	3/8	16.0	1	266RL-16AC01F160E																		
				14.0	1	266RL-16AC01F140E																		
				12.0	1	266RL-16AC01F120E																		
				10.0	1	266RL-16AC01F100E																		
				8.0	1	266RL-16AC01F080E																		
		22	1/2	6.0	1	266RL-22AC01A060M																		
					1	266RL-22AC01F060E																		
						5.0	1	266RL-22AC01F050E																
				4.0	1	266RL-22AC01F040E																		
		27	5/8	3.0	1	266RL-27AC01F030E																		

Internal left-hand threads

				P	M	K	N	S	Dimensions, mm, inch														
		TPI	NT	Ordering code	1020	1135	1020	1135	1020	1135	1020	1135	1020	1135	CF	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
		3/8	12.0	1	266LL-16AC01F120E	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.7	3.63	.1429	1.82	.0717	1.60	.062	1.23	.048
			10.0	1	266LL-16AC01F100E	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.8	1.98	.0780	1.04	.0409	1.00	.039	1.32	.051
			8.0	1	266LL-16AC01F080E	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.0	1.86	.0732	1.21	.0476	0.90	.035	1.32	.051
		1/2	6.0	1	266LL-22AC01F060E	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.4	5.19	.2043	2.76	.1087	1.90	.074	1.35	.053
			5.0	1	266LL-22AC01F050E	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.7	6.22	.2449	3.37	.1327	2.00	.078	0.96	.037
			4.0	1	266LL-22AC01F040E	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.2	7.77	.3059	4.28	.1685	2.40	.094	0.70	.027

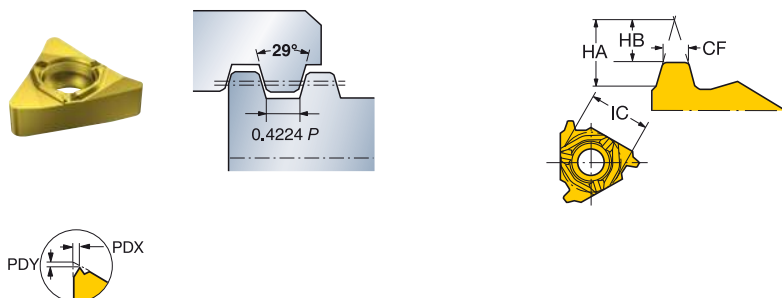
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

STUB-ACME 29° Chamfered crest form

THFTSR ANSI B1.8-1988
TCTR 2G
NT 1



External right-hand threads

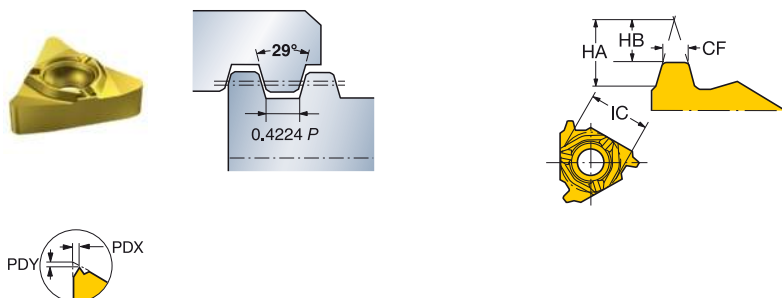
					P	M	K	N	S	Dimensions, mm, inch											
					1020	1135	1020	1135	1020	1135	1020	1135									
		TPI	NT	Ordering code									CF	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
16	3/8	16.0	1	266RG-16SA01F160E		☆		☆		☆		☆	0.6	3.94	.1551	2.08	.0819	1.50	.059	1.23	.048
		14.0	1	266RG-16SA01F140E		☆		☆		☆		☆	0.7	2.87	.1130	1.58	.0622	1.85	.072	1.30	.051
		12.0	1	266RG-16SA01F120E		☆		☆		☆		☆	0.8	2.47	.0972	1.65	.0650	1.10	.043	1.32	.051
		10.0	1	266RG-16SA01F100E		☆		☆		☆		☆	0.9	2.95	.1161	1.87	.0736	1.20	.047	1.32	.051
22	1/2	8.0	1	266RG-16SA01F080E		☆		☆		☆		☆	1.2	3.67	.1445	2.39	.0941	1.50	.059	1.52	.060
		6.0	1	266RG-22SA01F060E	☆		☆		☆		☆		1.6	4.86	.1913	3.27	.1287	1.80	.070	1.67	.065
		5.0	1	266RG-22SA01F050E	☆		☆		☆		☆		2.0	5.83	.2295	3.98	.1567	2.00	.078	1.67	.065
		4.0	1	266RG-22SA01F040E	☆		☆		☆		☆		2.6	7.27	.2862	5.05	.1988	2.40	.094	1.67	.065
27	5/8	3.0	1	266RG-27SA01F030E	☆		☆		☆		☆		3.5	9.66	.3803	6.81	.2681	3.10	.122	1.72	.067

CoroThread® 266 insert for thread turning

STUB-ACME 29° Chamfered crest form

THFTSR
TCTR
NT

ANSI B1.8-1988
2G
1



Internal right-hand threads

						Dimensions, mm, inch											
	TPI	NT	Ordering code	P		M		K		N		S					
				1020	1135	1020	1135	1020	1135	1020	1135	1020	1135	CF	HA	HA"	HB
16	3/8	16.0	1 266RL-16SA01F160E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.5	2.25	.0886	1.16
		14.0	1 266RL-16SA01F140E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.7	0.78	.0307	0.13
		12.0	1 266RL-16SA01F120E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.8	2.40	.0945	1.59
		10.0	1 266RL-16SA01F100E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.9	2.88	.1134	1.80
22	1/2	8.0	1 266RL-16SA01F080E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.2	3.59	.1413	2.31
		6.0	1 266RL-22SA01F060E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.6	4.77	.1878	3.18
		5.0	1 266RL-22SA01F050E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.0	5.71	.2248	3.87
		4.0	1 266RL-22SA01F040E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.5	7.13	.2807	4.91
27	5/8	3.0	1 266RL-27SA01F030E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.4	9.49	.3736	6.64

Internal left-hand threads

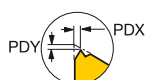
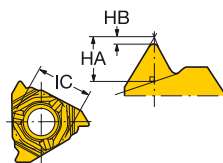
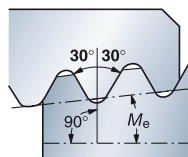
														Dimensions, mm, inch			
	TPI	NT	Ordering code	P		M		K		N		S		CF	HA	HA"	HB
				1020	1135	1020	1135	1020	1135	1020	1135	1020	1135	CF	HA	HA"	HB
16	3/8	12.0	1 266LL-16SA01F120E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.8	2.95	.1161	1.87
		10.0	1 266LL-16SA01F100E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.9	3.67	.1445	2.39
		8.0	1 266LL-16SA01F080E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.2	3.59	.1413	2.00
22	1/2	6.0	1 266LL-22SA01F060E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.6	4.77	.1878	3.18
		5.0	1 266LL-22SA01F050E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.0	5.71	.2248	3.87
		4.0	1 266LL-22SA01F040E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.5	7.13	.2807	4.91

N = Neutral, R = Right hand, L = Left hand



API 60° Full form for shouldered connections

API Spec. 7
1



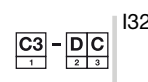
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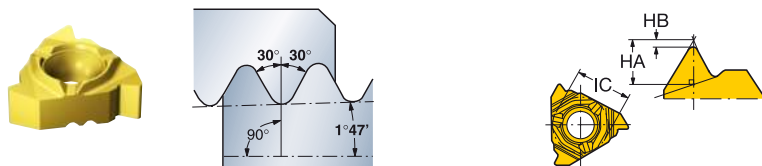
G



CoroThread® 266 insert for thread turning

API Round 60° Full form

THFTSR API Spec. 5B
NT 1



External right-hand threads

				P	M	K	N	S	Dimensions, mm, inch											
		TPI	NT	Ordering code	1020	1125	1020	1125	1020	1125	1020	1125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
	3/8	10.0	1	266RG-16RD01A100E	☆	☆	☆	☆	☆	☆	☆	☆	1.76	.0693	0.36	.0142	1.30	.051	1.34	.053
		1	266RG-16RD01C100M	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.23	.0878	0.43	.0169	1.50	.059	1.34	.053
	8.0	1	266RG-16RD01A080E	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.23	.0878	0.43	.0169	1.50	.059	1.34	.053
		1	266RG-16RD01C080M	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.23	.0878	0.43	.0169	1.34	.053	1.50	.059
	1/2	10.0	1	266RG-22RD01A100E	☆	☆	☆	☆	☆	☆	☆	☆	1.76	.0693	0.36	.0142	2.00	.078	1.67	.065
	8.0	1	266RG-22RD01A080E	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.23	.0878	0.43	.0169	2.00	.078	1.67	.065

Internal right-hand threads

				P			M			K			N			S			Dimensions, mm, inch																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					
		TPI	NT	Ordering code																		HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
		16	3/8	10.0	1	266RL-16RD01A100E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆

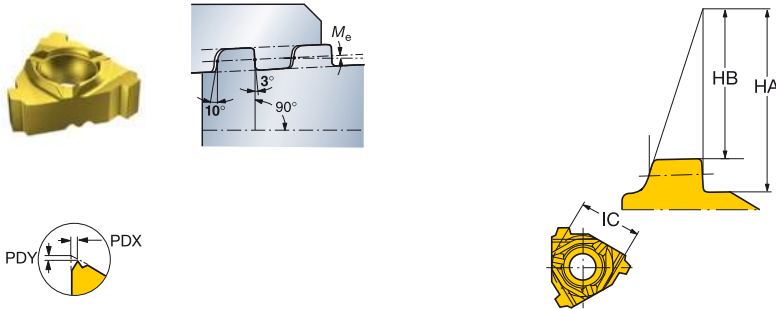
N = Neutral, R = Right hand, L = Left hand



CoroThread® 266 insert for thread turning

API Full form for tubes and casings

THFTSR
NT API Spec. 5B
1



External right-hand threads

				P	M	K	N	S	Dimensions, mm, inch									
HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG										
22	1/2	5.0	1	266RG-22BU01A0501E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
12.0	.4748	10.6	.4173	2.50	.098	1.97	.077	0.08										
1				266RG-22BU01A050E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
12.0	.4744	10.4	.4122	2.50	.098	1.97	.077	0.06										

Internal right-hand threads

				P	M	K	N	S	Dimensions, mm, inch									
HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG										
22	1/2	5.0	1	266RL-22BU01A0501E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
12.0	.4740	10.6	.4181	2.20	.086	1.93	.075	0.08										
1				266RL-22BU01A050E	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
12.1	.4795	10.6	.4173	2.30	.090	1.93	.075	0.06										

N = Neutral, R = Right hand, L = Left hand

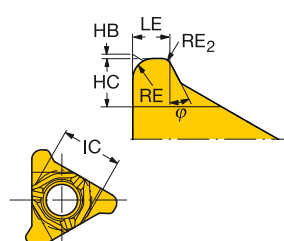
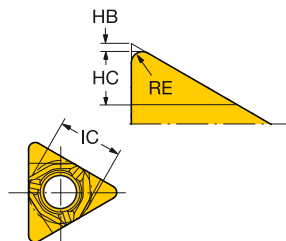
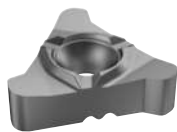


CoroThread® 266 carbide blank

Blanks

DSGN 1

2



External threads

			Dimensions, mm, inch															
	DSGN	Ordering code	P	M	K	N	S	HB	HB"	HC	HC"	RE	RE"	RE ₂	RE ₂ "	LE	LE"	
			H13A	H13A	H13A	H13A	H13A											
16	3/8	1	266R/LG-160000-300-BG	☆	☆	☆	☆	☆	0.70	.0256	3.20	.1262	1.00	.0394				
22	1/2	2	266R/LG-220000-600-BG	☆	☆	☆	☆	☆	0.30	.0118	4.80	.1890	2.00	.0787	1.00	.0394	3.5	.138
27	5/8	2	266RG-270000-800-BG	☆	☆	☆	☆	☆	0.30	.0118	5.80	.2283	2.00	.0787	1.00	.0394	6.5	.256

Internal threads

				Dimensions, mm, inch													
				P	M	K	N	S									

N = Neutral, R = Right hand, L = Left hand

Note: Precaution should be taken when grinding cemented carbide products. See page I7 for safety information.



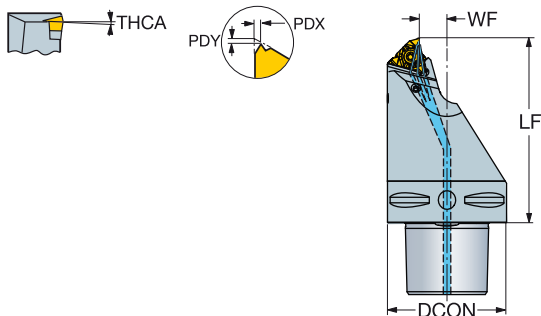
CoroThread® 266 cutting unit for thread turning

Screw clamp design

Coromant Capto® - High precision coolant supply



266 R/LG



External

						Dimensions, mm, inch									
			CZC _{MS}	OHX	CNSC	Ordering code	DCON	LF	WF	HF	THCA	CP Bar/PSI	Nm	Kg	MIID
	16	3/8	C6	100	1	C6-266RS18100-16HP	63	100.0	18.0	0	-1	80	3.5	1.8	266.RG-16..
							2.480	3.937	.709	.000		1160			266.RG-16..
	22	1/2	C6	100	1	C6-266RS16100-22HP	63	100.0	16.0	0	-1	80	5.0	1.8	266.RG-22..
							2.480	3.937	.630	.000		1160			266.RG-22..

N = Neutral, R = Right hand, L = Left hand

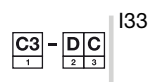
For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89

Note:

In a Multi-task machine the tool must lean 45 degrees otherwise the tool holder, B-axes, will interfere with the chuck.



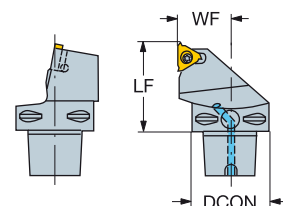
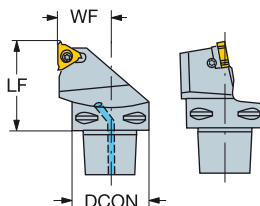
CoroThread® 266 cutting unit for thread turning

Screw clamp design

Coromant Capto® - Internal coolant supply

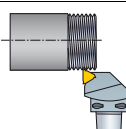
Cx-266R/LFG

Cx-266R/LFGZ



266 R/LG

External

							Dimensions, mm, inch									
			CZC _{MS}	OHX	CNSC	Ordering code	DCON	LF	WF	HF	THCA	CP Bar/PSI	 Nm	 Kg	MIID	
	16	3/8	C3	40	1	C3-266R/LFG-22040-16	32	40.0	22.0	0	1	10	3.0	0.3	266.RG-16..	
				1.575			1.260	1.575	.866	.000		145			266.LG-16..	
			C4	50	1	C4-266R/LFG-27050-16	40	50.0	27.0	0	1	10	3.0	0.5	266.RG-16..	
				1.969			1.575	1.969	1.063	.000		145			266.LG-16..	
			C5	60	1	C5-266R/LFG-35060-16	50	60.0	35.0	0	1	10	3.0	0.5	266.RG-16..	
				2.362			1.969	2.362	1.378	.000		145			266.RG-16..	
			C6	65	1	C6-266R/LFG-45065-16	63	65.0	45.0	0	1	10	3.0	0.5	266.LG-16..	
				2.559			2.480	2.559	1.772	.000		145			266.RG-16..	
			C8	80	1	C8-266R/LFG-55080-16	80	80.0	55.0	0	1	10	3.0	0.9	266.LG-16..	
				3.150			3.150	3.150	2.165	.000		145			266.LG-16..	
	22	1/2	C3	40	1	C3-266R/LFG-22040-22	32	40.0	22.0	0	-1	10	5.0	0.1	266.LG-22..	
				1.575			1.260	1.575	.866	.000		145			266.LG-22..	
			C4	50	1	C4-266R/LFG-27050-22	40	50.0	27.0	0	-1	10	5.0	0.3	266.LG-22..	
				1.969			1.575	1.969	1.063	.000		145			266.LG-22..	
			C5	60	1	C5-266R/LFG-35060-22	50	60.0	35.0	0	-1	10	5.0	0.6	266.RG-22..	
				2.362			1.969	2.362	1.378	.000		145			266.RG-22..	
			C6	65	1	C6-266R/LFG-45065-22	63	65.0	45.0	0	-1	10	5.0	1.1	266.RG-22..	
				2.559			2.480	2.559	1.772	.000		145			266.RG-22..	
			C8	80	1	C8-266R/LFG-55080-22	80	80.0	55.0	0	-1	10	5.0	2.4	266.LG-22..	
				3.150			3.150	3.150	2.165	.000		145			266.LG-22..	
	27	5/8	C6	65	1	C6-266R/LFG-45065-27	63	65.0	45.0	0	-1	10	7.5	1.1	266.RG-27..	
				2.559			2.480	2.559	1.772	.000		145			266.RG-27..	
	16	3/8	C4	50	1	C4-266RFGZ27050-16	40	50.0	27.0	0	1	10	3.0	0.5	266.RG-16..	
				1.969			1.575	1.969	1.063	.000		145			266.RG-16..	
			C5	60	1	C5-266RFGZ35060-16	50	60.0	35.0	0	1	10	3.0	0.5	266.RG-16..	
				2.362			1.969	2.362	1.378	.000		145			266.RG-16..	
			C6	65	1	C6-266RFGZ45065-16	63	65.0	45.0	0	1	10	3.0	0.6	266.RG-16..	
				2.559			2.480	2.559	1.772	.000		145			266.RG-16..	
	22	1/2	C4	50	1	C4-266R/LFGZ27050-22	40	50.0	27.0	0	-1	10	5.0	0.3	266.RG-22..	
				1.969			1.575	1.969	1.063	.000		145			266.RG-22..	
			C5	60	1	C5-266R/LFGZ35060-22	50	60.0	35.0	0	-1	10	5.0	0.6	266.LG-22..	
				2.362			1.969	2.362	1.378	.000		145			266.LG-22..	
			C6	65	1	C6-266R/LFGZ45065-22	63	65.0	45.0	0	-1	10	5.0	1.1	266.RG-22..	
				2.559			2.480	2.559	1.772	.000		145			266.LG-22..	
	27	5/8	C6	65	1	C6-266R/LFGZ45065-27	63	65.0	45.0	0	-1	10	7.5	1.1	266.LG-27..	
				2.559			2.480	2.559	1.772	.000		145			266.LG-27..	

N = Neutral, R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89

Z = For upside down mounting



C4



I1



F16



I38



I33

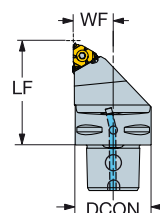
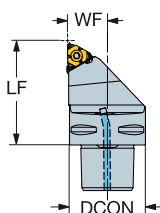
CoroThread® 266 cutting unit for thread turning

Screw clamp design

Coromant Capto® - Internal coolant supply

Cx-266R/LFA

Cx-266R/LFAZ



266 R/LG

External

						Dimensions, mm, inch									
			CZC _{MS}	OHX	CNSC	Ordering code	DCON	LF	WF	HF	THCA	CP Bar/PSI			MIID
	16	3/8	C3	39	1	C3-266R/LFA-17039-16	32	39.0	17.0	0	1	10	3.0	0.1	266.LG-16..
				1.535			1.260	1.535	.669	.000		145			266.LG-16..
			C4	55	1	C4-266R/LFA-21055-16	40	55.0	21.0	0	1	10	3.0	0.4	266.RG-16..
				2.165			1.575	2.165	.827	.000		145			266.LG-16..
			C5	65	1	C5-266R/LFA-26065-16	50	65.0	26.0	0	1	10	3.0	0.7	266.RG-16..
				2.559			1.969	2.559	1.024	.000		145			266.LG-16..
			C6	75	1	C6-266R/LFA-33075-16	63	75.0	33.0	0	1	10	3.0	1.3	266.LG-16..
				2.953			2.480	2.953	1.299	.000		145			266.RG-16..
	16	3/8	C3	39	1	C3-266RFAZ17039-16	32	39.0	17.0	0	1	10	3.0	0.8	266.RG-16..
				1.535			1.260	1.535	.669	.000		145			266.RG-16..
			C4	55	1	C4-266RFAZ21055-16	40	55.0	21.0	0	1	10	3.0	0.4	266.RG-16..
				2.165			1.575	2.165	.827	.000		145			266.RG-16..
			C5	65	1	C5-266RFAZ26065-16	50	65.0	26.0	0	1	10	3.0	0.7	266.RG-16..
				2.559			1.969	2.559	1.024	.000		145			266.RG-16..
			C6	75	1	C6-266RFAZ33075-16	63	75.0	33.0	0	1	10	3.0	1.3	266.RG-16..
				2.953			2.480	2.953	1.299	.000		145			266.RG-16..

N = Neutral, R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89

Z = For upside down mounting



C4



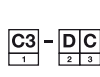
I1



F16



I38

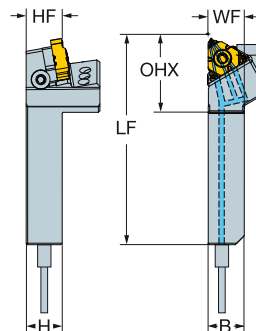


I33

CoroThread® 266 QS shank tool for thread turning

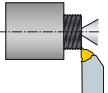
Screw clamp design

High precision coolant supply

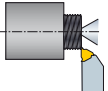


266 R/LG

Metric version

		CZC _{MS}	OHX	CNSC	Ordering code	Dimensions, mm								CP 	Nm 	Kg 	MIID
	16	12 x 12	25	1	QS-266RFA-1212-16HP	B	H	LF	WF	HF	THCA	80	3.0	0.090	266.RG-16..		
		16 x 16	25	1	QS-266RFA-1616-16HP	16	16	70	16	16	1	80	3.0	0.190	266.RG-16..		

Inch version

						Ordering code	Dimensions, inch							 CP PSI	 Ft/lbs	 Lbs	MIID
		CZC _{MS}	OHX	CNSC	B		H	LF	WF	HF	THCA						
	3/8	1/2 x 1/2	.984	1	QS-266RFA-083HP	.500	.500	2.755	.500	.500	1	1160	1.62	.198	266.RG-16..		
		5/8 x 5/8	.984	1	QS-266RFA-103HP	.625	.625	2.755	.625	.625	1	1160	2.21	.418	266.RG-16..		

R = Right hand

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



I1



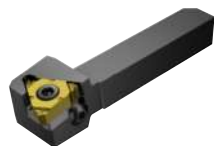
H10



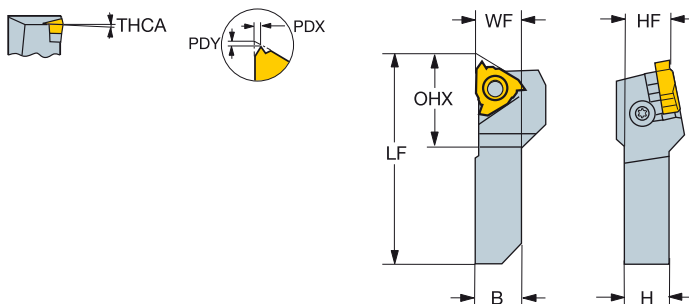
I38

CoroThread® 266 QS shank tool for thread turning

Screw clamp design



266 R/LG



Metric version

						Dimensions, mm								
						B	H	LF	WF	HF	THCA			MIID
		16	CZC _{MS}	OHX	CNSC	Ordering code								
			10 x 10	19	0	QS-266RFA-1010-16								
			12 x 12	21	0	QS-266RFA-1212-16								
			16 x 16	23	0	QS-266RFA-1616-16								

Inch version

						Dimensions, inch								
						B	H	LF	WF	HF	THCA			MIID
		3/8	CZC _{MS}	OHX	CNSC	Ordering code								
			3/8 x 3/8	.779	0	QS-266RFA-063								
			1/2 x 1/2	.838	0	QS-266RFA-083								
			5/8 x 5/8	.917	0	QS-266RFA-103								

R = Right hand

For PDX/PDY values - see insert page.

