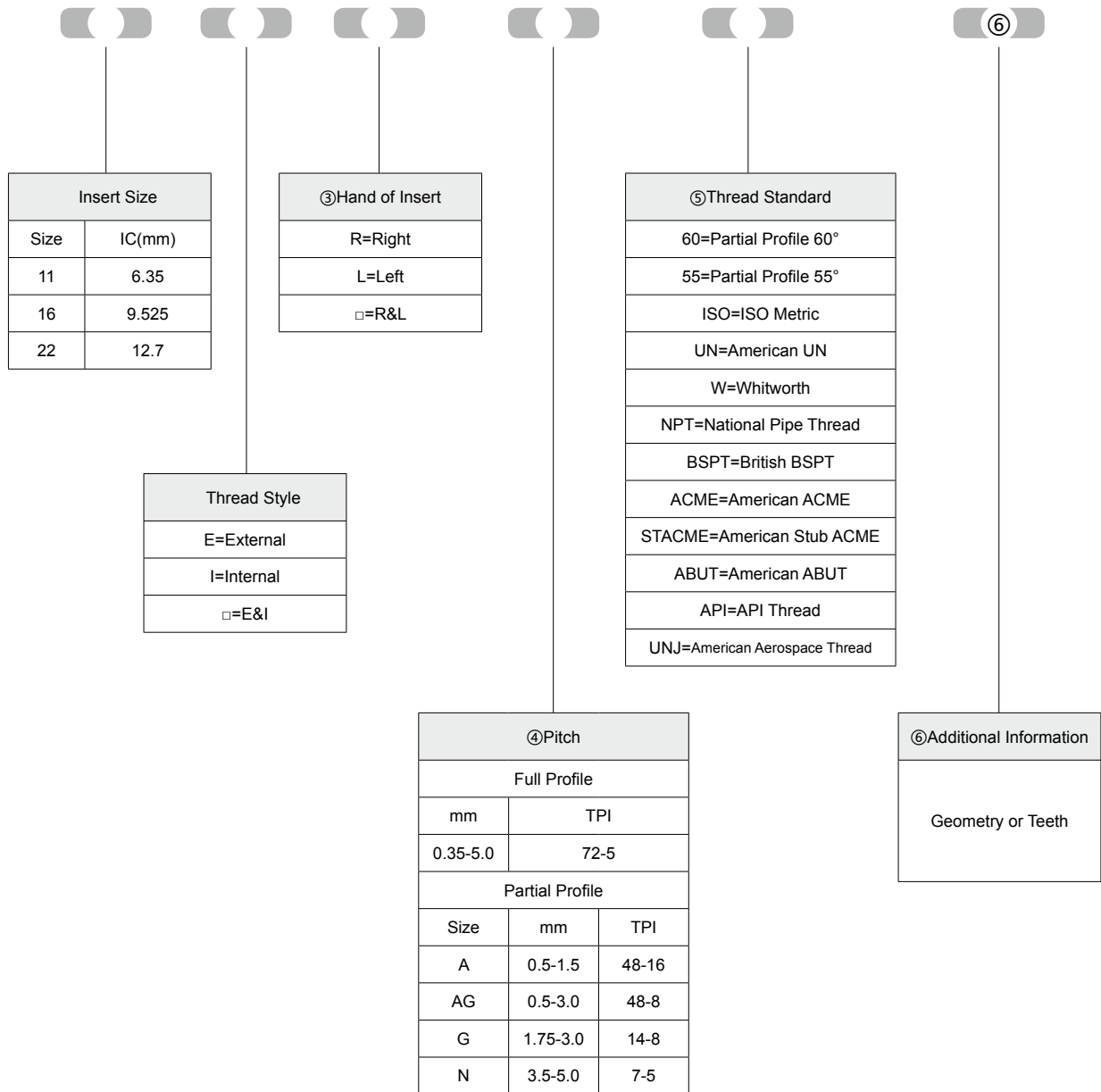


THREADING TOOLS

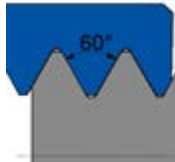
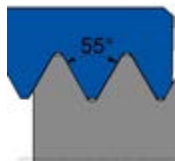
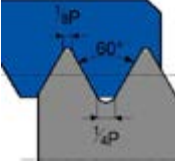
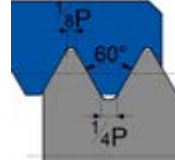
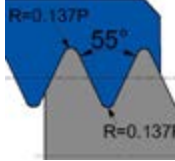
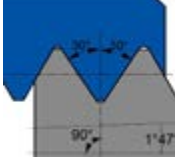
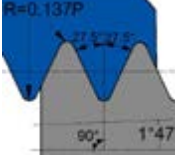
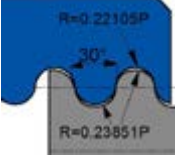


Threading Inserts Identification System

16 E R 1.