For infed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



I1



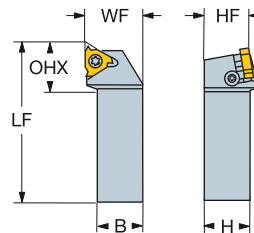
H10



I38

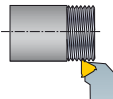
CoroThread® 266 shank tool for thread turning

Screw clamp design

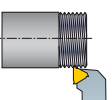


266 R/LG

Metric version

						Dimensions, mm											
		CZC _{MS}	OHX	CNSC	Ordering code	B	H	LF	WF	HF	THCA			MIID			
	16	16 x 16	21	0	266R/LFG-1616-16	16	16	100	20	16	1	3.0	0.550	266.LG-16..			
		20 x 20	21	0	266R/LFG-2020-16	20	20	125	25	20	1	3.0	0.550	266.RG-16..			
		25 x 25	22	0	266R/LFG-2525-16	25	25	150	32	25	1	3.0	0.800	266.RG-16..			
		32 x 25	22	0	266R/LFG-3225-16	25	32	150	32	32	1	3.0	0.550	266.RG-16..			
	22	25 x 25	33	0	266R/LFG-2525-22	25	25	150	32	25	-1	5.0	0.800	266.RG-22..			
		32 x 32	34	0	266R/LFG-3232-22	32	32	170	40	32	-1	5.0	1.500	266.RG-22..			
		40 x 40	29	0	266R/LFG-4040-22	40	40	250	50	40	-1	5.0	4.240	266.RG-22..			
		27	32 x 32	39	0	266R/LFG-3232-27	32	32	170	40	32	-1	7.5	1.500	266.RG-27..		
	40 x 40		34	0	266R/LFG-4040-27	40	40	250	50	40	-1	7.5	4.250	266.RG-27..			

Inch version

					Ordering code	Dimensions, inch							 		MIID
	CZC _{MS}	OHX	CNSC			B	H	LF	WF	HF	THCA	Ft/lbs	Libs		
	3/8	3/4 x 3/4	.870	0	266R/LFG-123B	.750	.750	4.500	1.000	.750	1	2.21	.880	266.LG-16..	
		1 x 1	.870	0	266R/LFG-163D	1.00	1.00	6.000	1.250	1.000	1	2.21	1.760	266.LG-16..	
		1 1/4 x 1 1/4	.870	0	266R/LFG-203D	1.25	1.25	6.000	1.500	1.250	1	2.21	2.640	266.LG-16..	
	1/2	1 x 1	1.272	0	266R/LFG-164D	1.00	1.00	6.000	1.250	1.000	-1	3.68	1.760	266.LG-22..	
		1 1/4 x 1 1/4	1.271	0	266R/LFG-204D	1.25	1.25	6.000	1.500	1.250	-1	3.68	2.640	266.LG-22..	
		1 1/2 x 1 1/2	1.192	0	266R/LFG-244E	1.50	1.50	7.000	2.000	1.500	-1	3.68	4.400	266.LG-22..	
	5/8	1 1/4 x 1 1/4	1.455	0	266R/LFG-205D	1.25	1.25	6.000	1.500	1.250	-1	5.53	2.640	266.LG-27..	
		1 1/2 x 1 1/2	1.385	0	266R/LFG-245E	1.50	1.50	7.000	2.000	1.500	-1	5.53	4.400	266.LG-27..	

N = Neutral, R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



I1



F16



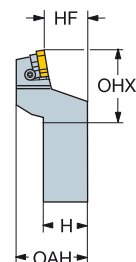
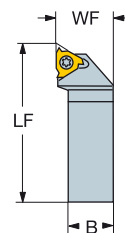
I38



I32

CoroThread® 266 shank tool for thread turning

Screw clamp design



266 R/LG

Metric version

				Dimensions, mm											
		CZC _{MS}	OHX	CNSC	Ordering code	B	H	LF	WF	HF	OAH	THCA			MIID
	16	25 x 25	22	0	266R/LFGZ2525-16	25	25	150	32	25	44	1	3.0	0.550	266.LG-16..
		32 x 25	22	0	266RFGZ3225-16	25	32	170	32	32	48	1	3.0	0.550	266.RG-16..
	22	25 x 25	33	0	266R/LFGZ2525-22	25	25	150	32	25	46	-1	5.0	0.800	266.LG-22..
		32 x 32	34	0	266R/LFGZ3232-22	32	32	170	40	32	52	-1	5.0	1.200	266.LG-22..

Inch version

				Dimensions, inch											
		CZC _{MS}	OHX	CNSC	Ordering code	B	H	LF	WF	HF	OAH	THCA			MIID
	3/8	3/4 x 3/4	.870	0	266R/LFGZ123B	.750	.750	4.500	1.000	.750	1.379	1	2.21	.880	266.LG-16..
		1 x 1	.870	0	266R/LFGZ163D	1.00	1.00	6.000	1.250	1.000	1.629	1	2.21	1.760	266.LG-16..
		1 1/4 x 1 1/4	.870	0	266RFGZ203D	1.25	1.25	6.000	1.500	1.250	2.037	1	2.21	2.750	266.RG-16..
	1/2	1 x 1	1.272	0	266R/LFGZ164D	1.00	1.00	6.000	1.250	1.000	1.787	-1	3.68	1.760	266.LG-22..
		1 1/4 x 1 1/4	1.271	0	266R/LFGZ204D	1.25	1.25	6.000	1.500	1.250	2.037	-1	3.68	2.750	266.LG-22..

N = Neutral, R = Right hand, L = Left hand

Z = For upside down mounting

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



I1



F16



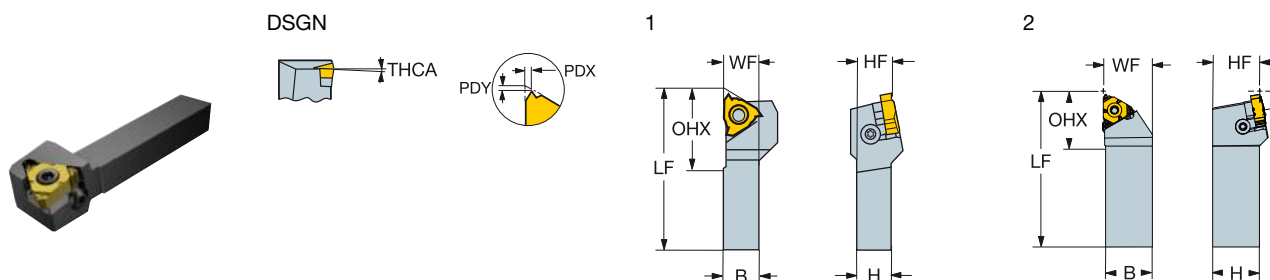
I38



I32

CoroThread® 266 shank tool for thread turning

Screw clamp design



266 R/LG

Metric version

							Dimensions, mm									
							B	H	LF	WF	HF	THCA	Nm	Kg		
	16	CZC _{MS}	OHX	CNSC	DSGN	Ordering code	10	10	125	10	10	1	3.0	0.171	266.LG-16..	
	12 x 12		23	0	2	266R/LFA-1212-16	12	12	80	12	12	1	3.0	0.127	266.RG-16..	
	12 x 12		21	0	1	266R/LFA-1212-16-S	12	12	125	12	12	1	3.0	0.171	266.RG-16..	
	16 x 16		21	0	2	266R/LFA-1616-16	16	16	100	16	16	1	3.0	0.217	266.RG-16..	
	16 x 16		23	0	1	266R/LFA-1616-16-S	16	16	125	16	16	1	3.0	0.272	266.RG-16..	
	20 x 20		21	0	2	266R/LFA-2020-16	20	20	125	20	20	1	3.0	0.400	266.RG-16..	
	25 x 25		22	0	2	266R/LFA-2525-16	25	25	150	25	25	1	3.0	0.708	266.RG-16..	

Inch version

							Dimensions, inch									
							B	H	LF	WF	HF	THCA	Ft/lbs	Lbs		
	3/8	CZC _{MS}	OHX	CNSC	DSGN	Ordering code	.375	.375	5.000	.375	.375	1	2.21	.376	266.RG-16..	
	1/2 x 1/2		.841	0	1	266R/LFA-083-S	.500	.500	5.000	.500	.500	1	2.21	.376	266.RG-16..	
	1/2 x 1/2		.921	0	2	266RFA-083	.500	.500	3.500	.520	.500	1	1.62	.316	266.RG-16..	
	5/8 x 5/8		.921	0	2	266R/LFA-103	.625	.625	4.000	.645	.625	1	1.62	.440	266.LG-16..	
	5/8 x 5/8		.841	0	1	266R/LFA-103-S	.625	.625	5.000	.625	.625	1	2.21	.596	266.LG-16..	
	3/4 x 3/4		.921	0	2	266R/LFA-123B	.750	.750	4.500	.770	.750	1	1.62	.792	266.LG-16..	
	3/4 x 3/4		.841	0	1	266R/LFA-123-S	.750	.750	5.000	.750	.750	1	2.21	.880	266.LG-16..	
	1 x 1		.921	0	2	266R/LFA-163D	1.00	1.00	6.000	1.020	1.000	1	1.62	1.603	266.LG-16..	
	1 1/4 x 1 1/4		.921	0	2	266RFA-203D	1.25	1.25	6.000	1.289	1.250	1	1.62	2.393	266.RG-16..	

For threading near a tail stock

N = Neutral, R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



I1



F16



I38

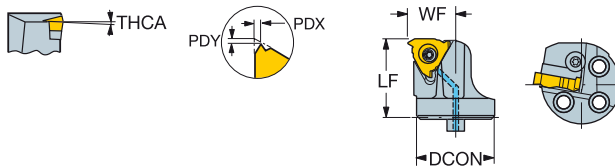


I32

CoroThread® 266 head for thread turning

Screw clamp design

CoroTurn® SL - Internal coolant supply



266 R/LG

							Dimensions, mm, inch									
			CZC _{MS}	DMIN ₁	OHX	CNSC	Ordering code	DCON	LF	WF	HF	THCA	CP Bar/PSI			MIID
	16	3/8	20	25	25	0	SL-266R/LFG-202514-16	20	25.0	14.0	0	1		3.0	0.1	266.RG-16..
				.984	.984			.787	0.984	.551	.000					266.RG-16..
			25	32	25	1	SL-266R/LFG-252517-16	25	25.0	17.0	0	-1	10	3.0	0.1	266.RG-16..
				1.259	.984			.984	0.984	.669	.000		145			266.RG-16..
			32	40	32	1	SL-266R/LFG-323222-16	32	32.0	22.0	0	-1	10	3.0	0.1	266.RG-16..
				1.574	1.260			1.260	1.260	.866	.000		145			266.RG-16..
			40	50	32	1	SL-266R/LFG-403227-16	40	32.0	27.0	0	-1	10	3.0	0.2	266.RG-16..
				1.968	1.260			1.575	1.260	1.063	.000		145			266.RG-16..

When using an external CoroThread 266 SL cutting head the right hand head uses a left hand external insert and left hand head uses a right hand external insert.

N = Neutral, R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



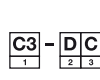
I1



G1



I38



I39

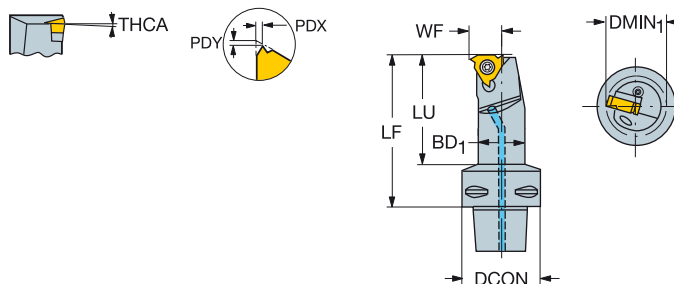
CoroThread® 266 cutting unit for thread turning

Screw clamp design

Coromant Capto® - Internal coolant supply



266 R/LL



								Dimensions, mm, inch													MIID
	16	3/8	CZC _{MS}	DMIN ₁	LU	OHX	CNSC	Ordering code	DCON	BD ₁	LF	WF	HF	THCA	CP Bar/PSI	Nm	Kg				
			C3	20	33	50	1	C3-266R/LKF-12050-16	32	15	50.0	12.0	0	2	10	3.0	0.21	266.RL-16..			
				.787	1.299	1.969			1.260	.610	1.969	.472	.000		145			266.RL-16..			
			C3	25	44	60	1	C3-266R/LKF-14060-16	32	18	60.0	14.0	0	1	10	3.0	0.24	266.RL-16..			
				.984	1.732	2.362			1.260	.728	2.362	.551	.000		145			266.RL-16..			
			C4	20	37	60	1	C4-266R/LKF-12060-16	40	15	60.0	12.0	0	2	10	3.0	0.55	266.RL-16..			
				.787	1.457	2.362			1.575	.610	2.362	.472	.000		145			266.LL-16..			
			C4	25	38	60	1	C4-266R/LKF-14060-16	40	18	60.0	14.0	0	1	10	3.0	0.51	266.LL-16..			
				.984	1.496	2.362			1.575	.728	2.362	.551	.000		145			266.LL-16..			
			C4	32	48	70	1	C4-266R/LKF-17070-16	40	24	70.0	17.0	0	1	10	3.0	0.52	266.LL-16..			
				1.259	1.890	2.756			1.575	.964	2.756	.669	.000		145			266.LL-16..			
			C4	40	69	90	1	C4-266RKF-22090-16	40	32	90.0	22.0	0	1	10	3.0	0.52	266.RL-16..			
				1.574	2.717	3.543			1.575	1.259	3.543	.866	.000		145			266.RL-16..			
			C5	20	35	60	1	C5-266R/LKF-12060-16	50	15	60.0	12.0	0	2	10	3.0	0.55	266.RL-16..			
				.787	1.378	2.362			1.969	.610	2.362	.472	.000		145			266.RL-16..			
			C5	25	36	60	1	C5-266R/LKF-14060-16	50	18	60.0	14.0	0	1	10	3.0	0.55	266.RL-16..			
				.984	1.417	2.362			1.969	.728	2.362	.551	.000		145			266.RL-16..			
			C5	32	47	70	1	C5-266R/LKF-17070-16	50	24	70.0	17.0	0	1	10	3.0	0.55	266.RL-16..			
				1.259	1.850	2.756			1.969	.964	2.756	.669	.000		145			266.RL-16..			
			C5	40	68	90	1	C5-266R/LKF-22090-16	50	32	90.0	22.0	0	1	10	3.0	0.55	266.RL-16..			
				1.574	2.677	3.543			1.969	1.259	3.543	.866	.000		145			266.RL-16..			
			C5	50	84	105	1	C5-266R/LKF-27105-16	50	40	105.0	27.0	0	1	10	3.0	0.55	266.RL-16..			
				1.968	3.307	4.134			1.969	1.574	4.134	1.063	.000		145			266.RL-16..			
			C6	25	42	70	1	C6-266R/LKF-14070-16	63	18	70.0	14.0	0	1	10	3.0	0.55	266.LL-16..			
				.984	1.654	2.756			2.480	.728	2.756	.551	.000		145			266.RL-16..			
			C6	32	48	75	1	C6-266R/LKF-17075-16	63	24	75.0	17.0	0	1	10	3.0	0.55	266.RL-16..			
				1.259	1.890	2.953			2.480	.964	2.953	.669	.000		145			266.RL-16..			
			C6	40	64	90	1	C6-266R/LKF-22090-16	63	32	90.0	22.0	0	1	10	3.0	1.10	266.RL-16..			
				1.574	2.520	3.543			2.480	1.259	3.543	.866	.000		145			266.RL-16..			
			C6	50	80	105	1	C6-266R/LKF-27105-16	63	40	105.0	27.0	0	1	10	3.0	1.35	266.RL-16..			
				1.968	3.150	4.134			2.480	1.574	4.134	1.063	.000		145			266.RL-16..			

N = Neutral, R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



I1



F16



I38



I33

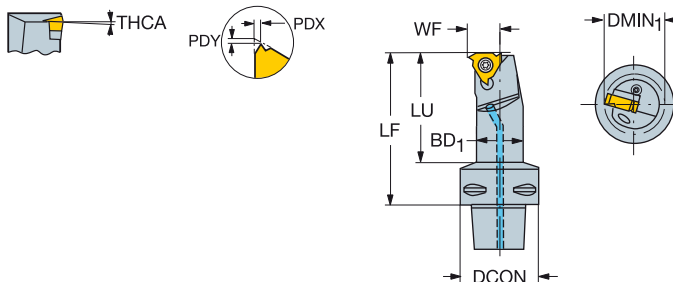
CoroThread® 266 cutting unit for thread turning

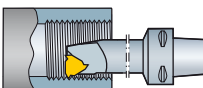
Screw clamp design

Coromant Capto® - Internal coolant supply



266 R/LL



								CZC _{MS}	DMIN ₁	LU	OHX	CNSC	Ordering code	Dimensions, mm, inch									
	22	1/2	DCON	BD ₁	LF	WF	HF							THCA	CP Bar/PSI	 Nm	 Kg	MIID					
			C4	25	42	65	1	C4-266R/LKF-15065-22	40	18	65.0	15.0	0	2	10	5.0	0.55	266.LL-22..					
				.984	1.654	2.559			1.575	.728	2.559	.591	.000		145			266.LL-22..					
			C4	32	48	70	1	C4-266RKF-19070-22	40	25	70.0	19.0	0	1	10	5.0	0.55	266.RL-22..					
				1.259	1.890	2.756			1.575	.984	2.756	.748	.000		145			266.RL-22..					
			C4	40	69	90	1	C4-266RKF-22090-22	40	31	90.0	22.0	0	1	10	5.0	0.55	266.RL-22..					
				1.574	2.717	3.543			1.575	1.240	3.543	.866	.000		145			266.RL-22..					
			C4	50	60	80	1	C4-266RKF-27080-22	40	39	80.0	27.0	0	1	10	5.0	0.55	266.RL-22..					
				1.968	2.362	3.150			1.575	1.555	3.150	1.063	.000		145			266.RL-22..					
			C5	25	41	65	1	C5-266R/LKF-15065-22	50	18	65.0	15.0	0	2	10	5.0	0.55	266.RL-22..					
				.984	1.614	2.559			1.969	.728	2.559	.591	.000		145			266.RL-22..					
			C5	50	84	105	1	C5-266R/LKF-27105-22	50	40	105.0	26.9	0	1	10	5.0	1.10	266.RL-22..					
				1.968	3.307	4.134			1.969	1.574	4.134	1.059	.000		145			266.RL-22..					
			C5	32	47	70	1	C5-266RKF-19070-22	50	25	70.0	19.0	0	1	10	5.0	0.55	266.RL-22..					
				1.259	1.850	2.756			1.969	.984	2.756	.748	.000		145			266.RL-22..					
			C5	40	68	90	1	C5-266RKF-22090-22	50	32	90.0	22.0	0	1	10	5.0	0.55	266.RL-22..					
				1.574	2.677	3.543			1.969	1.259	3.543	.866	.000		145			266.RL-22..					
			C6	50	80	105	1	C6-266R/LKF-27105-22	63	40	105.0	26.9	0	1	10	5.0	1.35	266.RL-22..					
				1.968	3.150	4.134			2.480	1.574	4.134	1.059	.000		145			266.RL-22..					
			C6	32	48	75	1	C6-266RKF-19075-22	63	25	75.0	19.0	0	1	10	5.0	0.55	266.RL-22..					
				1.259	1.890	2.953			2.480	.984	2.953	.748	.000		145			266.RL-22..					
			C6	40	64	90	1	C6-266RKF-22090-22	63	31	90.0	22.0	0	1	10	5.0	0.55	266.RL-22..					
				1.574	2.520	3.543			2.480	1.240	3.543	.866	.000		145			266.RL-22..					

N = Neutral, R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



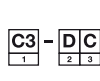
I1



F16



I38

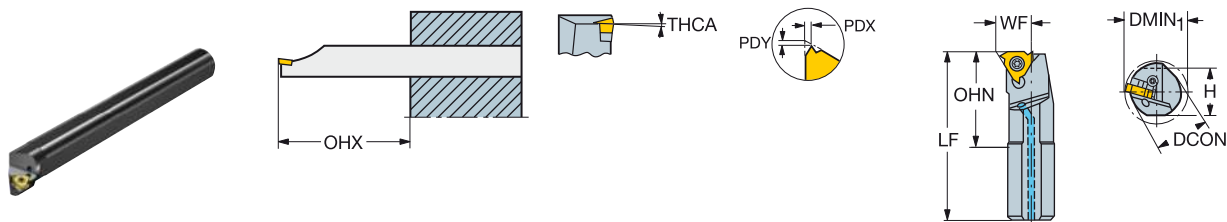


I33

CoroThread® 266 boring bar for thread turning

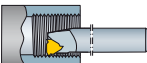
Screw clamp design

Cylindrical with flats - Internal coolant supply

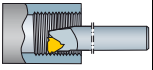


266 R/LL

Metric version

							Ordering code	Dimensions, mm												
		CZC _{MS}	DMIN ₁	OHX	OHN	CNSC		DCON	H	LF	WF	HF	THCA	CP Bar			MIID			
	16	20	48	27	1	266R/LKF-16-16	16	15	200	12	0	2	10	3.0	0.300	266.RL-16..				
		20	25	60	29	1	266R/LKF-20-16	20	18	250	14	0	1	10	3.0	0.597	266.LL-16..			
		25	32	75	29	1	266R/LKF-25-16	25	23	300	17	0	1	10	3.0	0.550	266.LL-16..			
		32	40	96	30	1	266R/LKF-32-16	32	30	250	22	0	1	10	3.0	0.550	266.LL-16..			
		40	50	120	31	1	266R/LKF-40-16	40	37	300	27	0	1	10	3.0	0.550	266.LL-16..			
		50	63	150	40	1	266R/LKF-50-16	50	49	350	35	0	1	10	3.0	0.550	266.LL-16..			
	22	20	25	60	36	1	266R/LKF-20-22	20	18	250	15	0	2	10	5.0	0.600	266.LL-22..			
		25	32	75	34	1	266R/LKF-25-22	25	23	300	19	0	1	10	5.0	0.550	266.LL-22..			
		32	40	96	37	1	266R/LKF-32-22	32	30	250	21	0	1	10	5.0	1.500	266.LL-22..			
		40	50	120	38	1	266R/LKF-40-22	40	37	300	26	0	1	10	5.0	2.760	266.LL-22..			
		50	63	150	45	1	266R/LKF-50-22	50	47	350	34	0	1	10	5.0	12.700	266.LL-22..			
		27	40	50	120	47	1	266R/LKF-40-27	40	37	300	26	0	1	10	7.5	2.760	266.LL-27..		

Inch version

								Dimensions, inch										
							Ordering code	DCON	H	LF	WF	HF	THCA	CP 	PSI 	Ft/lbs 	Lbs 	MIID
	3/8	5/8	.790	1.875	1.050	1	266R/LKF-D10-3	.625	.562	8.000	.472	.000	2	145	2.21	.607	266.RL-16..	
		3/4	.980	2.250	1.140	1	266R/LKF-D12-3	.750	.709	10.00	.550	.000	1	145	2.21	1.100	266.RL-16..	
		1	1.260	3.000	1.140	1	266R/LKF-D16-3	1.000	.905	12.00	.669	.000	1	145	2.21	2.200	266.RL-16..	
		1 1/4	1.580	3.750	1.220	1	266R/LKF-D20-3	1.250	1.18	14.00	.865	.000	1	145	2.21	4.400	266.RL-16..	
		1 1/2	1.970	4.500	1.260	1	266R/LKF-D24-3	1.500	1.37	15.00	1.06	.000	1	145	2.21	11.000	266.RL-16..	
		2	2.480	6.000	1.580	1	266R/LKF-D32-3	2.000	1.87	16.00	1.37	.000	1	145	2.21	27.940	266.RL-16..	
	1/2	1 1/4	1.580	3.750	1.742	1	266R/LKF-D20-4	1.250	1.18	14.00	.865	.000	1	145	3.68	4.400	266.RL-22..	
		1 1/2	1.970	4.500	2.011	1	266R/LKF-D24-4	1.500	1.37	15.00	1.06	.000	1	145	3.68	6.094	266.RL-22..	
		2	2.480	6.000	2.059	1	266R/LKF-D32-4	2.000	1.87	16.00	1.37	.000	1	145	3.68	27.940	266.RL-22..	

N = Neutral, R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



I1



F16



I38

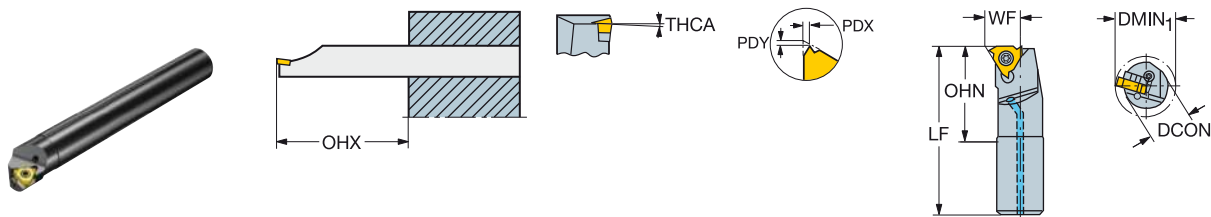


I33

CoroThread® 266 boring bar for thread turning

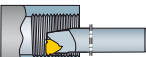
Screw clamp design

Cylindrical with EasyFix position support - Internal coolant supply

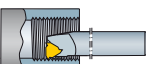


266 R/LL

Metric version

							Ordering code	Dimensions, mm							 CP Bar	 Nm	 Kg	MIID
		CZC _{MS}	DMIN ₁	OHX	OHN	CNSC		DCON	LF	WF	HF	THCA						
	16	16	20	48	27	1	266R/LKF-16-16-R	16	125	12	0	2	10	3.0	0.180	266.RL-16..		
		16	20	96	33	1	266R/LKF-16-16-RE	16	200	12	0	2	10	3.0	0.480	266.LL-16..		
		20	25	60	28	1	266R/LKF-20-16-R	20	140	14	0	1	10	3.0	0.550	266.LL-16..		
		25	32	75	28	1	266R/LKF-25-16-R	25	180	17	0	1	10	3.0	0.550	266.RL-16..		
	22	20	25	60	34	1	266R/LKF-20-22-R	20	140	15	0	2	10	5.0	0.550	266.LL-22..		
		25	32	75	34	1	266R/LKF-25-22-R	25	180	19	0	1	10	5.0	0.550	266.RL-22..		

Inch version

							Ordering code	Dimensions, inch									
		CZC _{MS}	DMIN	OHX	OHN	CNSC		DCON	LF	WF	HF	THCA	CP PSI	 Ft/lbs	 Lbs	MIID	
	3/8	5/8	.787	1.875	1.062	1	266R/LKF-D10-3-R	.625	8.000	.472	.000	2	145	2.21	.396	266.RL-16..	
	5/8	.787	3.750	1.060	1	266R/LKF-D10-3-RE	.625	10.00	.472	.000	2	145	2.21	1.364	266.LL-16..		
	3/4	.980	2.250	1.140	1	266R/LKF-D12-3-R	.750	10.00	.550	.000	1	145	2.21	1.100	266.LL-16..		
	3/4	.980	4.500	1.140	1	266RKF-D12-3-RE	.750	10.00	.550	.000	1	145	2.21	1.100	266.RL-16..		
	1	1.260	3.000	1.140	1	266R/LKF-D16-3-R	1.000	12.00	.669	.000	1	145	2.21	2.244	266.LL-16..		
	1/2	3/4	.984	1.875	1.346	1	266R/LKF-D12-4-R	.750	10.00	.590	.000	2	145	3.68	1.210	266.LL-22..	
	1	1.260	3.000	1.340	1	266R/LKF-D16-4-R	1.000	12.00	.669	.000	1	145	3.68	2.200	266.LL-22..		

N = Neutral, R = Right hand, L = Left hand

E= Carbide reinforced boring bar

Round boring bars can be used with EasyFix sleeves for secure and accurate clamping

For PDX/PDY values - see insert page.

For infed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



I1



F16



I38

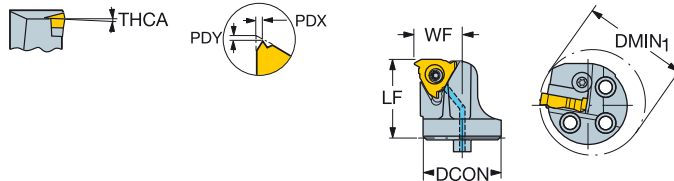


I33

CoroThread® 266 head for thread turning

Screw clamp design

CoroTurn® SL - Internal coolant supply



266 R/LL

							Dimensions, mm, inch									
			CZC _{MS}	DMIN ₁	OHX	CNSC	Ordering code	DCON	LF	WF	HF	THCA	CP BarPSI			MIID
	16	3/8	20	25	25	1	SL-266R/LKF-202514-16	20	25.0	14.0	0	1	10	3.0	0.1	266.RL-16..
				.984	.984			.787	0.984	.551	.000		145			266.LL-16..
			25	32	25	1	SL-266R/LKF-252517-16	25	25.0	17.0	0	1	10	3.0	0.1	266.LL-16..
				1.259	.984			.984	0.984	.669	.000		145			266.LL-16..
			32	40	32	1	SL-266R/LKF-323222-16	32	32.0	22.0	0	1	10	3.0	0.1	266.LL-16..
				1.574	1.260			1.260	1.260	.866	.000		145			266.LL-16..
			40	50	32	1	SL-266R/LKF-403227-16	40	32.0	27.0	0	1	10	3.0	0.2	266.LL-16..
				1.968	1.260			1.575	1.260	1.063	.000		145			266.LL-16..
	22	1/2	25	32	28	1	SL-266R/LKF-252819-22	25	28.0	19.0	0	1	10	5.0	0.0	266.LL-22..
				1.259	1.102			.984	1.102	.748	.000		145			266.LL-22..
			32	40	32	1	SL-266R/LKF-323222-22	32	32.0	21.9	0	1	10	5.0	0.0	266.LL-22..
				1.574	1.260			1.260	1.260	.862	.000		145			266.LL-22..
			40	50	32	1	SL-266R/LKF-403227-22	40	32.0	26.9	0	1	10	5.0	0.1	266.LL-22..
				1.968	1.260			1.575	1.260	1.059	.000		145			266.LL-22..
	27	5/8	40	50	36	1	SL-266R/LKF-403627-27	40	36.0	26.9	0	1	10	7.5	0.1	266.LL-27..
				1.968	1.417			1.575	1.417	1.059	.000		145			266.LL-27..

N = Neutral, R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C4



I1



G1



I38



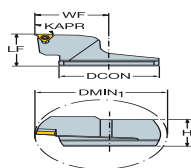
I33

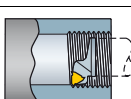
CoroTurn® SL



266 R/LL

PSIR 90°



								Dimensions, mm, inch										 			
	CZC _{MS}	D _{MIN} ₁	O _{HX}	C _{NSC}	Ordering code	D _{CON}	B _{D1}	H	L _F	W _F	H _F	THCA			MIID						
	16	3/8	80	100	45	0	SL-266R/LKF-80-16-QC	80	80	37	45.0	58.5	0	1	3.0	0.54	266.LL-16..				
				3.937	1.772				3.150	3.149	1.476	1.772	2.303	.000			266.RL-16..				
	22	1/2	80	100	45	0	SL-266RKF-80-22-QC	80	80	37	45.0	58.5	0	1	5.0	0.55	266.RL-22..				
				3.937	1.772				3.150	3.149	1.476	1.772	2.303	.000			266.RL-22..				
	27	5/8	80	100	45	0	SL-266RKF-80-27-QC	80	80	37	45.0	58.5	0	1	7.5	0.48	266.RL-27..				
				3.937	1.772				3.150	3.149	1.476	1.772	2.303	.000			266.RL-27..				

R = Right hand, L = Left hand

Angle of inclination (THCA) with different shims, see page C89



C4



11



G1



138



133

A

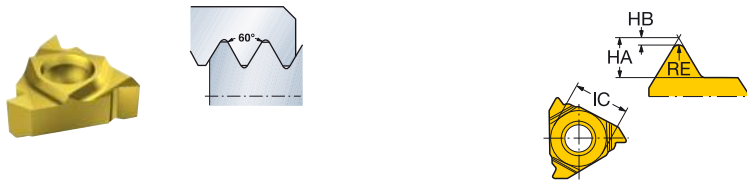
T-Max® U-Lock insert for thread turning

B

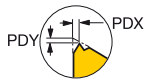
V-profile 60° Non-topping

NT

1



C



Internal right-hand threads

							Dimensions, mm, inch																				
							P	M	K	N	S	H															
		TPN	TPX	TPIN	TPIX	NT	Ordering code	1020	4125	1020	4125	1020	4125	1020	4125	1020	4125	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
11	1/4	1.00	2.00	24	12	1	R166.0L-11VM01-001	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.06	.002	1.45	.057	0.06	.002	0.90	.035	0.68	.026
						1	R166.0L-11VM01C001	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.06	.002	1.45	.057	0.06	.002	0.90	.035	0.68	.026

Internal left-hand threads

								P	M	K	N	S	H	Dimensions, mm, inch											
		TPN	TPX	TPIN	TPIX	NT	Ordering code	1020	1020	1020	1020	1020	1020	RE	RE*	HA	HA*	HB	HB*	PDX	PDX*	PDY	PDY*		
11	1/4	1.00	2.00	24	12	1	L166.0L-11VM01-001	☆	☆	☆	☆	☆	☆	0.06	.002	1.45	.057	0.06	.002	0.90	.035	0.06	.002		

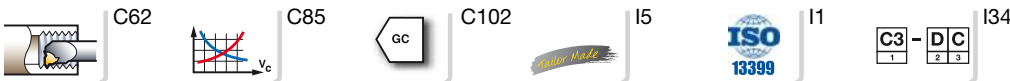
R = Right hand, L = Left hand

F

G

H

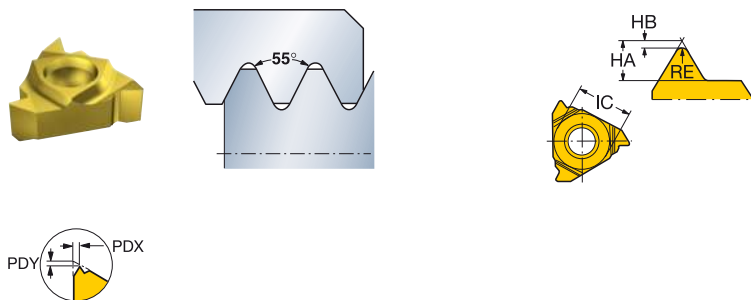
I



T-Max® U-Lock insert for thread turning

V-profile 55° Non-topping

NT 1



Internal right-hand threads

						P	M	K	N	S	H	Dimensions, mm, inch									
11	1/4	TPIN	TPIX	NT	Ordering code	1020	4125	1020	4125	1020	4125	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
11	1/4	28	14	1	R166.0L-11VW01-001	☆	☆	☆	☆	☆	☆	0.11	.004	1.60	.0630	0.12	.0047	0.95	.037	0.68	.026

Internal left-hand threads

						P	M	K	N	S	H	Dimensions, mm, inch									
11	1/4	TPIN	TPIX	NT	Ordering code	1020	4125	1020	4125	1020	4125	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
11	1/4	28	14	1	L166.0L-11VW01-001	☆	☆	☆	☆	☆	☆	0.11	.004	1.60	.0630	0.12	.0047	0.95	.037	0.12	.004

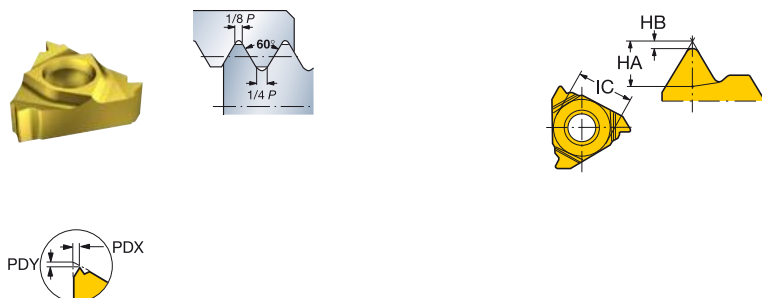
R = Right hand, L = Left hand



T-Max® U-Lock insert for thread turning

UN 60° Full form

THFTSR ISO 5864-1978
TCTR 2B
NT 1



Internal right-hand threads

								Dimensions, mm, inch							
								HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
		11	1/4	32.0	1	Ordering code		0.50	.0197	0.04	.0016	0.60	.023	0.68	.026
		28.0	1	R166.0L-11UN01-280	☆	☆	☆	0.58	.0228	0.05	.0020	0.80	.031	0.68	.026
		24.0	1	R166.0L-11UN01-240	☆	☆	☆	0.67	.0264	0.06	.0024	0.85	.033	0.68	.026
		20.0	1	R166.0L-11UN01-200	☆	☆	☆	0.80	.0315	0.07	.0028	0.90	.035	0.68	.026
		18.0	1	R166.0L-11UN01-180	☆	☆	☆	0.89	.0350	0.08	.0032	1.00	.039	0.68	.026
		16.0	1	R166.0L-11UN01-160	☆	☆	☆	1.00	.0394	0.09	.0035	1.00	.039	0.68	.026
		14.0	1	R166.0L-11UN01-140	☆	☆	☆	1.13	.0445	0.11	.0043	1.05	.041	0.68	.026

Internal left-hand threads

								Dimensions, mm, inch							
								HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
		28.0	1	L166.0L-11UN01-280	☆	☆	☆	0.58	.0228	0.05	.0020	0.80	.031	0.68	.026
		24.0	1	L166.0L-11UN01-240	☆	☆	☆	0.67	.0264	0.06	.0024	0.85	.033	0.68	.026
		20.0	1	L166.0L-11UN01-200	☆	☆	☆	0.80	.0315	0.07	.0028	0.90	.035	0.68	.026
		18.0	1	L166.0L-11UN01-180	☆	☆	☆	0.89	.0350	0.08	.0032	1.00	.039	0.68	.026
		16.0	1	L166.0L-11UN01-160	☆	☆	☆	1.00	.0394	0.09	.0035	1.00	.039	0.68	.026
		14.0	1	L166.0L-11UN01-140	☆	☆	☆	1.13	.0445	0.11	.0043	1.05	.041	0.68	.026

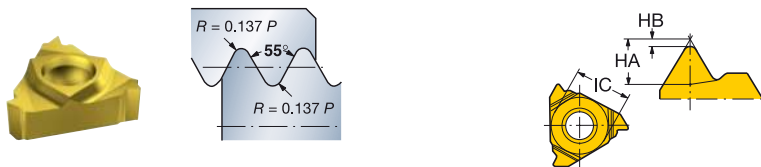
R = Right hand, L = Left hand



T-Max® U-Lock insert for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

THFTSR ISO 228-1982
THFTSR BS 2779-1973
THFTSR BS-84-1956
TCTR A
NT 1



Internal right-hand threads

				P	M	K	N	S	H	Dimensions, mm, inch							
	TPI	NT	Ordering code	1020	4125	1020	4125	1020	4125	1020	4125	1020	4125	HA	HA"	HB	HB"
				☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.99	.0390	0.17	.0067
11	1/4	20.0	R166.0L-11WH01-200	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.05	.0413	0.18	.0071
		19.0	R166.0L-11WH01-190	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.90	.035	0.68	.026
		14.0	R166.0L-11WH01-140	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	1.43	.0563	0.25	.0098

Internal left-hand threads

				P	M	K	N	S	H	Dimensions, mm, inch							
	TPI	NT	Ordering code	1020	1020	1020	1020	1020	1020	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"
				☆	☆	☆	☆	☆	☆	0.99	.0390	0.17	.0067	0.90	.035	0.68	.026
11	1/4	20.0	L166.0L-11WH01-200	☆	☆	☆	☆	☆	☆	1.05	.0413	0.18	.0071	0.90	.035	0.68	.026
		19.0	L166.0L-11WH01-190	☆	☆	☆	☆	☆	☆	1.43	.0563	0.25	.0098	1.05	.041	0.68	.026
		14.0	L166.0L-11WH01-140	☆	☆	☆	☆	☆	☆								

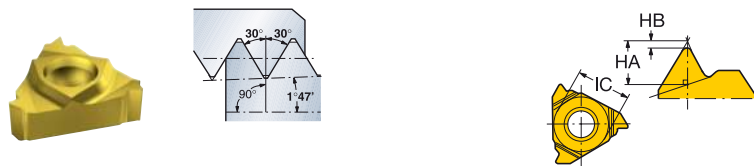
R = Right hand, L = Left hand



T-Max® U-Lock insert for thread turning

NPT 60° NPSC, NPTR, LINE PIPE Full form

THFTSR
NT
ANSI B.1.20.1-1983
1

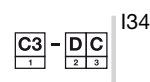
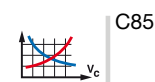
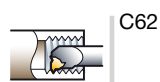


Internal threads

				P	M	K	N	S	H	Dimensions, mm, inch								
		TPI	NT	Ordering code	1020	1020	1020	1020	1020	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG
11	1/4	18.0	1	R166.0L-11NT01F180	☆	☆	☆	☆	☆	1.14	.0449	0.08	.0032	0.85	.033	0.67	.026	0.06
		14.0	1	R166.0L-11NT01F140	☆	☆	☆	☆	☆	1.46	.0575	0.09	.0035	0.95	.037	0.67	.026	0.06

The insert can give a slightly bigger truncation for LINE PIPE 14 t.p.i.

R = Right hand, L = Left hand



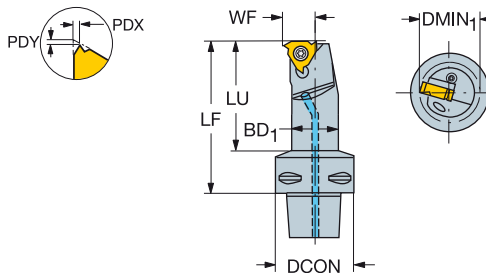
T-Max® U-Lock cutting unit for thread turning

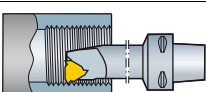
Screw clamp design

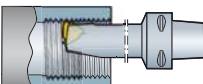
Coromant Capto® - Internal coolant supply



166.0L



								Ordering code	Dimensions, mm, inch									
	 IC	CZC _{MS}	DMIN ₁	LU	OHX	CNSC	DCON		BD ₁	LF	WF	HF	THCA	CP Bar/PSI			MIID	
	11	1/4	C3	20	33	50	1	C3-R/L166.0KF-12050-11	32	16	50.0	12.0	0	1	10	0.9	0.20	R166.0L-11..
				.787	1.299	1.969			1.260	.629	1.969	.472	.000		145			R166.0L-11..
			C4	20	37	60	1	C4-R/L166.0KF-12060-11	40	16	60.0	12.0	0	1	10	0.9	0.34	R166.0L-11..
				.787	1.457	2.362			1.575	.629	2.362	.472	.000		145			R166.0L-11..

								Ordering code	Dimensions, mm, inch									
	CZC _{MS}	DMIN ₁	LU	OHX	CNSC	DCON	BD ₁		LF	WF	HF	THCA	CP BarPSI			MIID		
	11	1/4	C3	20	33	50	1	C3-R166.0KFZ12050-11	32	16	50.0	12.0	0	1	10	0.9	0.13	R166.0L-11..
				.787	1.299	1.969			1.260	.629	1.969	.472	.000		145			R166.0L-11..
			C4	20	37	60	1	C4-R166.0KFZ12060-11	40	16	60.0	12.0	0	1	10	0.9	0.34	R166.0L-11..
				.787	1.457	2.362			1.575	.629	2.362	.472	.000		145			R166.0L-11..

R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89

Z = For upside down mounting



C56



I1



F16



I38

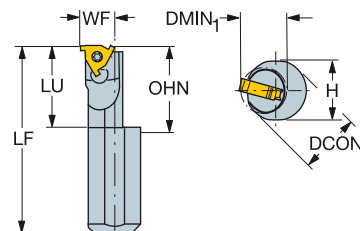
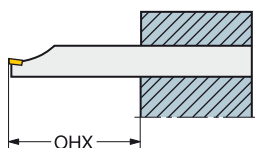


I33

T-Max® U-Lock boring bar for thread turning

Screw clamp design

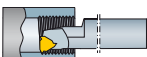
Cylindrical with flats



166.0L



Metric version

									Dimensions, mm										
		CZC _{MS}	DMIN ₁	LU	OHX	OHN	CNSC	Ordering code	DCON	H	LF	WF	HF	THCA			MIID		
	11	16	12	20	48	20	0	R/L166.0KF-16-1220-11B	16	15	125	10	0	2	0.9	0.186	R166.0L-11..		
		16	16	25	48	25	0	R/L166.0KF-16-1625-11B	16	15	150	10	0	2	0.9	0.220	L166.0L-11..		

Inch version

								Dimensions, inch											
		CZC _{MS}	DMIN	LU	OHX	OHN	CNSC	Ordering code	DCON	H	LF	WF	HF	THCA			MIID		
	1/4	5/8	.500	.818	1.875	.820	0	R/L166.0KF-D10-D0812-2B	.625	.570	5.000	.394	.000	2	0.66	.308	R166.0L-11..		
		5/8	.630	1.02	1.875	1.030	0	R166.0KF-D10-D1016-2B	.625	.562	6.000	.412	.000	2	0.66	.492	R166.0L-11..		

R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C56



I1



F16



I38

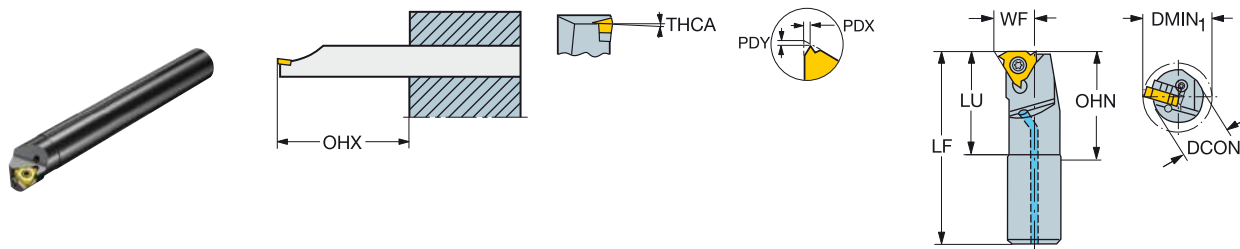


I34

T-Max® U-Lock boring bar for thread turning

Screw clamp design

Cylindrical with flats - Internal coolant supply

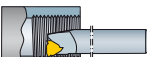


166.0L

Metric version

								Ordering code	Dimensions, mm								   MIID
	CZC _{MS}	DMIN ₁	LU	OHX	OHN	CNSC	DCON		LF	WF	HF	THCA	Bar	Nm	Kg		
	11	10	12	60	60	21	1	R166.0KF-10E-11	10	150	7	0	2	10	0.9	0.140	R166.0L-11..
		12	16	72	72	25	1	R166.0KF-12E-11	12	180	9	0	2	10	0.9	0.239	R166.0L-11..

Inch version

									Dimensions, inch										
		CZC _{MS}	DMIN	LU	OHX	OHN	CNSC		Ordering code	DCON	H	LF	WF	HF	THCA	 Ft/lbs	 Lbs		
	1/4	3/8	.500	2.25	2.250	.880	0	R/L166.0KF-D06C-2C	.375	.359	6.000	.295	.000	2	0.66	.308	R166.0L-11..		
		1/2	.630	3.00	3.000	.930	0	R/L166.0KF-D08C-2C	.500	.484	8.000	.354	.000	2	0.66	.805	R166.0L-11..		

R = Right hand, L = Left hand

For PDX/PDY values - see insert page.

For infeed recommendations, see page C91

Angle of inclination (THCA) with different shims, see page C89



C56



I1



F16



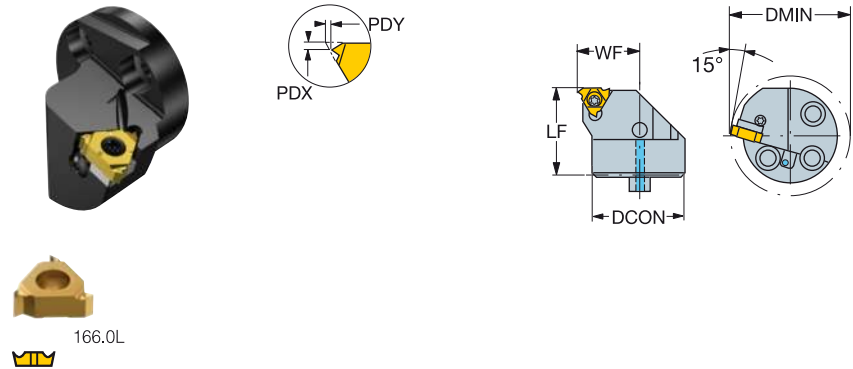
I38

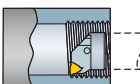


I34

T-Max® U-Lock head for thread turning

Screw clamp design
CoroTurn® SL - Internal coolant supply



							CZC _{MS}	DMIN _i	OHX	CNSC	Ordering code	Dimensions, mm, inch							
	11	1/4	16	20	20	0	R/L566.0KFC-162012-11	16	20.0	12.0	0	1				MIID			
				.787	.787			.630	.787	.472	.000		145			R166.0L-11..			
			20	25	20	1	R/L566.0KFC-202014-11	20	20.0	14.0	0	1	10	0.9	0.05	L166.0L-11..			
				.984	.787			.787	.787	.551	.000		145			L166.0L-11..			

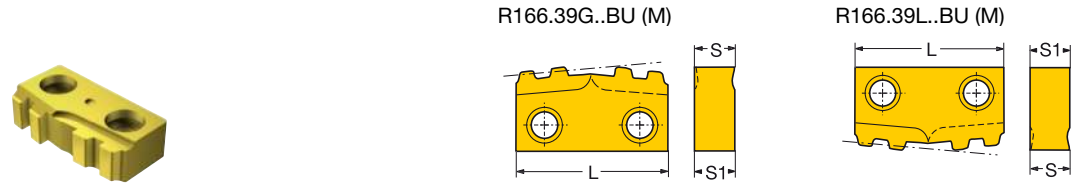
R = Right hand, L = Left hand

For PDX/PDY values - see insert page.
For infeed recommendations, see page C91
Angle of inclination (THCA) with different shims, see page C89



T-Max® Twin-Lock insert for thread turning

API round buttress



External right-hand threads

				P	M	K	S	H	Dimensions, mm, inch								
SSC	TPI	NT	Ordering code	1125	4125	4125	4125	4125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG
24	5.0	2	R166.39G-24BU12-050	☆	☆	☆	☆	☆	10.05	.3957	10.47	.4122	8.41	.331	12.00	.472	0.06
		2	R166.39G-24BU22-050	☆	☆	☆	☆	☆	12.06	.4748	10.60	.4173	8.14	.320	12.03	.473	0.08

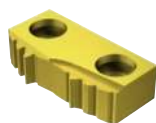
Internal right-hand threads

				P	M	K	S	H	Dimensions, mm, inch								
SSC	TPI	NT	Ordering code	1125	4125	4125	4125	4125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG
24	5.0	2	R166.39L-24BU12-050	☆	☆	☆	☆	☆	12.18	.4795	10.60	.4173	8.41	.331	12.02	.473	0.06
		2	R166.39L-24BU22-050	☆	☆	☆	☆	☆	12.04	.4740	10.62	.4181	8.41	.331	12.04	.474	0.08

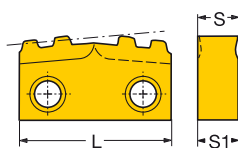


T-Max® Twin-Lock insert for thread turning

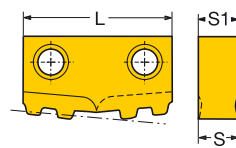
API round vee



R166.39G..RD (M)



R166.39L..RD (M)

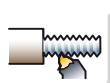


External right-hand threads

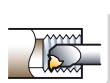
				P	M	K	S	H	Dimensions, mm, inch									
SSC	TPI	NT	Ordering code	1125	4125	4125	4125	4125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG	
24	10.0	3	R166.39G-24RD03-100	☆	☆	☆	☆	☆	1.76	.0693	0.36	.0142	6.87	.270	12.86	.506	0.06	
	8.0	3	R166.39G-24RD13-080	☆	☆	☆	☆	☆	2.23	.0878	0.43	.0169	10.34	.407	12.38	.487	0.06	

Internal right-hand threads

				P	M	K	S	H	Dimensions, mm, inch									
SSC	TPI	NT	Ordering code	1125	4125	4125	4125	4125	HA	HA"	HB	HB"	PDX	PDX"	PDY	PDY"	TG	
24	10.0	4	R166.39L-24RD04-100	☆	☆	☆	☆	☆	1.76	.0693	0.36	.0142	9.41	.370	12.09	.476	0.06	
	8.0	4	R166.39L-24RD04-080	☆	☆	☆	☆	☆	2.24	.0882	0.43	.0169	10.34	.407	12.38	.487	0.06	



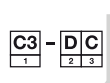
C68



C69



I1



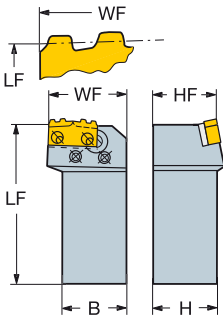
I34

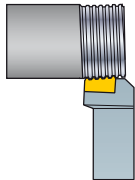
T-Max® Twin-Lock shank tool for thread turning

Lever clamp design



R166.39G/L



							Dimensions, mm, inch									
	SSC	SSC	CZC _{MS}	OHX	CNSC	Ordering code	B	H	LF	WF	HF	THCA			MIID	
	24	24	32 x 32	24	0	R166.39FG-3232-24	32	32	148.4	38.6	32	1	1.7	1.16	R166.39G-24..	
				.980			1.260	1.260	5.843	1.520	1.260				R166.39G-24..	

R = Right hand

For PDX/PDY values - see insert page.
 For infeed recommendations, see page C91
 Angle of inclination (THCA) with different shims, see page C89


C66


I1


F16


I38

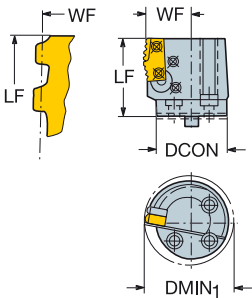

I34

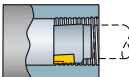
T-Max® Twin-Lock head for thread turning

Lever clamp design
CoroTurn® SL



R166.39G/L



							Dimensions, mm, inch							
	SSC	CZC _{MS}	DMIN ₁	OHX	CNSC	Ordering code	DCON	LF	WF	HF	THCA	 	MIID	
	24	40	60	44	0	R566.39KF-404527-24	40	44.2	25.8	0	1	1.7	0.39	R166.39L-24..
			2.374	1.740			1.575	1.740	1.016	.000				R166.39L-24..

R = Right hand

For PDX/PDY values - see insert page.
For infeed recommendations, see page C91
Angle of inclination (THCA) with different shims, see page C89


C66


I1


G1


I38

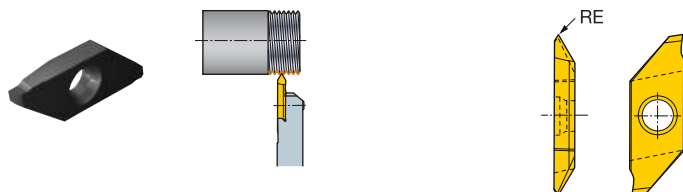

I34

CoroCut® XS insert for thread turning

Metric 60° fullform

THFTSR
TCTR
NT

ISO 965-1998
6
1

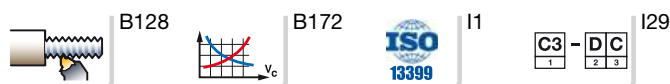


External right-hand threads

				P	M	N	S	Dimensions, mm, inch							
SSC	TP	NT	Ordering code	1105	1105	1105	1105	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"
3	0.20	1	MATR 3-MM01F-020-A	☆	☆	☆	☆	0.03	.001	5.19	.2043	2.76	.1087	1.90	.074
	0.25	1	MATR 3-MM01F-025-A	☆	☆	☆	☆	0.04	.002	0.15	.0059	0.03	.0012	0.28	.011
	0.30	1	MATR 3-MM01F-030-A	☆	☆	☆	☆	0.04	.002	0.18	.0071	0.04	.0016	0.28	.011
	0.35	1	MATR 3-MM01F-035-A	☆	☆	☆	☆	0.07	.003	0.31	.0122	0.07	.0028	0.48	.018
	0.40	1	MATR 3-MM01F-040-A	☆	☆	☆	☆	0.06	.002	0.25	.0098	0.05	.0020	0.38	.014
	0.45	1	MATR 3-MM01F-045-A	☆	☆	☆	☆	0.07	.003	0.28	.0110	0.07	.0028	0.38	.014
	0.50	1	MATR 3-MM01F-050-A	☆	☆	☆	☆	0.07	.003	0.28	.0110	0.07	.0028	0.38	.014

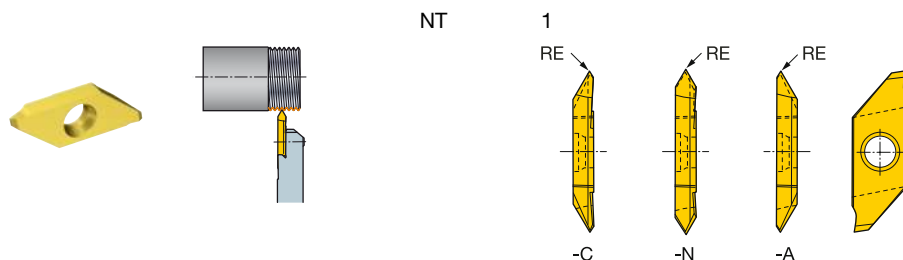
SSC = To correspond with SSC on holder.

R = Right hand



CoroCut® XS insert for thread turning

V-profile 60° Non-topping



External right-hand threads

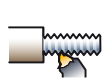
							P	M	N	S	Dimensions, mm, inch													
SSC	TPN	TPX	TPIN	TPIX	NT	Ordering code	1025	1105	1025	1105	1025	1105	H13A	1025	1105	H13A	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"
3	0.35	1.00	72	24	1	MATR 3 60-A	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.05	.002	0.75	.0295	0.05	.0020	0.60	.023
					1	MATR 3 60-C	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.05	.002	0.75	.0295	0.05	.0020	0.60	.023
		2.00		12	1	MATR 3 60-N	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.05	.002	1.50	.0591	0.05	.0020	1.59	.062

External left-hand threads

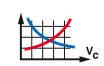
							P		M		N		S		Dimensions, mm, inch									
SSC	TPN	TPX	TPIN	TPIX	NT	Ordering code	1025	1105	1025	1105	1025	1105	H13A	1025	1105	H13A	RE	RE"	HA	HA"	HB	HB"	PDX	PDX"
3	0.35	1.00	72	24	1	MATL 3 60-A	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.05	.002	0.75	.0295	0.05	.0020	0.60	.023
					1	MATL 3 60-C	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.05	.002	0.75	.0295	0.05	.0020	0.60	.023
		2.00		12	1	MATL 3 60-N	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	0.05	.002	1.50	.0591	0.05	.0020	1.59	.062

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand



B128



B172



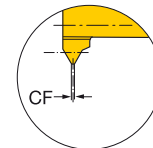
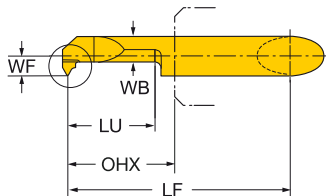
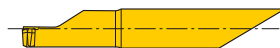
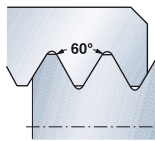
I1



I29

CoroTurn® XS solid carbide tool for thread turning

V-profile 60° Non-topping



Internal right-hand threads

									P	M	N	S	H	Dimensions, mm, inch							
CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	7015		DCON	CF	LF	WF	LPR	WB	HA	HB
4	0.50	0.50	56	48	4	15	17.6	CXS-04TH050VM-4215R	☆	☆	☆	☆		4	0.06	32.3	2.0	32.7	2.9	0.45	0.05
					.165	.591	.693							.157	.0023	1.272	.077	1.287	.116	.017	.001
5	0.50	0.50	56	48	5	15	17.5	CXS-05TH050VM-5215R	☆	☆	☆	☆		5	0.06	37.3	2.5	37.7	3.7	0.48	0.05
					.205	.591	.692							.197	.0023	1.469	.096	1.485	.147	.018	.001
	0.70	0.75	56	48	5	15	17.5	CXS-05TH070VM-5115R	☆	☆	☆	☆		5	0.09	37.3	2.4	37.7	3.6	0.65	0.08
					.201	.591	.691							.197	.0035	1.469	.093	1.486	.143	.025	.003
	1.00	1.00	40	36	4	15	17.4	CXS-05TH100VM-4815R	☆	☆	☆	☆		5	0.12	37.3	2.3	37.8	3.5	0.80	0.10
					.189	.591	.687							.197	.0047	1.469	.089	1.490	.139	.031	.003
6	1.00	1.00	40	36	6	15	17.4	CXS-06TH100VM-6215R	☆	☆	☆	☆	☆	6	0.12	37.3	3.0	37.8	3.5	0.80	0.10
					.244	.591	.687							.236	.0047	1.469	.116	1.490	.139	.031	.003
	1.25	1.15	20	20	6	15	17.1	CXS-06TH125VM-6215R	☆	☆	☆	☆		6	0.15	37.3	3.0	38.1	3.5	0.97	0.13
					.244	.591	.676							.236	.0059	1.469	.116	1.501	.139	.038	.005
	1.50	1.50	18	16	6	15	17.1	CXS-06TH150VM-6215R	☆	☆	☆	☆	☆	6	0.18	37.3	3.0	38.2	3.5	1.14	0.16
					.244	.591	.676							.236	.0070	1.469	.116	1.507	.139	.044	.006

Internal left-hand threads

									P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	WB	HA	HB
4	0.50	0.50	56	48	4	15	17.6	CXS-04TH050VM-4215L	☆	☆	☆	☆	4	0.06	32.3	2.0	32.7	2.9	0.45	0.05
					.165	.591	.693						.157	.0023	1.272	.077	1.287	.116	.017	.001
5	1.00	1.00	40	36	4	15	17.4	CXS-05TH100VM-4815L	☆	☆	☆	☆	5	0.12	37.3	2.3	37.8	3.5	0.80	0.10
					.189	.591	.687						.197	.0047	1.469	.089	1.490	.139	.031	.003
6	1.00	1.00	40	36	6	15	17.4	CXS-06TH100VM-6215L	☆	☆	☆	☆	6	0.12	37.3	3.0	37.8	3.5	0.80	0.10
					.244	.591	.687						.236	.0047	1.469	.116	1.490	.139	.031	.003
	1.25	1.25	20	20	6	15	17.1	CXS-06TH125VM-6215L	☆	☆	☆	☆	6	0.15	37.3	3.0	38.1	3.5	0.97	0.13
					.244	.591	.676						.236	.0059	1.469	.116	1.501	.139	.038	.005
	1.50	1.50	18	16	6	15	17.1	CXS-06TH150VM-6215L	☆	☆	☆	☆	6	0.18	37.3	3.0	38.2	3.5	1.14	0.16
					.244	.591	.676						.236	.0070	1.469	.116	1.507	.139	.044	.006

CZC_{MS} to correspond with CZC_{WS} on holder

R = Right hand, L = Left hand



A566



I1



G2

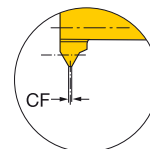
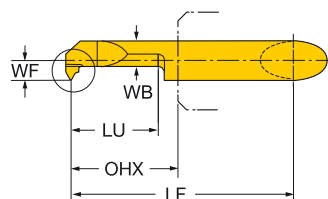
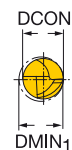
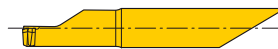
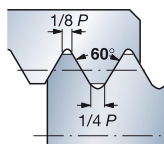


I19

CoroTurn® XS solid carbide tool for thread turning

Metric 60° Full form

TCTR 6



Internal right-hand threads

						P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TP	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	WB	HA	HB
4	0.50	4	15	17.6	CXS-04TH050MM-4215R	☆	☆	☆	☆	4	0.06	32.3	2.0	32.7	3.4	0.45	0.05
		.165	.591	.693					.157	.0023	1.272	.077	1.287	.135	.017	.001	
	0.70	4	15	17.5	CXS-04TH070MM-4215R	☆	☆	☆	☆	4	0.08	32.3	1.9	32.8	3.2	0.77	0.07
	0.65	.165	.591	.689						.157	.0031	1.272	.075	1.291	.127	.030	.002
		0.80	4	15	17.5	CXS-04TH080MM-4015R	☆	☆	☆	☆	4	0.10	32.3	1.9	32.8	3.0	0.84
	.157	.591	.689						.157	.0039	1.272	.073	1.291	.118	.033	.003	
5	0.50	5	15	17.6	CXS-05TH050MM-5215R	☆	☆	☆	☆	5	0.06	37.3	2.5	37.7	4.4	0.45	0.05
		.205	.591	.693					.197	.0023	1.469	.096	1.484	.175	.017	.001	
	0.75	5	15	17.5	CXS-05TH075MM-5115R	☆	☆	☆	☆	5	0.09	37.3	2.4	37.8	4.1	0.78	0.08
	0.70	.201	.591	.689						.197	.0035	1.469	.094	1.488	.163	.030	.003
		1.00	4	15	17.4	CXS-05TH100MM-4815R	☆	☆	☆	☆	5	0.12	37.3	2.3	37.9	3.5	1.00
	.189	.591	.685						.197	.0047	1.469	.089	1.492	.139	.039	.003	
6	1.00	6	15	17.4	CXS-06TH100MM-6215R	☆	☆	☆	☆	6	0.12	37.3	3.0	37.9	5.0	1.00	0.10
		.244	.591	.685					.236	.0047	1.469	.116	1.492	.198	.039	.003	
	1.25	6	15	17.3	CXS-06TH125MM-6215R	☆	☆	☆	☆	6	0.15	37.3	3.0	38.0	4.8	1.28	0.13
	1.20	.244	.591	.681						.236	.0059	1.469	.116	1.496	.188	.050	.005
		1.50	6	15	17.2	CXS-06TH150MM-6215R	☆	☆	☆	☆	6	0.18	37.3	3.0	38.1	4.5	1.61
	.244	.591	.677						.236	.0070	1.469	.116	1.500	.177	.063	.006	
	1.75	6	15	17.1	CXS-06TH175MM-6215R	☆	☆	☆	☆	6	0.21	37.3	3.0	38.2	4.3	1.83	0.18
		.244	.591	.673						.236	.0082	1.469	.116	1.503	.169	.072	.007
	2.00	6	15	17.0	CXS-06TH200MM-6215R	☆	☆	☆	☆	6	0.25	37.3	3.0	38.3	4.1	2.07	0.22
	2.00	.244	.591	.669						.236	.0098	1.469	.116	1.507	.161	.081	.008

CZC_{MS} to correspond with CZC_{WS} on holder

R = Right hand, L = Left hand



A566



I1



G2

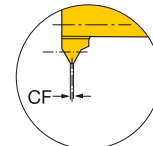
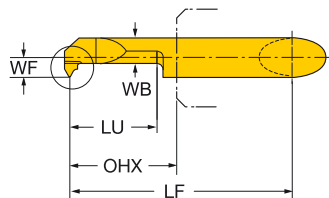
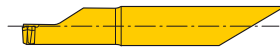
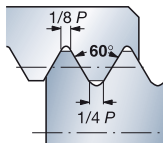


I19

CoroTurn® XS solid carbide tool for thread turning

UN 60° Full form

TCTR 2B



Internal right-hand threads

					P	M	N	S	Dimensions, mm, inch									
CZC _{MS}	TPI	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	WB	HA	HB	
4	32	4	15	17.4	CXS-04TH320UN-4015R	☆	☆	☆	☆	4	0.10	32.3	1.9	32.8	2.9	0.89	0.09	
		.157	.591	.687						.157	.0039	1.272	.073	1.293	.116	.035	.003	
	28	4	15	17.4	CXS-04TH280UN-4015R	☆	☆	☆	☆	4	0.11	32.3	1.9	32.9	2.9	0.90	0.10	
		.157	.591	.685						.157	.0043	1.272	.073	1.295	.116	.035	.003	
24	4	15	17.3	17.3	CXS-04TH240UN-4215R	☆	☆	☆	☆	4	0.13	32.3	2.0	32.9	3.0	1.01	0.11	
		.165	.591	.683						.157	.0051	1.272	.077	1.297	.120	.039	.004	
	5	5	15	17.3	CXS-05TH200UN-5215R	☆	☆	☆	☆	5	0.16	37.3	2.5	38.0	3.9	1.13	0.13	
		.205	.591	.681						.197	.0062	1.469	.096	1.496	.155	.044	.005	
6	18	6	15	17.2	CXS-06TH180UN-6215R	☆	☆	☆	☆	6	0.18	37.3	2.5	38.0	4.8	1.25	0.15	
		.244	.591	.679						.236	.0070	1.469	.096	1.498	.190	.049	.005	
	16	6	15	15.1	CXS-06TH160UN-6215R	☆	☆	☆	☆	6	0.20	37.3	3.0	38.1	4.7	1.36	0.16	
		.244	.591	.596						.236	.0078	1.469	.116	1.501	.187	.053	.006	

CZC_{MS} to correspond with CZC_{WS} on holder

R = Right hand, L = Left hand



A566



I1



G2

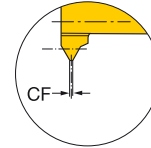
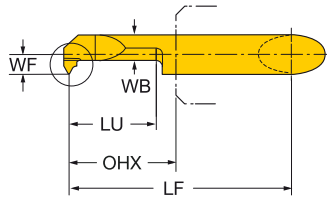
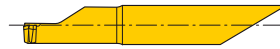
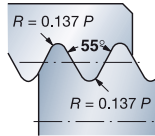


I19

CoroTurn® XS solid carbide tool for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

TCTR A



Internal right-hand threads

						P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	1025	DCON	RE	LF	WF	LPR	WB	HA	HB
5	28	5	15	17.2	CXS-05TH28WH-5215R	☆	☆	☆	☆	5	0.10	37.3	2.5	38.1	3.7	0.73	0.14
		.205	.591	.677						.197	.005	1.469	.096	1.500	.147	.028	.005
	26	5	15	17.2	CXS-05TH26WH-5215R	☆	☆	☆	☆	5	0.20	37.3	2.5	38.1	3.7	0.78	0.16
		.205	.591	.677						.197	.006	1.469	.096	1.500	.147	.030	.006
	24	5	15	17.2	CXS-05TH24WH-5215R	☆	☆	☆	☆	5	0.20	37.3	2.5	38.1	3.7	0.85	0.17
		.205	.591	.677						.197	.006	1.469	.096	1.500	.147	.033	.006
6	28	6	15	17.2	CXS-06TH28WH-6215R	☆	☆	☆	☆	6	0.10	37.3	3.0	38.1	3.9	0.73	0.14
		.244	.591	.677						.236	.005	1.469	.116	1.500	.155	.028	.005
	26	6	15	17.2	CXS-06TH26WH-6215R	☆	☆	☆	☆	6	0.10	37.3	3.0	38.1	3.9	0.78	0.16
		.244	.591	.677						.236	.005	1.469	.116	1.500	.155	.030	.006
	24	6	15	17.2	CXS-06TH24WH-6215R	☆	☆	☆	☆	6	0.20	37.3	3.0	38.1	3.9	0.85	0.17
		.244	.591	.677						.236	.006	1.469	.116	1.500	.155	.033	.006
	22	6	15	17.0	CXS-06TH22WH-6215R	☆	☆	☆	☆	6	0.20	37.3	3.0	38.3	3.9	0.92	0.18
		.244	.591	.669						.236	.006	1.469	.116	1.507	.155	.036	.007
	20	6	15	17.0	CXS-06TH20WH-6215R	☆	☆	☆	☆	6	0.20	37.3	3.0	38.3	3.9	1.02	0.20
		.244	.591	.669						.236	.007	1.469	.116	1.507	.155	.040	.007
	19	6	15	17.0	CXS-06TH19WH-6215R	☆	☆	☆	☆	6	0.20	37.3	3.0	38.3	3.9	1.07	0.21
		.244	.591	.669						.236	.007	1.469	.116	1.507	.155	.042	.008

Internal left-hand threads

						P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	1025	DCON	RE	LF	WF	LPR	WB	HA	HB
6	19	6	15	17.0	CXS-06TH19WH-6215L	☆	☆	☆	☆	6	0.20	37.3	3.0	38.3	3.9	1.07	0.21
		.244	.591	.669						.236	.007	1.469	.116	1.507	.155	.042	.008

CZC_{MS} to correspond with CZC_{WS} on holder

R = Right hand, L = Left hand



A566



I1



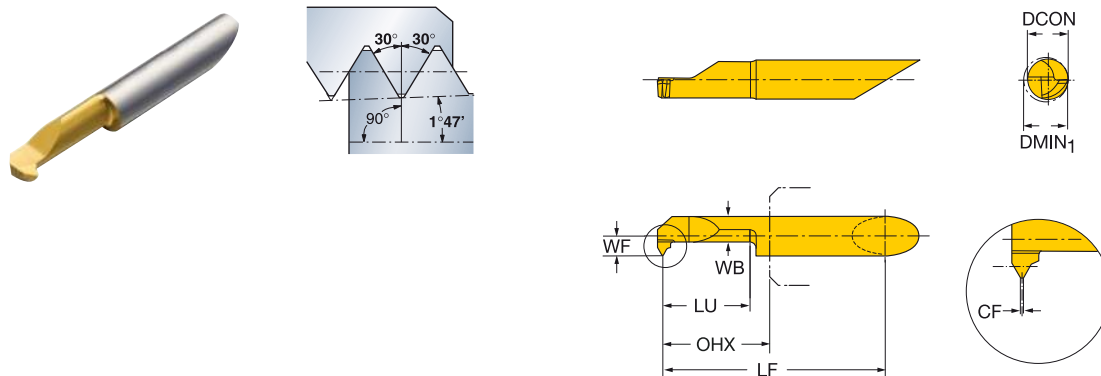
G2



I19

CoroTurn® XS solid carbide tool for thread turning

NPT 60° NPSC, NPTR, LINE PIPE Full form



Internal right-hand threads

						P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	1025	DCON	RE	LF	WF	LPR	WB	HA	HB
6	27	6	15	17.2	CXS-06TH27NT-6215R	☆	☆	☆	☆	6	0.10	37.3	3.0	38.1	3.9	1.63	0.03
		.244	.591	.677						.236	.003	1.469	.116	1.500	.155	.064	.001
18	6	15	17.2		CXS-06TH18NT-6215R	☆	☆	☆	☆	6	0.10	37.3	3.0	38.3	3.9	1.64	0.04
		.244	.591	.677						.236	.004	1.469	.116	1.507	.155	.064	.001

Internal left-hand threads

						P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	1025	DCON	RE	LF	WF	LPR	WB	HA	HB
6	18	6	15	17.0	CXS-06TH18NT-6215L	☆	☆	☆	☆	6	0.10	37.3	3.0	38.3	3.9	1.64	0.04
		.244	.591	.669						.236	.004	1.469	.116	1.507	.155	.064	.001

CZC_{MS} to correspond with CZC_{WS} on holder

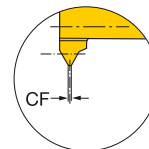
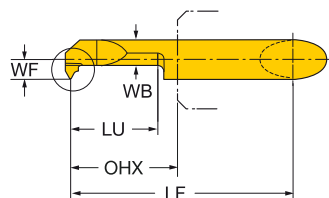
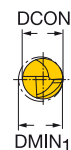
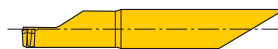
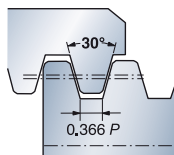
R = Right hand, L = Left hand



CoroTurn® XS solid carbide tool for thread turning

ISO Trapezoidal 30° Chamfered crest form

TCTR 7



Internal right-hand threads

						P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TP	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	WB	HA	HB
6	1.50	6	20	17.4	CXS-06TH150TR-6220R	☆	☆	☆	☆	6	0.47	37.6	3.0	38.2	4.9	1.81	0.91
		.244	.787	.685						.236	.0185	1.480	.116	1.503	.192	.071	.035
	2.00	6	20	17.2	CXS-06TH200TR-6220R	☆	☆	☆	☆	6	0.60	37.6	3.0	38.3	4.5	2.41	1.16
7	3.00	7	30	16.9	CXS-07TH300TR-7230R	☆	☆	☆	☆	7	0.96	52.3	3.5	53.3	4.5	3.54	1.79
		.283	1.181	.665						.276	.0377	2.057	.136	2.100	.179	.139	.070

CZC_{MS} to correspond with CZC_{WS} on holder

R = Right hand, L = Left hand



A566



I1



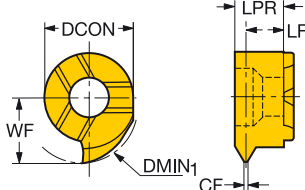
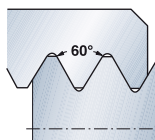
G2



I19

CoroCut® MB solid carbide head for thread turning

V-profile 60° Non-topping



Internal right-hand threads

								P	M	N	S	Dimensions, mm, inch						
CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	HA	HB
07	0.50	0.75	48	32	10	3.4	MB-07TH050VM-10R	☆	☆	☆	☆	7	0.06	3.4	5.8	3.8	0.45	0.05
					.394	.134						.276	.0023	.134	.228	.149	.017	.001
	1.00	1.25	28	24	10	3.2	MB-07TH100VM-10R	☆	☆	☆	☆	7	0.12	3.2	5.8	3.8	0.80	0.10
					.394	.126						.276	.0047	.126	.228	.149	.031	.003
	1.50	1.75	20	16	10	3.0	MB-07TH150VM-10R	☆	☆	☆	☆	7	0.18	3.0	5.8	3.8	1.13	0.16
					.394	.118						.276	.0070	.118	.228	.149	.044	.006
	2.00	2.25	14	12	10	2.7	MB-07TH200VM-10R	☆	☆	☆	☆	7	0.25	2.8	5.8	3.8	1.63	0.22
					.394	.108						.276	.0098	.108	.228	.149	.064	.008
	2.50	2.50	11	10	10	2.5	MB-07TH250VM-10R	☆	☆	☆	☆	7	0.31	2.6	5.8	3.8	1.95	0.27
					.394	.100						.276	.0122	.100	.228	.149	.076	.010

Internal left-hand threads

								P	M	N	S	Dimensions, mm, inch						
CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	HA	HB
07	0.50	0.75	48	32	10	3.4	MB-07TH050VM-10L	☆	☆	☆	☆	7	0.06	3.4	5.8	3.8	0.45	0.05
					.394	.134						.276	.0023	.134	.228	.149	.017	.001
	1.00	1.25	28	24	10	3.2	MB-07TH100VM-10L	☆	☆	☆	☆	7	0.12	3.2	5.8	3.8	0.80	0.10
					.394	.126						.276	.0047	.126	.228	.149	.031	.003
	1.50	1.75	20	16	10	3.0	MB-07TH150VM-10L	☆	☆	☆	☆	7	0.18	3.0	5.8	3.8	1.13	0.16
					.394	.118						.276	.0070	.118	.228	.149	.044	.006
	2.00	2.25	14	12	10	2.7	MB-07TH200VM-10L	☆	☆	☆	☆	7	0.25	2.8	5.8	3.8	1.63	0.22
					.394	.108						.276	.0098	.108	.228	.149	.064	.008
	2.50	2.50	11	10	10	2.5	MB-07TH250VM-10L	☆	☆	☆	☆	7	0.31	2.6	5.8	3.8	1.95	0.27
					.394	.100						.276	.0122	.100	.228	.149	.076	.010

To correspond to insert size on holder

R = Right hand, L = Left hand



B173



I1



G2

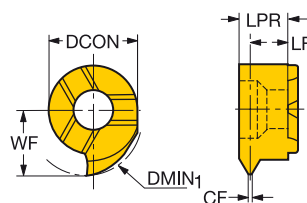
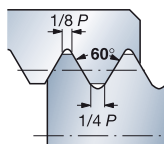
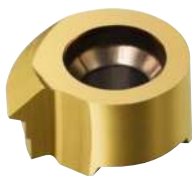


I30

CoroCut® MB solid carbide head for thread turning

Metric 60° Full form

TCTR 6



Internal right-hand threads

CZC _{MS}	TP	DMIN ₁	OHX	Ordering code	P M N S H					Dimensions, mm, inch						
					1025	1025	1025	1025	7015	DCON	CF	LF	WF	LPR	HA	HB
07	0.50	10	3.4	MB-07TH050MM-10R	☆	☆	☆	☆	☆	7	0.06	3.4	5.8	3.8	0.45	0.05
										.276	.0023	.134	.228	.149	.017	.001
	1.00	10	3.2	MB-07TH100MM-10R	☆	☆	☆	☆	☆	7	0.12	3.2	5.8	3.8	0.90	0.10
										.276	.0047	.126	.228	.149	.035	.003
	1.50	10	3.0	MB-07TH150MM-10R	☆	☆	☆	☆	☆	7	0.18	3.0	5.8	3.8	1.36	0.16
										.276	.0070	.118	.228	.149	.053	.006
	1.75	10	2.9	MB-07TH175MM-10R	☆	☆	☆	☆	☆	7	0.21	2.9	5.8	3.8	1.13	0.18
										.276	.0082	.114	.228	.149	.044	.007
	2.00	10	2.7	MB-07TH200MM-10R	☆	☆	☆	☆	☆	7	0.25	2.8	5.8	3.8	1.30	0.22
										.276	.0098	.108	.228	.149	.051	.008
	2.50	10	2.5	MB-07TH250MM-10R	☆	☆	☆	☆	☆	7	0.31	2.6	5.8	3.8	1.62	0.27
										.276	.0122	.100	.228	.149	.063	.010

Internal left-hand threads

CZC _{MS}	TP	DMIN ₁	OHX	Ordering code	P M N S					Dimensions, mm, inch						
					1025	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	HA	HB
07	0.50	10	3.4	MB-07TH050MM-10L	☆	☆	☆	☆	☆	7	0.06	3.4	5.8	3.8	0.45	0.05
										.276	.0023	.134	.228	.149	.017	.001
	1.00	10	3.2	MB-07TH100MM-10L	☆	☆	☆	☆	☆	7	0.12	3.2	5.8	3.8	0.90	0.10
										.276	.0047	.126	.228	.149	.035	.003
	1.50	10	3.0	MB-07TH150MM-10L	☆	☆	☆	☆	☆	7	0.18	3.0	5.8	3.8	1.36	0.16
										.276	.0070	.118	.228	.149	.053	.006
	1.75	10	2.9	MB-07TH175MM-10L	☆	☆	☆	☆	☆	7	0.21	2.9	5.8	3.8	1.13	0.18
										.276	.0082	.114	.228	.149	.044	.007
	2.00	10	2.7	MB-07TH200MM-10L	☆	☆	☆	☆	☆	7	0.25	2.8	5.8	3.8	1.30	0.22
										.276	.0098	.108	.228	.149	.051	.008
	2.50	10	2.5	MB-07TH250MM-10L	☆	☆	☆	☆	☆	7	0.31	2.6	5.8	3.8	1.62	0.27
										.276	.0122	.100	.228	.149	.063	.010

To correspond to insert size on holder

R = Right hand, L = Left hand



B173



I1



G2

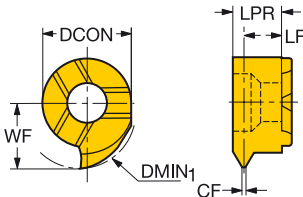
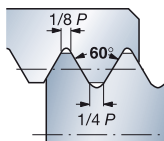
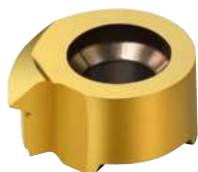


I30

CoroCut® MB solid carbide head for thread turning

UN 60° Full form

TCTR 2B



Internal right-hand threads

					P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	HA	HB	
07	32	10	3.4	MB-07TH320UN-10R	☆	☆	☆	☆	7	0.10	3.4	5.8	3.8	0.89	0.09	
		.394	.134						.276	.0039	.134	.228	.149	.035	.003	
	28	10	3.4	MB-07TH280UN-10R	☆	☆	☆	☆	7	0.11	3.4	5.8	3.8	0.90	0.10	
		.394	.134						.276	.0043	.134	.228	.149	.035	.003	
	24	10	3.3	MB-07TH240UN-10R	☆	☆	☆	☆	7	0.13	3.3	5.8	3.8	1.01	0.11	
		.394	.130						.276	.0051	.130	.228	.149	.039	.004	
	20	10	3.2	MB-07TH200UN-10R	☆	☆	☆	☆	7	0.15	3.2	5.8	3.8	1.13	0.13	
		.394	.126						.276	.0059	.126	.228	.149	.044	.005	
	18	10	3.2	MB-07TH180UN-10R	☆	☆	☆	☆	7	0.17	3.2	5.8	3.8	1.25	0.15	
		.394	.126						.276	.0066	.126	.228	.149	.049	.005	
	16	10	3.1	MB-07TH160UN-10R	☆	☆	☆	☆	7	0.19	3.1	5.8	3.8	1.36	0.16	
		.394	.122						.276	.0074	.122	.228	.149	.053	.006	
	14	10	3.2	MB-07TH140UN-10R	☆	☆	☆	☆	7	0.22	3.2	5.8	3.8	1.59	0.19	
		.394	.126						.276	.0086	.126	.228	.149	.062	.007	

Internal left-hand threads

					P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	HA	HB	
07	32	10	3.4	MB-07TH320UN-10L	☆	☆	☆	☆	7	0.10	3.4	5.8	3.8	0.89	0.09	
		.394	.134						.276	.0039	.134	.228	.149	.035	.003	
	28	10	3.4	MB-07TH280UN-10L	☆	☆	☆	☆	7	0.11	3.4	5.8	3.8	0.90	0.10	
		.394	.134						.276	.0043	.134	.228	.149	.035	.003	
	24	10	3.3	MB-07TH240UN-10L	☆	☆	☆	☆	7	0.13	3.3	5.8	3.8	1.01	0.11	
		.394	.130						.276	.0051	.130	.228	.149	.039	.004	
	20	10	3.2	MB-07TH200UN-10L	☆	☆	☆	☆	7	0.15	3.2	5.8	3.7	1.13	0.13	
		.394	.126						.276	.0059	.126	.228	.145	.044	.005	
	18	10	3.2	MB-07TH180UN-10L	☆	☆	☆	☆	7	0.17	3.2	5.8	3.8	1.25	0.15	
		.394	.126						.276	.0066	.126	.228	.149	.049	.005	
	16	10	3.1	MB-07TH160UN-10L	☆	☆	☆	☆	7	0.19	3.1	5.8	3.8	1.36	0.16	
		.394	.122						.276	.0074	.122	.228	.149	.053	.006	
	14	10	3.2	MB-07TH140UN-10L	☆	☆	☆	☆	7	0.22	3.2	5.8	3.8	1.59	0.19	
		.394	.126						.276	.0086	.126	.228	.149	.062	.007	

To correspond to insert size on holder

R = Right hand, L = Left hand



B173



I1



G2

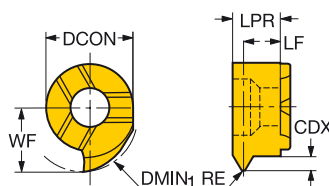
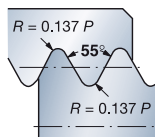
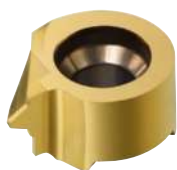


I30

CoroCut® MB solid carbide head for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

TCTR A



Internal right-hand threads

					P	M	N	S	Dimensions, mm, inch						
CZC _{MS}	TPI	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	RE	LF	WF	LPR	HA	HB
07	19	10	2.8	MB-07TH190WH-10R	☆	☆	☆	☆	7	0.20	2.8	5.8	3.8	1.06	0.21
		.394	.110						.276	.007	.110	.228	.149	.041	.008
	14	10	2.6	MB-07TH140WH-10R	☆	☆	☆	☆	7	0.20	2.6	5.8	3.8	1.44	0.28
		.394	.102						.276	.009	.102	.228	.149	.056	.011
	11	10	2.3	MB-07TH110WH-10R	☆	☆	☆	☆	7	0.30	2.3	5.8	3.8	1.84	0.36
		.394	.091						.276	.012	.091	.228	.149	.072	.014

Internal left-hand threads

					P	M	N	S	Dimensions, mm, inch						
CZC _{MS}	TPI	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	RE	LF	WF	LPR	HA	HB
07	19	10	2.8	MB-07TH190WH-10L	☆	☆	☆	☆	7	0.20	2.8	5.8	3.8	1.06	0.21
		.394	.110						.276	.007	.110	.228	.149	.041	.008
	14	10	2.6	MB-07TH140WH-10L	☆	☆	☆	☆	7	0.20	2.6	5.8	3.8	1.44	0.28
		.394	.102						.276	.009	.102	.228	.149	.056	.011
	11	10	2.3	MB-07TH110WH-10L	☆	☆	☆	☆	7	0.30	2.3	5.8	3.8	1.84	0.36
		.394	.091						.276	.012	.091	.228	.149	.072	.014

To correspond to insert size on holder

R = Right hand, L = Left hand



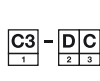
B173



I1



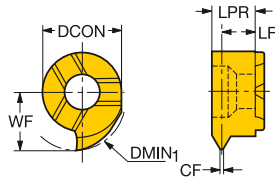
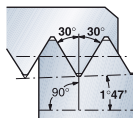
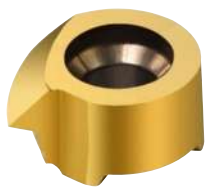
G2



I30

CoroCut® MB solid carbide head for thread turning

NPT 60° NPSC, NPTR, LINE PIPE Full form



Internal right-hand threads

					P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	RE	LF	WF	LPR	HA	HB	
07	18	10	2.9	MB-07TH180NT-10R	☆	☆	☆	☆	7	0.10	2.9	5.8	3.8	1.44	0.04	
		.394	.114						.276	.002	.114	.228	.149	.056	.001	
	14	10	2.9	MB-07TH140NT-10R	☆	☆	☆	☆	7	0.10	2.7	5.8	3.8	1.54	0.06	
		.394	.114						.276	.003	.106	.228	.149	.060	.002	
					P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	RE	LF	WF	LPR	HA	HB	
07	18	10	2.9	MB-07TH180NT-10L	☆	☆	☆	☆	7	0.10	2.9	5.8	3.8	1.44	0.04	
		.394	.114						.276	.002	.114	.228	.149	.056	.001	
	14	10	2.7	MB-07TH140NT-10L	☆	☆	☆	☆	7	0.10	2.7	5.8	3.8	1.54	0.06	
		.394	.106						.276	.003	.106	.228	.149	.060	.002	

To correspond to insert size on holder

R = Right hand, L = Left hand



B173



I1



G2

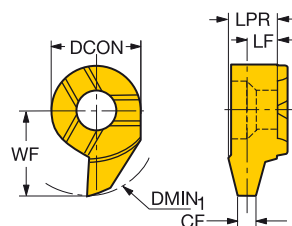
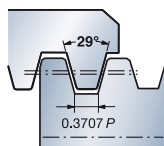


I30

CoroCut® MB solid carbide head for thread turning

ACME 29° partial profile

TCTR 2G



External right-hand threads

					P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	HA	HB	
07	16	11	3.3	MB-07TH160AC-11R	☆	☆	☆	☆	7	0.52	3.3	6.8	3.9	2.06	1.01	
									.276	.0204	.130	.268	.153	.081	.039	
	14	11	3.2	MB-07TH140AC-11R	☆	☆	☆	☆	7	0.60	3.2	6.8	3.9	2.33	1.16	
									.276	.0236	.126	.268	.153	.091	.045	
	12	11	3.1	MB-07TH120AC-11R	☆	☆	☆	☆	7	0.71	3.1	6.8	3.9	2.69	1.37	
									.276	.0279	.122	.268	.153	.105	.053	
	10	11	3.0	MB-07TH100AC-11R	☆	☆	☆	☆	7	0.80	3.0	6.8	3.9	3.33	1.55	
									.276	.0314	.118	.268	.153	.131	.061	
	8	11	2.8	MB-07TH080AC-11R	☆	☆	☆	☆	7	1.03	2.8	6.8	3.9	4.09	1.99	
									.276	.0405	.110	.268	.153	.161	.078	

To correspond to insert size on holder

R = Right hand, L = Left hand



B173



I1



G2

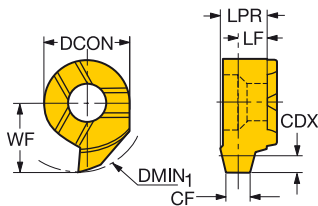
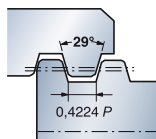


I30

CoroCut® MB solid carbide head for thread turning

STUB-ACME 29° partial profile

TCTR 2G



Internal right-hand threads

					P	M	N	S	Dimensions, mm, inch							
CZC _{MS}	TPI	DMIN ₁	OHX	Ordering code	1025	1025	1025	1025	DCON	CF	LF	WF	LPR	HA	HB	
07	16	10	3.3	MB-07TH160SA-10R	☆	☆	☆	☆	7	0.59	3.4	5.8	4.0	1.88	1.14	
		.394	.132						.276	.0232	.132	.228	.157	.074	.044	
	14	10	3.2	MB-07TH140SA-10R	☆	☆	☆	☆	7	0.69	3.3	5.8	4.0	2.15	1.33	
		.394	.128						.276	.0271	.128	.228	.157	.084	.052	
	12	10	3.2	MB-07TH120SA-10R	☆	☆	☆	☆	7	0.82	3.2	5.8	4.0	2.51	1.59	
		.394	.126						.276	.0322	.126	.228	.157	.098	.062	
	10	10	3.0	MB-07TH100SA-10R	☆	☆	☆	☆	7	0.93	3.1	5.8	3.9	2.99	1.80	
		.394	.120						.276	.0366	.120	.228	.153	.117	.070	
	8	10	2.4	MB-07TH080SA-10R	☆	☆	☆	☆	7	1.19	2.5	5.8	3.7	3.71	2.30	
		.394	.096						.276	.0468	.096	.228	.146	.146	.090	

To correspond to insert size on holder

R = Right hand, L = Left hand



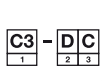
B173



I1



G2



I30

Cutting speed recommendations, metric values

ISO P								
MC No.	CMC No.	Material	Specific cutting force	Hardness Brinell	Grades			
			N/mm²	HB	GC1125	GC1135	GC1020	H13A
					Cutting speed (v _c), m/min			
P1.1.Z.AN	01.1	Unalloyed steel	1500	125	230	205	185	160
P1.2.Z.AN	01.2	C = 0.1–0.25%	1600	150	195	170	155	130
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	170	180	160	145	125
P2.1.Z.AN	02.1	Low-alloy steel						
		(alloying elements ≤5%)						
P2.1.Z.AN	02.1	Non-hardened	1700	180	155	140	125	115
P2.1.Z.AN	02.12	Ball bearing steel	1800	210	145	125	115	105
P2.5.Z.HT	02.2	Hardened and tempered	1850	275	120	105	95	80
P2.5.Z.HT	02.2	Hardened and tempered	2050	350	95	85	75	65
P3.0.Z.AN	03.11	High-alloy steel						
		(alloying elements >5%)						
P3.0.Z.AN	03.11	Annealed	1950	200	140	120	110	105
P3.0.Z.HT	03.21	Hardened tool steel	3000	325	115	100	80	70
P1.5.C.UT	06.1	Steel castings						
		Unalloyed	1550	180	220	200	180	170
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	150	130	120	95
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	2050	225	120	105	95	85
P3.2.C.AQ	06.33	Manganese steel, 12–14% Mn	2900	250	40	38	35	33
ISO M								
P5.0.Z.AN	05.11	Bars/forged						
		Ferritic/martensitic						
P5.0.Z.PH	05.12	Non-hardened	1800	200	160	145	130	90
P5.0.Z.HT	05.13	PH-hardened	2850	330	115	100	90	70
		Hardened	2350	330	105	95	85	65
M1.0.Z.AQ	05.21	Bars/forged						
		Austenitic	1800	180	140	130	120	75
M1.0.Z.PH	05.22	PH-hardened	2850	330	100	90	80	60
M2.0.Z.AQ	05.23	Super austenitic	2250	200	80	75	70	50
M3.1.Z.AQ	05.51	Stainless steel – Bars/forged						
		Austenitic-ferritic (Duplex)						
M3.1.Z.AQ	05.51	Non-weldable C ≥ 0.05%	2000	230	110	100	90	-
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	90	80	70	-
P5.0.C.UT	15.11	Stainless steel – Cast						
		Ferritic/martensitic						
P5.0.C.UT	15.11	Non-hardened	1700	200	120	100	90	90
P5.0.C.HT	15.12	PH-hardened	2450	330	90	80	70	55
P5.0.C.HT	15.13	Hardened	2150	330	70	65	60	50
M1.0.C.UT	15.21	Stainless steel – Cast						
		Austenitic	1700	180	120	110	100	80
M1.0.C.UT	15.22	PH-hardened	2450	330	70	65	60	50
M2.0.C.AQ	15.23		2150	200	90	80	70	40
M3.1.C.AQ	15.51	Stainless steel – Cast						
		Austenitic-ferritic (Duplex)						
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	100	95	85	-
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	75	70	65	-
ISO K								
K1.1.C.NS	07.1	Malleable cast iron						
		Ferritic (short chipping)	790	130	170	150	135	95
K1.1.C.NS	07.2	Pearlitic (long chipping)	900	230	125	110	100	70
K2.1.C.UT	08.1	Grey cast iron						
		Low tensile strength	890	180	160	140	130	85
K2.2.C.UT	08.2	High tensile strength	970	220	140	130	120	80
K3.1.C.UT	09.1	Nodular SG iron						
		Ferritic	900	160	140	135	125	110
K3.3.C.UT	09.2	Pearlitic	1350	250	110	100	90	80
K3.4.C.UT	09.3	Martensitic	2100	380	80	75	65	60
ISO N								
N1.2.Z.UT	30.11	Aluminium alloys						
		Wrought/wrought and						
N1.2.Z.UT	30.11	+ cold-worked, non aging	400	60	500	500	500	500
N1.2.Z.AG	30.12	Aged	650	100	500	500	500	450
N1.3.C.UT	30.21	Aluminium alloys						
		Cast, non-aging	600	75	500	500	455	425
N1.3.C.AG	30.22	Cast or cast and aged	700	90	400	325	280	250
N1.3.C.AG	30.41	Cast Si 13-15%	700	130	300	270	245	210
N1.4.C.NS	30.42	Cast Si 16-22%	700	130	300	270	245	210
N3.3.U.UT	33.1	Copper and copper alloys						
		Free cutting alloys, ≥1% Pb	550	110	500	460	420	370
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	550	90	300	270	245	210
N3.1.U.UT	33.3	Bronze and non-leadad copper incl. electrolytic copper	1350	100	210	190	175	150

A

Cutting speed recommendations, metric values

B

ISO S									
MC No.	CMC No.	Material	Specific cutting force k_{c1}	Hardness Brinell	Grades				
					GC1125	GC1135	GC1020	H13A	CB7015
					Cutting speed (v_c), m/min				
		Heat resistant alloys							
		Iron base							
S1.0.U.AN	20.11	Annealed	2400	200	55	50	45	45	-
S1.0.U.AG	20.12	Aged	2500	280	35	35	30	30	-
		Nickel base							
S2.0.Z.AN	20.21	Annealed	2650	250	25	25	20	19	-
S2.0.Z.AG	20.22	Aged	2900	350	15	15	13	13	-
S2.0.C.NS	20.24	Cast	3000	320	13	13	10	11	-
		Cobalt alloys							
S3.0.Z.AN	20.31	Annealed	2700	200	30	30	25	22	-
S3.0.Z.AG	20.32	Aged	3000	300	20	18	15	14	-
S3.0.C.NS	20.33	Cast	3100	320	20	18	15	15	-
		Titanium alloys							
S4.1.Z.UT	23.1	Commercial pure (99.5% Ti)	1300	400 Rm	170	160	140	120	-
S4.2.Z.AN	23.21	α , near α and $\alpha + \beta$ alloys, annealed	1400	950 Rm	70	65	60	50	-
S4.3.Z.AG	23.22	$\alpha + \beta$ alloys in aged conditions, β alloys, annealed or aged	1400	1050 Rm	60	55	50	40	-
ISO H									
		Extra hard steel							
H1.1.Z.HA	04.1	Hardened and tempered	2750	47 HRC	60	50	50	-	130
H1.3.Z.HA	04.1		4300	60 HRC	39	32	32	-	130
		Chilled cast iron							
H2.0.C.UT	10.1	Cast or cast and aged	2250	400	45	40	35	50	-

Cutting speed recommendations, inch values

ISO P								
MC No.	CMC No.	Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	Grades			
					GC1125	GC1135	GC1020	H13A
					Cutting speed (V_c) ft/min			
P1.1.Z.AN	01.1	Unalloyed steel C = 0.1 - 0.25%	216,500	125	760	670	610	520
P1.2.Z.AN	01.2	C = 0.25 - 0.55%	233,000	150	640	560	510	430
P1.3.Z.AN	01.3	C = 0.55 - 0.80%	247,000	170	590	530	475	410
P2.1.Z.AN	02.1	Low-alloy steel (alloying elements ≤5%) Non-hardened	249,500	180	510	460	405	380
P2.1.Z.AN	02.12	Ball bearing steel	259,500	210	475	410	375	-
P2.5.Z.HT	02.2	Hardened and tempered	268,000	275	385	350	310	270
P2.5.Z.HT	02.2	Hardened and tempered	298,000	350	310	280	250	220
P3.0.Z.AN	03.11	High-alloy steel (alloying elements >5%) Annealed	282,000	200	460	395	360	345
P3.0.Z.HT	03.21	Hardened tool steel	435,500	325	375	320	270	230
P1.5.C.UT	06.1	Steel castings Unalloyed	225,000	180	730	660	590	560
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	230,500	200	490	425	395	305
P3.0.C.UT	06.3	High-alloy, alloying elements >5%	300,500	225	395	345	310	285
P3.2.C.AQ	06.33	Manganese steel, 12–14% Mn	420,500	250	130	125	115	105
ISO M								
P5.0.Z.AN	05.11	Bars/forged Ferritic/martensitic Non-hardened	262,000	200	520	475	425	295
P5.0.Z.PH	05.12	PH-hardened	411,500	330	375	330	295	235
P5.0.Z.HT	05.13	Hardened	340,000	330	345	310	280	215
M1.0.Z.AQ	05.21	Bars/forged Austenitic Austenitic	259,000	180	460	425	395	250
M1.0.Z.PH	05.22	PH-hardened	414,000	330	330	295	260	190
M2.0.Z.AQ	05.23	Super austenitic	328,000	200	260	245	230	170
M3.1.Z.AQ	05.51	Stainless steel – Bars/forged Austenitic-ferritic (Duplex) Non-weldable C ≥ 0.05%	286,500	230	360	330	295	-
M3.2.Z.AQ	05.52	Weldable < 0.05%C	356,500	260	295	265	230	-
P5.0.C.UT	15.11	Stainless steel – Cast Ferritic/martensitic Non-hardened	246,500	200	395	330	295	300
	15.12	PH-hardened	354,500	330	295	265	230	-
P5.0.C.HT	15.13	Hardened	311,000	330	230	215	195	160
M1.0.C.UT	15.21	Stainless steel – Cast Austenitic-ferritic (Duplex) Austenitic	248,000	180	395	360	325	265
	15.22	PH-hardened	356,000	330	230	215	200	165
M2.0.C.AQ	15.23	Super austenitic	310,500	200	295	265	230	-
M3.1.C.AQ	15.51	Non-weldable C ≥ 0.05%	258,000	230	330	310	280	-
M3.2.C.AQ	15.52	Weldable < 0.05%C	326,500	260	245	230	210	-
ISO K								
	07.1	Malleable cast iron Ferritic (short chipping)	115,000	130	560	490	440	315
K1.1.C.NS	07.2	Pearlitic (long chipping)	131,000	230	410	360	325	230
K2.1.C.UT	08.1	Grey cast iron Low tensile strength	130,000	180	520	460	425	285
K2.2.C.UT	08.2	High tensile strength	140,500	220	460	425	390	265
K3.1.C.UT	09.1	Nodular SG iron Ferritic	130,000	160	460	450	410	355
K3.3.C.UT	09.2	Pearlitic	194,500	250	360	330	290	260
K3.4.C.UT	09.3	Martensitic	307,000	380	260	245	220	195

Cutting speed recommendations, inch values

ISO N									
MC No.	CMC No.	Material	Specific cutting force k_{c1} lbs/in²	Hardness Brinell HB	Grades				
					GC1125	GC1135	GC1020	H13A	CB7015
					Cutting speed (V_c) ft/min				
N1.2.Z.UT N1.2.Z.AG	30.11	Aluminium alloys Wrought/wrought and + cold-worked, non aging Aged	58,000	60	1650	1650	1650	1650	
	30.12		94,500	100	1650	1650	1650	1450	
N1.3.C.UT N1.3.C.AG	30.21	Aluminium alloys Cast, non-aging Cast or cast and aged	87,000	75	1650	1650	1500	1400	
	30.22		101,500	90	1300	1050	920	820	
N1.4.C.NS	30.41	Aluminium alloys Cast Si 13-15% Cast Si 16-22%	101,500	130	980	890	800	690	
	30.42		101,500	130	980	890	800	690	
N3.3.U.UT N3.2.C.UT N3.1.U.UT	33.1	Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb Brass, leaded bronzes, $\leq 1\%$ Pb Bronze and non-leadad copper incl. electrolytic copper	79,500	110	1650	1500	1400	1200	
	33.2		80,000	90	980	890	800	690	
	33.3		196,000	100	690	620	570	490	
ISO S									
S1.0.U.AN S1.0.U.AG	20.11	Heat resistant super alloys Iron base Annealed or solution treated Aged or solution treated and aged	348,000	200	180	165	145	145	
	20.12		359,000	280	115	115	100	100	
S2.0.Z.AN S2.0.Z.AG	20.21	Nickel base Annealed or solution treated Aged or solution treated and aged	383,000	250	80	80	65	60	
	20.22		420,500	350	50	50	45	45	
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	45	45	33	35	
S3.0.Z.AN S3.0.Z.AG S3.0.C.NS	20.31	Cobalt alloys Annealed or solution treated Solution treated and aged Cast or cast and aged	391,500	200	100	100	80	70	
	20.32		432,000	300	65	60	50	45	
	20.33		450,500	320	65	60	50	50	
S4.1.Z.UT S4.2.Z.AN S4.3.Z.AG	23.1	Titanium alloys Commercial pure (99,5% Ti) α , near α and $\alpha + \beta$ alloys, annealed α , near α and $\alpha + \beta$ alloys, annealed $\alpha + \beta$ alloys in aged cond, β alloys, annealed or aged	188,500	400 Rm	560	520	460	395	
	23.21		203,000	950 Rm	230	215	195	-	
	23.22		203,000	1050 Rm	195	180	165	-	
ISO H									
H1.1.Z.HA H1.3.Z.HA	04.1	Extra hard steel Hardened and tempered Hardened and tempered	397,000	47 HRC	200	165	165	-	420
	04.1		625,500	60 HRC	125	105	105	-	420
H2.0.C.UT	10.1	Chilled cast iron Cast or cast and aged	326,500	400	150	130	115	170	-

CoroThread® 266

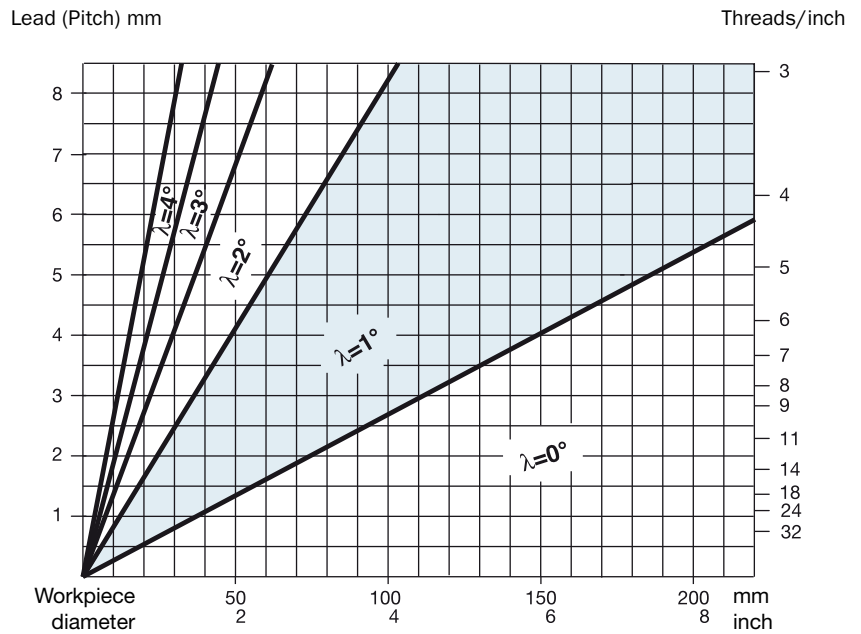
The angle of inclination is calculated by using the formula:

$$\lambda = \tan^{-1} \left(\frac{P}{d_2 \times \pi} \right)$$

P = Pitch

d_2 = Effective diameter of thread

λ = Angle of inclination



Pitch range	Insert size	Inclination angle	Shims	
mm (TPI)	 iC		 For right hand external tool For left hand internal tool	 For left hand external tool For right hand internal tool
0.5-3.0 (32-6)	16 3/8	-2° -1° 0° 1° 2° 3° 4°	5322 389-22 5322 389-21 5322 389-10 5322 389-11 ¹⁾ 5322 389-12 5322 389-13 5322 389-14	5322 390-22 5322 390-21 5322 390-10 5322 390-11 ¹⁾ 5322 390-12 5322 390-13 5322 390-14
2.5-7.0 (11.5-4)	22 1/2	-2° -1° 0° 1° 2° 3° 4°	5322 379-22 5322 379-21 5322 379-10 5322 379-11 ¹⁾ 5322 379-12 5322 379-13 5322 379-14	5322 380-22 5322 380-21 5322 380-10 5322 380-11 ¹⁾ 5322 380-12 5322 380-13 5322 380-14
8.0 (5-3)	27 5/8	0° 1° 2° 3° 4°	5322 387-10 5322 387-11 ¹⁾ 5322 387-12 5322 387-13 5322 387-14	5322 388-10 5322 388-11 ¹⁾ 5322 388-12 5322 388-13 5322 388-14
Pitch range	Insert size	Inclination angle	Shims for holders 266R/LFA	
mm (TPI)	 IC		 For right hand external tool For left hand internal tool	 For left hand external tool For right hand internal tool
0.5-3.0 (32-6)	16 3/8	0° 1° 2° 3° 4°	5322 391-10 5322 391-11 ¹⁾ 5322 391-12 5322 391-13 5322 391-14	5322 392-10 5322 392-11 ¹⁾ 5322 392-12 5322 392-13 5322 392-14

¹⁾ Delivered with the tool.

Note!

The last two figures in the shim code indicate + or - and the effective inclination angle with the shim mounted in the holder.e.g. 5322 379-11 = angle + 1° and 5322 379-21 = angle - 1°.

CoroThread® 266

TPI	Inclination angle				
	4°	3°	2° (-2°)	1° (-1°)	0°
	Thread diameter, inch				
32	<.16	.16-.23	.23-.38	.38-1.14	>1.14
28	<.16	.16-.26	.26-.43	.43-1.30	>1.30
24	<.22	.22-.30	.30-.51	.51-1.52	>1.52
20	<.26	.26-.36	.36-.61	.61-1.82	>1.82
18	<.29	.29-.40	.40-.68	.68-2.03	>2.03
16	<.33	.33-.46	.46-.76	.76-2.28	>2.28
14	<.37	.37-.52	.52-.87	.87-2.61	>2.61
13	<.40	.40-.56	.56-.94	.94-2.81	>2.81
12	<.43	.43-.61	.61-1.01	1.01-3.04	>3.04
11	<.47	.47-.66	.66-1.11	1.11-3.32	>3.32
10	<.52	.52-.73	.73-1.22	1.22-3.65	>3.65
9	<.58	.58-.81	.81-1.35	1.35-4.05	>4.05
8	<.65	.65-.91	.91-1.52	1.52-4.56	>4.56
7	<.74	.74-1.04	1.04-1.74	1.74-5.21	>5.21
6	<.87	.87-1.22	1.22-2.03	2.03-6.08	>6.08
5	<1.04	1.04-1.46	1.46-2.43	2.43-7.30	>7.30
4	<1.30	1.30-1.82	1.82-3.04	3.04-9.12	>9.12
3	<1.74	1.74-2.43	2.43-4.05	4.05-12.15	>12.15

Pitch, mm	Inclination angle				
	4°	3°	2° (-2°)	1° (-1°)	0°
	Thread diameter, inch				
0.50	<.10	.10-.14	.14-.72	.24-.72	>.72
0.75	<.15	.15-.22	.22-.36	.36-1.08	>1.08
1.00	<.20	.20-.29	.29-.48	.48-1.44	>1.44
1.25	<.26	.26-.36	.36-.60	.60-1.80	>1.80
1.50	<.31	.31-.43	.43-.72	.72-2.15	>2.15
1.75	<.36	.36-.50	.50-.84	.84-2.51	>2.51
2.00	<.41	.41-.57	.57-.96	.96-2.87	>2.87
2.50	<.51	.51-.72	.72-1.20	1.20-3.59	>3.59
3.00	<.62	.62-.86	.86-1.44	1.44-4.31	>4.31
3.50	<.72	.72-1.00	1.00-1.68	1.68-5.03	>5.03
4.00	<.82	.82-1.15	1.15-1.92	1.92-5.74	>5.74
4.50	<.92	.92-1.29	1.29-2.15	2.15-6.46	>6.46
5.00	<1.02	1.02-1.44	1.44-2.39	2.39-7.18	>7.18
5.50	<1.13	1.13-1.58	1.58-2.63	2.63-7.90	>7.90
6.00	<1.23	1.23-1.72	1.72-2.87	2.87-8.62	>8.62
7.00	<1.26	1.26-2.00	2.00-3.35	3.35-10.04	>10.04
8.00	<1.64	1.64-2.30	2.30-3.83	3.83-11.84	>11.84

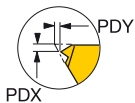
The angle of inclination is calculated by using the formula:

P = Pitch
 d_e = Effective diameter of thread
 λ = Angle of inclination

$$\lambda = \tan^{-1} \left(\frac{P}{d_e \times \pi} \right)$$

ISO Metric (MM), external

		Pitch, mm														
		0.50	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00
No. of infeeds	PDY	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.67	1.67	1.67	1.38	1.08	0.88
	PDX	.052	.052	.052	.052	.052	.052	.052	.052	.052	.066	.066	.066	.054	.043	.035
1	PDY	0.50	0.50	0.80	0.80	1.00	1.20	1.40	1.40	1.80	2.50	2.50	2.50	2.50	2.50	2.80
	PDX	.020	.020	.031	.031	.039	.047	.055	.055	.071	.098	.098	.098	.098	.098	.110
Radial infeed per pass		0.10	0.16	0.16	0.17	0.20	0.17	0.20	0.20	0.24	0.24	0.27	0.29	0.27	0.30	
2	PDY	.004	.006	.006	.007	.008	.007	.008	.008	.008	.009	.009	.011	.011	.011	.012
	PDX	.009	.015	.015	.015	.019	.017	.019	.019	.023	.022	.025	.028	.026	.029	
3	PDY	.004	.006	.006	.006	.007	.007	.007	.007	.007	.009	.009	.010	.011	.010	.011
	PDX	.008	.012	.014	.014	.018	.016	.018	.018	.022	.022	.024	.027	.026	.029	
4	PDY	.003	.005	.006	.006	.007	.006	.007	.007	.007	.009	.009	.009	.011	.010	.011
	PDX	.007	.007	.012	.013	.016	.015	.017	.017	.018	.021	.021	.023	.026	.025	.028
5	PDY	.003	.003	.005	.005	.006	.006	.007	.007	.007	.008	.008	.009	.010	.010	.011
	PDX			.008	.012	.014	.014	.016	.017	.017	.021	.021	.023	.025	.025	.027
6	PDY			.003	.005	.006	.006	.006	.007	.007	.008	.008	.009	.010	.010	.011
	PDX				.008	.008	.013	.015	.016	.017	.020	.020	.022	.025	.024	.026
7	PDY				.003	.003	.005	.006	.006	.007	.008	.008	.009	.010	.009	.010
	PDX					.011	.013	.015	.016	.018	.019	.021	.024	.023	.026	
8	PDY					.004	.005	.006	.006	.007	.007	.008	.009	.009	.010	
	PDX					.008	.008	.014	.015	.017	.018	.020	.023	.023	.025	
9	PDY					.003	.003	.006	.006	.007	.007	.008	.009	.009	.010	
	PDX						.012	.014	.016	.017	.019	.022	.022	.024		
10	PDY							.005	.006	.006	.007	.007	.009	.009	.009	
	PDX							.008	.013	.015	.016	.018	.020	.021	.023	
11	PDY							.003	.005	.006	.006	.007	.008	.008	.009	
	PDX								.012	.013	.015	.017	.019	.020	.022	
12	PDY								.005	.005	.006	.007	.007	.008	.009	
	PDX								.008	.008	.014	.016	.017	.019	.020	
13	PDY								.003	.003	.006	.006	.007	.007	.008	
	PDX									.012	.014	.015	.018	.019		
14	PDY										.005	.006	.006	.007	.007	
	PDX										.008	.010	.010	.016	.017	
15	PDY										.003	.004	.004	.006	.007	
	PDX													.014	.015	
16	PDY													.006	.006	
	PDX													.010	.010	
Total infeed		.034	.050	.065	.079	.095	.111	.126	.156	.188	.218	.249	.279	.310	.339	.370
		.013	.020	.026	.031	.037	.044	.050	.061	.074	.086	.098	.110	.122	.133	.145



mm
inch

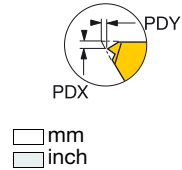
ISO Metric (MM), internal

		Pitch, mm														
		0.50	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00
No. of infeeds	PDY	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.64	1.64	1.64	1.35	1.06	0.87
	PDX	.051	.051	.051	.051	.051	.051	.051	.051	.051	.065	.065	.065	.053	.042	.034
1	PDY	0.50	0.50	0.80	0.80	1.00	1.20	1.40	1.40	1.80	2.50	2.50	2.50	2.50	2.50	2.40
	PDX	.020	.020	.031	.031	.039	.047	.055	.055	.071	.098	.098	.098	.098	.098	.094
Radial infeed per pass		0.10	0.15	0.15	0.16	0.20	0.16	0.19	0.19	0.19	0.22	0.21	0.23	0.26	0.25	0.28
2	PDY	.004	.006	.006	.006	.008	.006	.007	.007	.007	.009	.008	.009	.010	.010	.011
	PDX	.009	.014	.014	.015	.018	.015	.018	.018	.018	.021	.021	.023	.026	.025	.027
3	PDY	.004	.005	.006	.006	.007	.006	.007	.007	.007	.008	.008	.009	.010	.010	.011
	PDX	.008	.012	.013	.014	.017	.015	.017	.017	.018	.020	.020	.022	.025	.024	.026
4	PDY	.003	.005	.005	.006	.007	.006	.007	.007	.007	.008	.008	.009	.010	.010	.010
	PDX	.007	.007	.012	.013	.015	.014	.016	.017	.017	.020	.019	.022	.024	.024	.026
5	PDY	.003	.003	.005	.005	.006	.006	.006	.007	.007	.008	.008	.009	.010	.009	.010
	PDX			.008	.011	.013	.013	.015	.016	.016	.019	.019	.021	.024	.023	.025
6	PDY			.003	.005	.005	.005	.006	.006	.006	.007	.007	.008	.009	.009	.010
	PDX				.008	.008	.012	.014	.015	.016	.018	.018	.020	.023	.022	.024
7	PDY				.003	.003	.005	.005	.006	.006	.007	.007	.008	.009	.009	.010
	PDX					.011	.012	.014	.015	.017	.018	.020	.022	.022	.024	
8	PDY					.004	.005	.006	.006	.007	.007	.008	.009	.009	.009	
	PDX					.008	.008	.013	.014	.016	.017	.019	.021	.021	.023	
9	PDY					.003	.003	.005	.006	.006	.007	.007	.008	.008	.009	
	PDX						.012	.014	.015	.016	.018	.020	.020	.020	.022	
10	PDY							.005	.005	.006	.006	.007	.007	.008	.008	
	PDX							.008	.012	.014	.015	.017	.019	.020	.021	
11	PDY							.003	.005	.005	.006	.007	.007	.008	.008	
	PDX								.011	.012	.014	.016	.018	.019	.020	
12	PDY								.004	.005	.006	.006	.007	.007	.008	
	PDX								.008	.008	.013	.015	.016	.018	.019	
13	PDY								.003	.003	.005	.006	.006	.007	.007	
	PDX									.012	.014	.015	.017	.018		
14	PDY										.005	.005	.006	.007	.007	
	PDX										.008	.010	.010	.016	.016	
15	PDY										.003	.004	.004	.006	.006	
	PDX													.014	.015	
16	PDY													.005	.006	
	PDX													.010	.010	
Total infeed		.034	.048	.063	.077	.092	.105	.120	.148	.178	.203	.231	.261	.288	.319	.344
		.013	.019	.025	.030	.036	.041	.047	.058	.070	.080	.091	.103	.113	.126	.135

Total infeed = $a_p + 0.05 \text{ mm}$ (.002 inch)

ISO inch (UN), external

		Pitch, TPI																		
		32	28	24	20	18	16	14	13	12	11	10	9	8	7	6	5	4.5	4	
		1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.67	1.67	1.38	1.09	0.79
		.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.066	.066	.054	.043	.031
PDY	PDX	.050	.080	.080	.080	1.00	1.00	1.20	1.40	1.40	1.40	1.40	1.80	1.80	2.50	2.50	2.50	2.65	2.90	
		.020	.031	.031	.031	.039	.039	.047	.055	.055	.055	.055	.071	.071	.098	.098	.098	.098	.104	.114
No. of infeeds		Radial infeed per pass																		
1		.017	.015	.018	.018	.020	.019	.018	.020	.022	.021	.021	.021	.022	.025	.024	.029	.028	.032	
		.007	.006	.007	.007	.008	.007	.007	.008	.009	.008	.008	.008	.009	.010	.009	.012	.011	.013	
2		.016	.014	.016	.017	.018	.018	.018	.019	.021	.020	.020	.020	.021	.024	.023	.029	.028	.032	
		.006	.005	.006	.007	.007	.007	.007	.007	.008	.008	.008	.008	.008	.009	.009	.011	.011	.012	
3		.013	.013	.015	.015	.017	.017	.017	.018	.020	.019	.019	.019	.020	.023	.023	.028	.027	.031	
		.005	.005	.006	.006	.007	.007	.007	.007	.008	.008	.008	.008	.008	.009	.009	.011	.011	.012	
4		.008	.011	.013	.014	.015	.016	.016	.017	.019	.018	.018	.018	.019	.020	.022	.022	.027	.026	
		.003	.004	.005	.006	.006	.006	.006	.007	.007	.007	.007	.007	.007	.008	.009	.011	.010	.012	
5			.008	.008	.012	.013	.015	.016	.017	.017	.017	.018	.019	.021	.021	.026	.026	.029		
			.003	.003	.005	.005	.006	.006	.006	.007	.007	.007	.007	.007	.008	.008	.010	.010	.011	
6					.008	.008	.012	.014	.014	.015	.016	.016	.017	.018	.020	.021	.025	.025	.028	
					.003	.003	.005	.005	.006	.006	.006	.006	.006	.007	.007	.008	.008	.010	.010	
7						.008	.012	.012	.013	.015	.015	.016	.016	.017	.019	.020	.024	.024	.027	
						.003	.005	.005	.005	.006	.006	.006	.006	.007	.008	.008	.010	.010	.011	
8							.008	.008	.008	.013	.014	.015	.016	.018	.019	.023	.023	.026	.026	
							.003	.003	.003	.005	.006	.006	.006	.007	.008	.009	.009	.010	.010	
9											.008	.012	.014	.015	.017	.018	.022	.022	.025	
											.003	.005	.005	.006	.007	.007	.009	.009	.010	
10												.008	.012	.014	.015	.018	.021	.022	.024	
												.003	.005	.005	.006	.007	.008	.008	.010	
11													.008	.012	.013	.017	.019	.021	.023	
														.008	.012	.013	.017	.019	.021	
12															.005	.005	.007	.008	.008	
															.006	.006	.007	.008	.008	
13																.014	.015	.018	.020	
																.005	.006	.007	.008	
14																	.010	.010	.017	
																	.004	.007	.007	
15																			.015	
																			.006	
16																			.010	
																			.004	
Total infeed		.054	.060	.070	.084	.092	1.04	1.17	1.24	1.35	1.47	1.62	1.79	2.02	2.26	2.64	3.17	3.51	3.94	
		.021	.024	.028	.033	.036	.041	.046	.049	.053	.058	.064	.070	.080	.089	.104	.125	.138	.155	



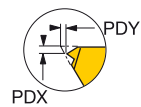
ISO inch (UN), internal

		Pitch, TPI																	
		32	28	24	20	18	16	14	13	12	11	10	9	8	7	6	5	4.5	4
		1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.64	1.64	1.35	1.06	0.87
		PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY	PDY
No. of infeeds	Radial infeed per pass	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	PDX	
		.020	.031	.031	.031	.039	.039	.047	.055	.055	.055	.055	.071	.071	.098	.098	.098	.098	.104
1		0.16 .006	0.14 .005	0.16 .006	0.16 .006	0.18 .007	0.17 .007	0.16 .006	0.18 .007	0.20 .008	0.19 .007	0.19 .007	0.19 .007	0.22 .009	0.21 .009	0.23 .023	0.26 .026	0.25 .025	0.28 .028
2		0.14 .006	0.13 .005	0.15 .006	0.16 .006	0.17 .007	0.16 .006	0.16 .006	0.16 .006	0.19 .007	0.18 .007	0.18 .007	0.18 .007	0.21 .008	0.21 .008	0.23 .023	0.26 .026	0.25 .025	0.27 .027
3		0.13 .005	0.12 .005	0.14 .006	0.14 .006	0.16 .006	0.15 .006	0.15 .006	0.15 .006	0.18 .007	0.18 .007	0.17 .007	0.18 .007	0.20 .008	0.20 .008	0.22 .022	0.25 .025	0.24 .024	0.26 .026
4		0.08 .003	0.11 .004	0.12 .005	0.13 .005	0.14 .006	0.14 .006	0.14 .006	0.14 .006	0.17 .007	0.17 .007	0.17 .007	0.17 .007	0.20 .009	0.19 .009	0.22 .022	0.24 .024	0.24 .024	0.26 .026
5			0.08 .003	0.08 .003	0.12 .005	0.13 .005	0.13 .006	0.14 .006	0.16 .006	0.16 .006	0.16 .006	0.16 .006	0.19 .007	0.19 .007	0.21 .009	0.21 .009	0.24 .024	0.23 .023	0.25 .025
6				0.03 .003	0.05 .005	0.08 .008	0.12 .012	0.13 .013	0.13 .013	0.16 .016	0.16 .016	0.16 .016	0.16 .016	0.19 .019	0.19 .019	0.22 .022	0.24 .024	0.24 .024	0.26 .026
7					0.03 .003	0.05 .005	0.08 .008	0.12 .012	0.13 .013	0.14 .014	0.15 .015	0.15 .015	0.16 .016	0.18 .018	0.18 .018	0.20 .020	0.23 .023	0.22 .022	0.24 .024
8						0.08 .008	0.11 .011	0.11 .011	0.13 .013	0.14 .014	0.15 .015	0.15 .015	0.16 .016	0.18 .018	0.18 .018	0.20 .020	0.22 .022	0.24 .024	0.26 .026
9							0.08 .008	0.08 .008	0.08 .008	0.12 .012	0.13 .013	0.14 .014	0.16 .016	0.17 .017	0.19 .019	0.21 .021	0.21 .021	0.23 .023	0.25 .025
10								0.05 .005	0.05 .005	0.06 .006	0.06 .006	0.06 .006	0.06 .006	0.07 .007	0.07 .007	0.08 .008	0.08 .008	0.09 .009	0.09 .009
11									0.08 .008	0.12 .012	0.14 .014	0.15 .015	0.16 .016	0.18 .018	0.20 .020	0.22 .022	0.24 .024	0.25 .025	0.27 .027
12										0.08 .008	0.12 .012	0.14 .014	0.15 .015	0.16 .016	0.18 .018	0.20 .020	0.21 .021	0.23 .023	0.25 .025
13											0.11 .011	0.12 .012	0.14 .014	0.16 .016	0.18 .018	0.19 .019	0.20 .020	0.22 .022	0.24 .024
14											0.04 .004	0.05 .005	0.06 .006	0.06 .006	0.07 .007	0.07 .007	0.08 .008	0.08 .008	0.09 .009
15											0.08 .008	0.08 .008	0.13 .013	0.15 .015	0.16 .016	0.18 .018	0.19 .019	0.21 .021	0.23 .023
16												0.03 .003	0.03 .003	0.05 .005	0.06 .006	0.06 .006	0.07 .007	0.07 .007	0.08 .008
17													0.12 .012	0.14 .014	0.15 .015	0.17 .017	0.18 .018	0.20 .020	0.22 .022
18													0.05 .005	0.05 .005	0.06 .006	0.07 .007	0.07 .007	0.08 .008	0.09 .009
19													0.08 .008	0.10 .010	0.10 .010	0.16 .016	0.16 .016	0.18 .018	0.20 .020
20													0.03 .003	0.04 .004	0.04 .004	0.06 .006	0.06 .006	0.08 .008	0.10 .010
21																0.14 .014	0.15 .015	0.16 .016	0.18 .018
22																0.05 .005	0.06 .006	0.07 .007	0.08 .008
23																	0.10 .010	0.10 .010	0.12 .012
24																	0.04 .004	0.04 .004	0.06 .006
Total infeed		0.51 .020	0.58 .023	0.66 .026	0.78 .030	0.86 .034	0.96 .038	1.07 .042	1.15 .045	1.25 .049	1.36 .053	1.48 .058	1.78 .070	2.03 .080	2.31 .090	2.61 .103	2.88 .113	3.19 .126	3.44 .135

Total infeed = $a_p + 0.05 \text{ mm}$ (.002 inch)

Whitworth (WH), external and internal

		Pitch, TPI																
		28	26	20	19	18	16	14	12	11	10	9	8	7	6	5	4.5	4
External	PDY	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.67	1.67	1.38	0.99	0.59
	PDX	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.066	.066	.054	.039	.023
Internal	PDY	0.80	0.80	0.80	0.80	1.00	1.00	1.40	1.40	1.40	1.40	1.80	1.80	2.50	2.50	2.50	2.65	2.75
	PDX	.031	.031	.031	.031	.039	.039	.055	.055	.055	.055	.071	.071	.098	.098	.098	.104	.108
No. of infeeds		Radial infeed per pass																
1		0.16	0.17	0.19	0.20	0.17	0.17	0.20	0.23	0.22	0.22	0.22	0.23	0.26	0.25	0.31	0.30	0.34
		.006	.007	.007	.008	.007	.007	.008	.009	.009	.009	.009	.009	.010	.010	.012	.012	.013
2		0.15	0.16	0.18	0.18	0.16	0.16	0.19	0.22	0.21	0.21	0.21	0.22	0.26	0.25	0.30	0.29	0.33
		.006	.006	.007	.007	.006	.006	.007	.009	.008	.008	.008	.009	.010	.010	.012	.012	.013
3		0.14	0.14	0.16	0.17	0.16	0.15	0.18	0.21	0.20	0.20	0.20	0.21	0.25	0.24	0.29	0.29	0.32
		.005	.006	.006	.007	.006	.006	.007	.008	.008	.008	.008	.008	.010	.009	.012	.011	.013
4		0.12	0.13	0.15	0.15	0.15	0.15	0.17	0.20	0.19	0.19	0.20	0.21	0.24	0.23	0.28	0.28	0.31
		.005	.005	.006	.006	.006	.006	.007	.008	.008	.008	.008	.008	.009	.009	.011	.011	.012
5		0.08	0.08	0.13	0.13	0.13	0.14	0.16	0.18	0.18	0.18	0.19	0.20	0.23	0.23	0.28	0.27	0.30
		.003	.003	.005	.005	.005	.005	.006	.007	.007	.007	.007	.008	.009	.009	.011	.011	.012
6				0.08	0.08	0.12	0.13	0.14	0.16	0.17	0.17	0.18	0.19	0.22	0.22	0.27	0.26	0.29
				.003	.003	.005	.005	.006	.006	.007	.007	.007	.008	.009	.009	.010	.010	.012
7					0.08	0.11	0.12	0.14	0.15	0.16	0.17	0.18	0.20	0.21	0.25	0.25	0.28	
					.003	.004	.005	.005	.006	.006	.007	.007	.008	.008	.010	.010	.011	
8						0.08	0.08	0.08	0.13	0.15	0.16	0.17	0.19	0.20	0.24	0.25	0.27	
						.003	.003	.003	.003	.005	.006	.006	.007	.008	.008	.010	.010	.011
9										0.08	0.13	0.14	0.16	0.18	0.19	0.23	0.24	0.26
										.003	.005	.006	.006	.007	.008	.009	.009	.010
10											0.08	0.12	0.14	0.16	0.18	0.22	0.23	0.25
											.003	.005	.006	.006	.007	.009	.009	.010
11												0.08	0.12	0.14	0.17	0.20	0.22	0.24
												.003	.005	.005	.007	.008	.008	.009
12													0.08	0.08	0.16	0.18	0.20	0.22
													.003	.003	.006	.007	.008	.009
13																0.16	0.19	0.21
																.004	.006	.007
14																0.10	0.17	0.19
																.004	.007	.007
15																		
																	0.15	0.16
16																	.006	.006
																	0.10	0.10
																	.004	.004
Total infeed		0.64	0.68	0.88	0.92	0.97	1.08	1.23	1.42	1.54	1.70	1.87	2.10	2.39	2.78	3.32	3.69	4.06
		.025	.027	.035	.036	.038	.043	.048	.056	.061	.067	.074	.083	.094	.109	.131	.145	.160



mm
inch

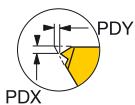
BSPT (PT), external and internal

		Pitch, TPI				
		28	19	14	11	8
External	PDY	1.32	1.32	1.32	1.32	1.32
	PDX	.052	.052	.052	.052	.052
Internal	PDY	0.80	0.80	1.20	1.40	1.80
	PDX	.031	.031	.047	.055	.071
No. of infeeds		Radial infeed per pass				
1		0.15	0.19	0.19	0.22	0.22
2		.006	.008	.007	.009	.009
3		.006	.007	.007	.008	.008
4		.005	.007	.007	.008	.008
5		.005	.006	.006	.007	.008
6		.003	.005	.006	.007	.008
7			.008	.014	.016	.018
8			.003	.005	.006	.007
9				.012	.015	.017
10				.005	.006	.007
11				.008	.013	.016
12				.003	.005	.006
13					.008	.015
14					.003	.006
15						.014
16						.006
Total infeed		.062	.090	.120	.151	.205

Total infeed = $a_p + 0.05$ mm (.002 inch)

Round 30° Din405 (RN) external

		Pitch, TPI			
		10	8	6	4
		1.33	1.33	1.43	1.38
PDY	PDX	.052	.052	.056	.054
		0.83	1.05	1.50	2.60
		.034	.041	.059	.102
		Radial infeed per pass			
1		0.21	0.21	0.24	0.30
		.008	.008	.009	.012
2		0.20	0.20	0.23	0.29
		.008	.008	.009	.011
3		0.19	0.19	0.22	0.28
		.007	.008	.009	.011
4		0.18	0.19	0.21	0.27
		.007	.007	.008	.011
5		0.16	0.18	0.20	0.26
		.006	.007	.008	.010
6		0.15	0.17	0.19	0.25
		.006	.007	.008	.010
7		0.13	0.15	0.18	0.24
		.005	.006	.007	.010
8		0.08	0.14	0.17	0.23
		.003	.006	.007	.009
9			0.12	0.16	0.22
			.005	.006	.009
10			0.08	0.15	0.21
			.003	.006	.008
11				0.13	0.19
				.005	.008
12				0.08	0.18
				.003	.007
13					0.15
					.006
14					0.10
					.004
Total infeed		1.30	1.63	2.17	2.95
		.051	.064	.085	.116



mm
inch

Round 30° Din405 (RN) internal

		Pitch, TPI			
		10	8	6	4
		1.30	1.30	1.45	1.35
PDY	PDX	.051	.051	.053	.053
		1.85	1.05	1.35	2.60
		.073	.041	.053	.102
		Radial infeed per pass			
1		0.22	0.21	0.24	0.30
		.009	.008	.009	.012
2		0.21	0.20	0.23	0.29
		.008	.008	.009	.012
3		0.20	0.20	0.22	0.29
		.008	.008	.009	.011
4		0.18	0.19	0.21	0.28
		.007	.007	.008	.011
5		0.17	0.18	0.21	0.27
		.007	.007	.008	.011
6		0.15	0.17	0.20	0.26
		.006	.007	.008	.010
7		0.13	0.16	0.19	0.25
		.005	.006	.007	.010
8		0.08	0.14	0.17	0.24
		.003	.006	.007	.009
9			0.12	0.16	0.23
			.005	.006	.009
10			0.08	0.15	0.21
			.003	.006	.008
11				0.13	0.20
				.005	.008
12				0.08	0.18
				.003	.007
13					0.16
					.006
14					0.10
					.004
Total infeed		1.34	1.64	2.18	2.98
		.053	.065	.086	.117

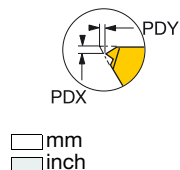
NPT (NT), external and internal

		Pitch, TPI				
		27	18	14	11½	8
		1.03	1.03	1.03	1.03	1.03
External	PDY	.041	.041	.041	.041	.041
		0.80	1.00	1.20	1.40	1.60
Internal	PDY	.031	.039	.047	.055	.063
		0.72	1.01	1.01	1.01	1.01
	PDX			.040	.040	.040
		0.85	1.20	1.20	1.40	1.60
				.047	.055	.063
No. of infeeds		Radial infeed per pass				
1		0.15	0.17	0.18	0.18	0.21
		.006	.007	.007	.007	.008
2		0.15	0.17	0.17	0.17	0.21
		.006	.007	.007	.007	.008
3		0.14	0.16	0.16	0.17	0.20
		.005	.006	.006	.007	.008
4		0.13	0.15	0.16	0.16	0.20
		.005	.006	.006	.006	.008
5		0.11	0.14	0.15	0.16	0.19
		.004	.006	.006	.006	.008
6		0.08	0.13	0.14	0.15	0.18
		.003	.005	.006	.006	.007
7			0.11	0.14	0.15	0.18
			.005	.005	.006	.007
8			0.08	0.13	0.14	0.17
			.003	.005	.006	.007
9				0.11	0.13	0.17
				.004	.005	.007
10				0.08	0.12	0.16
				.003	.005	.006
11					0.11	0.15
					.004	.006
12					0.08	0.14
					.003	.006
13						0.13
						.005
14						0.11
						.005
15						0.08
						.003
Total infeed		0.76	1.11	1.42	1.73	2.48
		.030	.044	.056	.068	.098

Total infeed = $a_p + 0.05 \text{ mm}$ (.002 inch)

ACME (AC), external

	PDY	Pitch, TPI								
		16	14	12	10	8	6	5	4	3
		1.33	1.33	1.33	1.33	1.50	1.37	1.37	0.76	0.54
	PDX									
		.052	.052	.052	.052	.059	.054	.054	.030	.021
		1.00	1.10	1.20	1.30	1.50	1.90	2.10	2.40	3.30
No. of infeeds		Radial infeed per pass								
1		0.22	0.20	0.20	0.20	0.20	0.24	0.26	0.28	0.31
		.009	.008	.008	.008	.008	.009	.010	.011	.012
2		0.20	0.19	0.19	0.20	0.20	0.23	0.25	0.28	0.31
		.008	.008	.008	.008	.008	.009	.010	.011	.012
3		0.19	0.18	0.18	0.19	0.19	0.23	0.25	0.27	0.30
		.007	.007	.007	.007	.008	.009	.010	.011	.012
4		0.17	0.17	0.17	0.18	0.18	0.22	0.24	0.26	0.30
		.007	.007	.007	.007	.007	.009	.010	.010	.012
5		0.14	0.15	0.16	0.17	0.18	0.21	0.23	0.26	0.29
		.006	.006	.006	.007	.007	.008	.009	.010	.011
6		0.08	0.13	0.15	0.16	0.17	0.20	0.23	0.25	0.28
		.003	.005	.006	.006	.007	.008	.009	.010	.011
7			0.08	0.13	0.15	0.16	0.20	0.22	0.24	0.28
			.003	.005	.006	.006	.008	.009	.010	.011
8				0.08	0.14	0.15	0.19	0.21	0.23	0.27
				.003	.005	.006	.007	.008	.009	.011
9					0.12	0.14	0.18	0.20	0.22	0.26
					.005	.006	.007	.008	.009	.010
10					0.08	0.13	0.17	0.19	0.22	0.25
					.003	.005	.007	.007	.008	.010
11						0.12	0.16	0.18	0.21	0.24
						.005	.006	.007	.008	.010
12						0.08	0.14	0.16	0.19	0.23
						.003	.005	.006	.008	.009
13							0.10	0.14	0.18	0.22
							.004	.006	.007	.009
14								0.10	0.17	0.21
								.004	.007	.008
15									0.15	0.20
									.006	.008
16									0.10	0.19
									.004	.007
17										0.17
										.007
18										0.15
										.006
19										.100
										.004
Total infeed		0.99	1.10	1.26	1.60	1.91	2.46	2.87	3.51	4.57
		.039	.043	.050	.063	.075	.097	.113	.138	.180



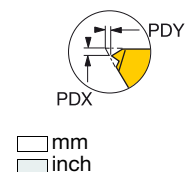
ACME (AC), internal

	PDY	Pitch, TPI								
		16	14	12	10	8	6	5	4	3
		1.30	1.30	1.33	1.33	1.14	1.33	0.92	0.81	0.54
	PDX									
		.051	.051	.054	.054	.050	.052	.036	.032	.021
		0.80	1.00	1.10	1.20	1.50	2.00	2.20	2.40	3.30
No. of infeeds		Radial infeed per pass								
1		0.22	0.21	0.21	0.21	0.21	0.24	0.26	0.29	0.31
		.009	.008	.008	.008	.008	.009	.010	.011	.012
2		0.21	0.20	0.20	0.20	0.20	0.23	0.26	0.28	0.31
		.008	.008	.008	.008	.008	.009	.010	.011	.012
3		0.19	0.19	0.19	0.20	0.20	0.23	0.25	0.27	0.30
		.008	.007	.007	.008	.008	.009	.010	.011	.012
4		0.17	0.17	0.18	0.19	0.19	0.22	0.24	0.27	0.29
		.007	.007	.007	.007	.007	.009	.010	.010	.012
5		0.14	0.16	0.16	0.18	0.18	0.21	0.24	0.26	0.29
		.006	.006	.006	.007	.007	.008	.009	.010	.011
6		0.08	0.13	0.15	0.17	0.17	0.21	0.23	0.25	0.28
		.003	.005	.006	.007	.007	.008	.009	.010	.011
7			0.08	0.13	0.16	0.17	0.20	0.22	0.24	0.27
			.003	.005	.006	.007	.008	.009	.010	.011
8				0.08	0.14	0.16	0.19	0.21	0.24	0.27
				.003	.006	.006	.007	.008	.009	.011
9					0.12	0.15	0.18	0.20	0.23	0.26
					.005	.006	.007	.008	.009	.010
10					0.08	0.13	0.17	0.19	0.22	0.25
					.003	.005	.007	.008	.009	.010
11						0.12	0.16	0.18	0.21	0.24
						.005	.006	.007	.008	.010
12						0.08	0.14	0.16	0.20	0.23
						.003	.006	.006	.008	.009
13							0.10	0.15	0.18	0.22
							.004	.006	.007	.009
14								0.10	0.17	0.21
								.004	.007	.008
15									0.15	0.20
									.006	.008
16									0.10	0.19
									.004	.007
17										0.17
										.007
18										0.15
										.006
19										.100
										.004
Total infeed		1.02	1.14	1.30	1.64	1.95	2.48	2.90	3.54	4.56
		.040	.045	.051	.065	.077	.098	.114	.139	.180

Total infeed = $a_p + 0.05 \text{ mm} (.002 \text{ inch})$

Stub-ACME (SA), external and internal

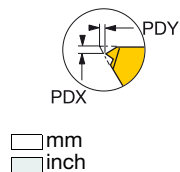
		Pitch, TPI								
		16	14	12	10	8	6	5	4	3
External	PDY	1.32	1.32	1.32	1.32	1.23	1.67	1.67	1.67	1.76
	PDX	.052	.052	.052	.052	.048	.066	.066	.066	.069
Internal	PDY	0.90	1.00	1.10	1.20	1.50	1.80	2.00	2.40	3.10
		.035	.029	.043	.047	.059	.071	.079	.094	.122
	PDX		1.64	1.33	1.30	1.20	1.64	1.64	1.64	1.76
			.065	.052	.051	.047	.065	.065	.065	.069
		2.40	1.10	1.20	1.50	1.80	2.00	2.40	3.10	
		.095	.043							.122
No. of infeeds		Radial infeed per pass								
1		0.18	0.20	0.18	0.21	0.22	0.24	0.25	0.24	0.25
		.007	.008	.007	.008	.008	.009	.010	.010	.010
2		0.16	0.18	0.17	0.20	0.21	0.23	0.24	0.24	0.24
		.006	.007	.007	.008	.008	.009	.009	.009	.010
3		0.15	0.17	0.16	0.19	0.19	0.22	0.23	0.23	0.24
		.006	.007	.006	.007	.008	.009	.009	.009	.009
4		0.13	0.14	0.15	0.17	0.18	0.21	0.22	0.22	0.23
		.005	.006	.006	.007	.007	.008	.009	.009	.009
5		0.08	0.08	0.13	0.15	0.17	0.19	0.21	0.21	0.22
		.003	.003	.005	.006	.007	.008	.008	.008	.009
6				0.08	0.13	0.15	0.18	0.19	0.20	0.22
				.003	.005	.006	.007	.008	.008	.009
7					0.08	0.13	0.16	0.18	0.19	0.21
					.003	.005	.006	.007	.008	.008
8						0.08	0.14	0.16	0.18	0.20
						.003	.005	.006	.007	.008
9							0.08	0.14	0.17	0.19
							.003	.006	.007	.008
10								0.09	0.16	0.18
								.004	.006	.007
11									0.14	0.17
									.005	.007
12									0.09	0.16
									.004	.006
13										0.15
										.006
14										0.13
										.005
15										0.09
										.004
Total infeed		0.70	0.77	0.87	1.13	1.33	1.64	1.90	2.27	2.90
		.028	.030	.034	.044	.052	.065	.075	.089	.114



Total infeed = $a_p + 0.05 \text{ mm}$ (.002 inch)

Trapezoidal (TR), external and internal

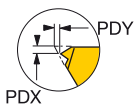
		Pitch, mm							
		1.5	2	3	4	5	6	7	8
External	PDY	1.37 .054	1.37 .054	1.27 .050	1.42 .056	1.42 .056	0.81 .032	0.81 .032	0.54 .021
	PDX	1.00 .039	1.10 .043	1.60 .063	1.90 .075	2.10 .083	2.40 .094	2.40 .094	3.30 .130
Internal	PDY		1.40 .055	1.29 .051	1.45 .057	1.45 .057	0.83 .033	1.03 .041	0.54 .021
	PDX		1.00 .043	1.60 .063	1.90 .075	2.10 .083	2.40 .094	2.40 .094	3.30 .130
No. of infeeds		Radial infeed per pass							
1		0.22 .009	0.22 .009	0.20 .008	0.24 .009	0.27 .011	0.29 .012	0.34 .013	0.32 .013
2		0.21 .008	0.21 .008	0.19 .007	0.23 .009	0.27 .010	0.29 .011	0.33 .013	0.31 .012
3		0.19 .008	0.20 .008	0.18 .007	0.22 .009	0.26 .010	0.28 .011	0.32 .013	0.31 .012
4		0.17 .007	0.19 .007	0.18 .007	0.22 .009	0.25 .010	0.27 .011	0.32 .012	0.30 .012
5		0.14 .006	0.17 .007	0.17 .007	0.21 .008	0.24 .009	0.27 .010	0.31 .012	0.29 .012
6		0.08 .003	0.16 .006	0.17 .007	0.20 .008	0.23 .009	0.26 .010	0.30 .012	0.29 .011
7			0.13 .005	0.16 .006	0.19 .008	0.22 .009	0.25 .010	0.29 .011	0.28 .011
8			0.08 .006	0.15 .007	0.18 .008	0.21 .010	0.24 .011	0.28 .011	0.27 .011
9				0.14 .006	0.17 .007	0.20 .008	0.23 .009	0.26 .010	0.26 .010
10				0.13 .005	0.16 .006	0.19 .007	0.22 .009	0.25 .010	0.25 .010
11				0.11 .005	0.14 .006	0.17 .007	0.21 .008	0.24 .009	0.25 .010
12				0.08 .003	0.13 .005	0.16 .006	0.20 .008	0.22 .009	0.24 .009
13					0.08 .003	0.13 .005	0.19 .007	0.21 .008	0.23 .009
14						0.08 .003	0.17 .007	0.19 .007	0.22 .008
15							0.15 .006	0.16 .006	0.20 .008
16							0.10 .004	0.10 .004	0.19 .007
17									0.17 .007
18									0.15 .006
19									0.10 .004
Total infeed		1.02 .040	1.36 .050	1.86 .073	2.37 .093	2.88 .113	3.63 .143	4.12 .162	4.62 .182



Total infeed = $a_p + 0.05 \text{ mm } (.002 \text{ inch})$

UNJ, external

		Pitch, TPI									
		32	28	24	20	18	16	14	12	10	8
	PDY	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32
	PDX	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052
	PDY	0.50	0.80	0.80	0.80	1.00	1.00	1.20	1.40	1.40	1.80
	PDX	.020	.031	.031	.031	.039	.039	.047	.055	.055	.071
No. of infeeds		Radial infeed per pass									
1		0.16	0.14	0.16	0.16	0.18	0.17	0.17	0.20	0.19	0.20
		.006	.005	.006	.006	.007	.007	.007	.008	.008	.008
2		0.14	0.13	0.15	0.15	0.17	0.16	0.16	0.19	0.19	0.20
		.006	.005	.006	.006	.007	.006	.006	.008	.007	.008
3		0.13	0.12	0.14	0.14	0.16	0.16	0.16	0.18	0.18	0.19
		.005	.005	.006	.006	.006	.006	.006	.007	.007	.007
4		0.08	0.11	0.12	0.13	0.15	0.15	0.15	0.17	0.17	0.18
		.003	.004	.005	.005	.006	.006	.006	.007	.007	.007
5			0.08	0.08	0.12	0.13	0.13	0.14	0.16	0.16	0.18
			.003	.003	.005	.005	.005	.005	.006	.006	.007
6					0.08	0.08	0.12	0.13	0.15	0.15	0.17
					.003	.003	.005	.005	.006	.006	.007
7							0.08	0.11	0.13	0.14	0.16
							.003	.004	.005	.006	.006
8								0.08	0.08	0.13	0.15
								.003	.003	.005	.006
9										0.12	0.14
										.005	.006
10										0.08	0.13
										.003	.005
11											0.12
											.005
12											0.08
											.003
Total infeed		0.51	0.57	0.66	0.78	0.87	0.97	1.10	1.27	1.52	1.90
		.020	.022	.026	.031	.034	.038	.043	.050	.060	.075



mm
inch

NPTF (NT), external and internal

		Pitch, TPI				
		27	18	14	11½	8
External	PDY	1.03	1.03	1.03	1.03	1.03
	PDX	.041	.041	.041	.041	.041
Internal	PDY	0.80	1.00	1.20	1.40	1.60
	PDX	.031	.039	.047	.055	.063
	PDY			1.01	1.01	1.01
	PDX			.040	.040	.040
	PDY			1.20	1.40	1.60
	PDX			.047	.055	.063
No. of infeeds		Radial infeed per pass				
1		0.14	0.16	0.17	0.17	0.19
		.005	.006	.007	.007	.008
2		0.13	0.16	0.17	0.17	0.19
		.005	.006	.007	.007	.007
3		0.13	0.15	0.16	0.16	0.18
		.005	.006	.006	.006	.007
4		0.12	0.14	0.16	0.16	0.18
		.005	.006	.006	.006	.007
5		0.11	0.13	0.15	0.15	0.18
		.004	.005	.006	.006	.007
6		0.08	0.12	0.14	0.15	0.17
		.003	.005	.006	.006	.007
7		0.11	0.13	0.14	0.14	0.17
			.004	.005	.006	.007
8		0.08	0.12	0.14	0.14	0.16
			.003	.005	.005	.006
9				0.11	0.13	0.16
				.004	.005	.006
10				0.08	0.12	0.15
				.003	.005	.006
11					0.11	0.14
					.004	.006
12					0.08	0.14
					.003	.005
13						0.13
						.005
14						0.12
						.005
15						0.11
						.004
16						0.08
						.003
Total infeed		0.70	1.06	1.41	1.69	2.36
		.028	.042	.056	.067	.093

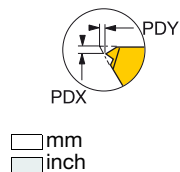
MJ, external

		Pitch, mm	
		1.5	2
	PDY	1.32	1.32
	PDX	.052	.052
	PDY	1.00	1.40
	PDX	.039	.055
No. of infeeds		Radial infeed per pass	
1		0.20	0.19
		.008	.008
2		0.18	0.18
		.007	.007
3		0.17	0.17
		.007	.007
4		0.15	0.16
		.006	.006
5		0.13	0.15
		.005	.006
6		0.08	0.14
		.003	.006
7			0.12
			.005
8			0.08
			.003
Total infeed		0.92	1.21
		.036	.048

Total infeed = $a_p + 0.05 \text{ mm}$ (.002 inch)

API thread forms

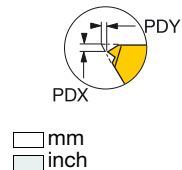
																			Total infeed
Insert	Pitch, TPI	PDY	PDX	No. of infeeds															
				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	
API 60° V-0.038R																			
Radial infeed per pass																			
266RG-22V381A0402E	4	0.88 .035	2.5 .098	0.36 .014	0.35 .014	0.33 .013	0.32 .013	0.30 .012	0.29 .011	0.27 .011	0.25 .010	0.23 .009	0.20 .008	0.16 .006	0.08 .003				3.08 .121
266RL-22V381A0402E	4	0.87 .031	2.5 .098	0.36 .014	0.35 .014	0.33 .013	0.32 .013	0.30 .012	0.29 .011	0.27 .011	0.25 .010	0.23 .009	0.20 .008	0.16 .006	0.08 .003				3.08 .121
266RG-22V381A0403E	4	0.88 .035	2.5 .098	0.36 .014	0.34 .013	0.33 .013	0.32 .013	0.30 .012	0.29 .011	0.27 .011	0.25 .010	0.23 .009	0.20 .008	0.16 .006	0.08 .003				3.07 .121
266RL-22V381A0403E	4	0.87 .031	2.5 .098	0.36 .014	0.34 .013	0.33 .013	0.32 .013	0.30 .012	0.29 .011	0.27 .011	0.25 .010	0.23 .009	0.20 .008	0.16 .006	0.08 .003				3.07 .121
API 60° V-0.040																			
266RG-22V401A0503E	5	1.38 .054	2.50 .098	0.35 .014	0.33 .013	0.32 .013	0.31 .012	0.29 .012	0.28 .011	0.26 .010	0.24 .009	0.22 .009	0.19 .008	0.16 .006	0.08 .003				2.98 .117
266RL-22V401A0503E	5	1.35 .053	2.50 .098	0.35 .014	0.33 .013	0.32 .013	0.31 .012	0.29 .012	0.28 .011	0.26 .010	0.24 .009	0.22 .009	0.19 .008	0.16 .006	0.08 .003				2.98 .117
API 60° V-0.050																			
266RG-22V501A0402E	4	0.88 .035	2.8 .110	0.34 .014	0.34 .013	0.33 .013	0.31 .012	0.30 .012	0.29 .012	0.28 .011	0.27 .011	0.25 .010	0.24 .009	0.22 .008	0.20 .007	0.18 .006	0.15 .003	0.08 .003	3.74 .147
266RL-22V501A0402E	4	0.87 .031	2.8 .110	0.34 .014	0.34 .013	0.33 .013	0.31 .012	0.30 .012	0.29 .012	0.28 .011	0.27 .011	0.25 .010	0.24 .009	0.22 .008	0.20 .007	0.18 .006	0.15 .003	0.08 .003	3.74 .147
266RG-22V501A0403E	4	0.88 .035	2.8 .110	0.34 .014	0.34 .013	0.32 .013	0.31 .012	0.30 .012	0.29 .012	0.28 .011	0.27 .011	0.25 .010	0.24 .009	0.22 .008	0.20 .007	0.18 .006	0.15 .003	0.08 .003	3.73 .147
266RL-22V501A0403E	4	0.87 .031	2.9 .114	0.34 .014	0.34 .013	0.32 .013	0.31 .012	0.30 .012	0.29 .012	0.28 .011	0.27 .011	0.25 .010	0.24 .009	0.22 .008	0.20 .007	0.18 .006	0.15 .003	0.08 .003	3.73 .147
API Round 60°																			
266RG-22RD01A100E	10	1.32 .052	1.30 .051	0.18 .007	0.18 .007	0.17 .007	0.16 .006	0.16 .006	0.15 .006	0.14 .005	0.13 .005	0.11 .004	0.08 .003						1.40 .055
266RL-22RD01A100E	10	1.30 .051	1.30 .051	0.18 .007	0.18 .007	0.17 .007	0.16 .006	0.16 .006	0.15 .006	0.14 .005	0.13 .005	0.11 .004	0.08 .003						1.40 .055
266RG-22RD01A080E	8	1.32 .052	1.50 .059	0.19 .008	0.19 .007	0.18 .007	0.18 .007	0.17 .007	0.16 .006	0.16 .006	0.15 .006	0.14 .005	0.13 .005	0.11 .003	0.08 .003				1.80 .071
266RL-22RD01A080E	8	1.3 .065	1.5 .079	0.20 .008	0.19 .007	0.18 .007	0.18 .007	0.17 .007	0.16 .006	0.16 .006	0.15 .006	0.14 .005	0.13 .005	0.11 .003	0.08 .003				1.81 .071
API Buttress																			
266RG-22BU01A050E	5	1.87 .074	2.00 .079	0.20 .008	0.19 .007	0.18 .007	0.18 .007	0.17 .007	0.16 .006	0.15 .006	0.14 .006	0.13 .005	0.12 .005	0.08 .003					1.65 .065
266RL-22BU01A050E	5	1.67 .066	2.00 .079	0.20 .008	0.19 .007	0.18 .007	0.18 .007	0.17 .007	0.16 .006	0.15 .006	0.14 .006	0.13 .005	0.12 .005	0.08 .003					1.65 .065
266RG-22BU01A0501E	5	1.67 .066	2.00 .079	0.20 .008	0.19 .007	0.18 .007	0.18 .007	0.17 .007	0.16 .006	0.15 .006	0.14 .006	0.13 .005	0.12 .005	0.08 .003					1.65 .065
266RL-22BU01A0501E	5	1.67 .066	2.00 .079	0.20 .008	0.19 .007	0.18 .007	0.18 .007	0.17 .007	0.16 .006	0.15 .006	0.14 .006	0.13 .005	0.12 .005	0.08 .003					1.65 .065



Total infeed = $a_p + 0.05 \text{ mm (.002 inch)}$

Multi-point

		ISO Metric (MM)					ISO inch (UN), external					Whitworth (WH)			NPT (NT)
		Pitch, mm					Pitch, TPI					Pitch, TPI			Pitch, TPI
		1.00	1.50	2.00	2.50	3.00	18	16	14	12	19	14	11	11 ½	
		1.62	1.42	1.91	1.98	2.79	2.14	1.52	1.79	1.91	2.04	1.73	1.88	1.67	
External	PDY	.064	.056	.075	.078	.110	.084	.060	.071	.076	.080	.068	.074	.066	
	PDX	2.02	2.20	2.90	3.75	4.40	3.45	2.40	2.70	3.10	3.30	2.70	3.40	3.40	
		.087	.087	.114	.148	.173	.136	.094	.106	.122	.130	.106	.134	.134	



No. of infeeds	Radial infeed per pass													
1	0.34	0.36	0.47	0.46	0.55	0.49	0.39	0.44	0.52	0.49	0.47	0.45	0.50	
	.013	.014	.019	.018	.022	.019	.015	.017	.020	.019	.019	.018	.020	
2	0.31	0.33	0.46	0.43	0.52	0.43	0.36	0.41	0.47	0.43	0.43	0.43	0.48	
	.012	.013	.018	.017	.020	.017	.014	.016	.019	.017	.017	.017	.019	
3		0.26	0.33	0.40	0.48		0.29	0.32	0.36		0.33	0.39	0.44	
		.010	.013	.016	.019		.011	.013	.014		.013	.015	.017	
4				0.27	0.33							0.27	0.31	
				.011	.013							.011	.012	
Total infeed	0.65	0.95	1.26	1.56	1.88	0.92	1.04	1.17	1.35	0.92	1.23	1.54	1.73	
	.026	.037	.050	.061	.074	.036	.041	.046	.053	.036	.048	.061	.068	

Internal														
		Pitch, mm					Pitch, TPI					Pitch, TPI		
		1.00	1.50	2.00	2.50	3.00	18	16	14	12	19	14	11	11 ½
		1.63	1.41	1.82	1.98	2.79				1.92		1.72	1.85	1.64
		.064	.056	.072	.078	.110				.076		.068	.073	.065
	PDY													
	PDX	2.40	2.25	2.85	3.75	4.40				2.95		2.70	3.40	3.40
		.094	.089	.112	.148	.173				.116		.106	.134	.134
No. of infeeds	Radial infeed per pass													
1	0.33	0.35	0.46	0.45	0.52				0.47		0.45	0.43	0.50	
	.013	.014	.018	.018	.020				.019		.018	.017	.020	
2	0.30	0.32	0.42	0.42	0.49				0.44		0.41	0.41	0.48	
	.012	.013	.017	.017	.019				.017		.016	.016	.019	
3		0.25	0.32	0.36	0.45				0.34		0.32	0.39	0.44	
		.010	.013	.014	.018				.013		.013	.015	.017	
4				0.25	0.32							0.27	0.31	
				.010	.013							.011	.012	
Total infeed	0.63	0.92	1.20	1.48	1.78				1.25		1.18	1.50	1.73	
	.025	.036	.047	.058	.070				.049		.046	.059	.068	

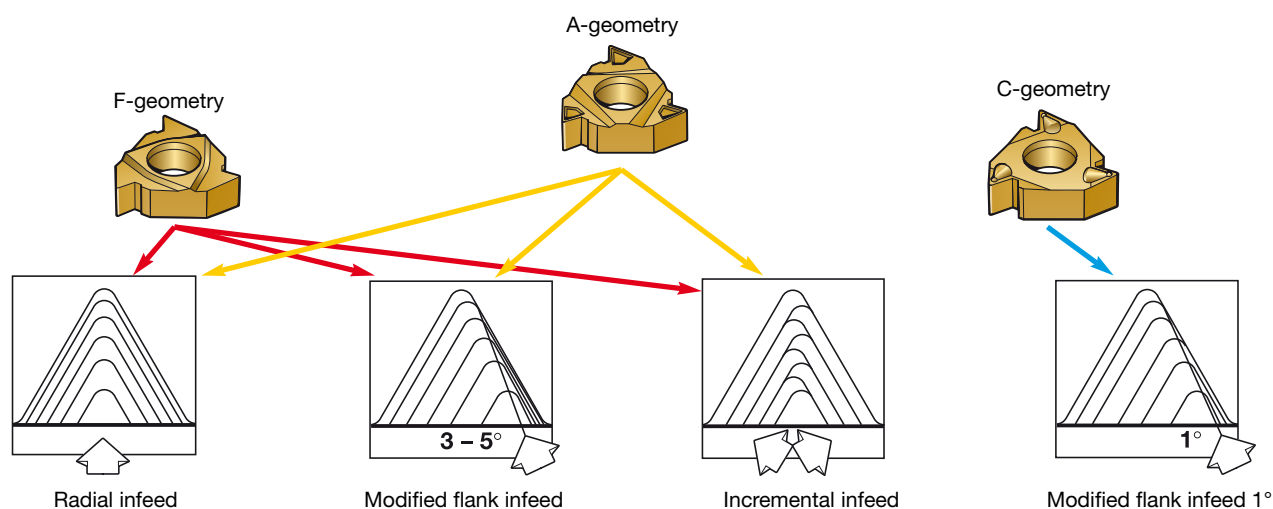
Total infeed = $a_p + 0.05 \text{ mm (.002 inch)}$

Infeed recommendations

The type of infeed, number of passes and size of infeed can have a decisive impact on the threading operation. The infeed recommendations are intended as starting values. Suitable number of passes must be determined by trial and error. The harder the workpiece the more number of passes.

- The workpiece diameter should not be more than 0.14 mm (.006 inch) larger than the max diameter of the thread to achieve optimum tool life.
- Infeeds of less than 0.05 mm (.002 inch) should be avoided, for austenitic stainless steels not less than 0.08 mm (.003 inch).

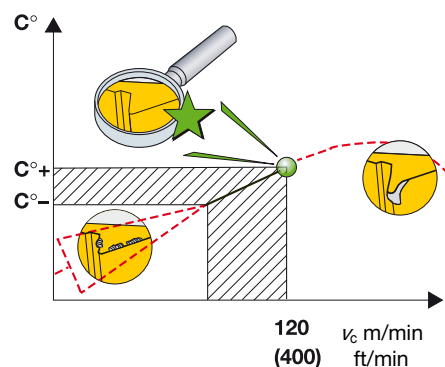
- When using a Cubic Boron Nitride (CBN) grade the max infeed value should be 0.07 mm (.003 inch).
- For C-geometry inserts, spring pass (a pass without infeed) should not be used.
- For Multi-point inserts it is essential that the recommendations on page C100 are used.
- For V-profile inserts the recommended number of passes that is used for full form inserts can be used.



Cutting speed

Starting cutting speed recommendations are given on page C85. Careful observation on the cutting edge can help you to achieve the best possible threading results.

- A cutting speed that is too low can result in built-up edge
- A cutting speed that is too high can result in plastic deformation of the edge



Formula

Formula to calculate infeed for each pass in a reduced series.

$$\Delta_{apx} = \frac{a_p}{\sqrt{nap-1}} \times \sqrt{\varphi}$$

- Δ_{ap} Radial infeed
- x Actual pass (in a series from 1 to nap)
- a_p Total depth of thread. See page C91
- nap Number of infeeds. See page C91
- φ 1st pass = 0.3
- 2nd pass = 1
- 3rd and higher passes = x-1

Grades for threading

	ISO	ANSI		
P Steel	01	C8		▲
	10			
		C7	GC 1020	GC 1125
	20			
		C6		GC 1135
	30			
M Stainless steel	40			
		C5		
	50			▼
				▲
	10	—	GC 1020	GC 1125
	20	—		GC 1135
K Cast iron				
	30	—		H13A
	40	—		
				▼
	01	C4	GC 1020	GC 1125
	10	C3		GC 1135
N Non-ferrous metals				
	20	C2		H13A
	30	C1		
	40			▼
				▲
	10	C4	GC 1020	GC 1135
S Heat resistant and super alloys				
	20	C3		H13A
	30	C2		
	40	C1		▼
				▲
	10	—	GC 1020	GC 1125
H Hardened materials				
	20	—		GC 1135
	30	—		H13A
	40	—		
				▼
				▲
H Hardened materials	10	C4	GC 1020	GC 1125
	20	C3		CB 7015
	30	C2		
	40	C1		
				▼
				▲

The position and form of the grade symbols indicate the suitable field of application.

Centre of the field of application.

Recommended field of application.

▲ Wear resistance

▼ Toughness

GC 1020

Additional coverage due to the F-geometry

Grades for threading



Steel, cast steel, long chipping malleable iron

GC1020 (HC) – P20 (P10-P40)

Good all round PVD-coated grade for threading steels. Combines good wear resistance with edge sharpness also in low carbon.

GC1125 (HC) – P20 (P05-P35)

PVD-coated grade with very good wear resistance for various steel threadings. To be used at high cutting speeds and long cutting times.

GC1135 (HC) – P25 (P10-P45)

Good allround PVD-coated grade with good wear resistance and edge line toughness for various steel threadings. To be used at medium cutting speeds.



Austenitic/ferritic/martensitic stainless steel, cast steel, manganese steel, alloy cast iron, malleable iron, free cutting steel.

GC1020 (HC) – M20 (M10-M30)

Good all round PVD-coated grade for threading stainless steels. Combines good wear resistance with edge sharpness.

GC1125 (HC) – M20 (M10-M30)

PVD-coated grade for stainless steels and other smearing materials at higher cutting speed.

H13A (HW) – M25 (M20-M30)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness. For moderate to low speeds.

GC1135 (HC) – M25 (M10-M35)

Good allround PVD-coated grade with good wear resistance and very good edge line toughness for stainless steels and other smearing materials. To be used at medium cutting speeds. First choice in M-area and toughness demanding threading operations.



Cast iron, chilled cast iron, short chipping malleable iron.

GC1020 (HC) – K15 (K01-K20)

Good PVD-coated all round grade for threading cast iron. Combines good wear resistance with edge sharpness. Moderate cutting speeds.

GC1125 (HC) – K15 (K05-K20)

PVD-coated grade with very good wear resistance in short chipping materials. To be used at high cutting speeds.

H13A (HW) – K20 (K10-K25)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness. For moderate to low speeds.

GC1135 (HC) – K20 (K10-K30)

Good allround PVD-coated grade with good wear resistance and very good edge line toughness for toughness demanding threading operations in K-area



Non ferrous metals

GC1020 (HC) – N25 (N10-N30)

Good all round PVD-coated grade with good wear resistance and edge sharpness in non-ferrous materials.

H13A (HW) – N25 (N20-N30)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness for medium to rough turning of aluminum alloys and brass.

GC1135 (HC) – N25 (N10-N30)

Good allround PVD-coated carbide grade with very good edge line toughness for all kinds of threading operations in non-ferrous metals. To be used at medium cutting speeds.



Heat resistant and super alloys

GC1020 (HC) – S20 (S05-S30)

A PVD-coated carbide grade for toughness demanding super alloy operations. To be used at low cutting speeds.

GC1125 (HC) – S20 (S10-S25)

PVD-coated carbide grade for toughness demanding super alloy operations. To be used at lower cutting speeds.

H13A (HW) – S25 (S20-S30)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness for threading of heat resistant alloys and titanium alloys.

GC1135 (HC) – S25 (S10-S35)

Good allround PVD-coated carbide grade for toughness demanding super alloy threading. To be used at low cutting speeds. First choice in S-area



Hardened materials

GC1020 (HC) – H20 (H05-H30)

Good all round PVD-coated grade with good wear resistance and edge sharpness. To be used at low cutting speed.

GC1125 (HC) – H20 (H10-H25)

PVD-coated carbide grade. To be used with lower cutting speeds.

CB7015 (BN) – H15 (H01-H25)

This grade has a low content of cubic boron nitride which makes it suitable for threading applications in hardened steels.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both.

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).

CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄).

CC Ceramics as above, but coated.

Boron nitride:

BN Cubic boron nitride

Note: Cubic boron nitride is also named superhard cutting material.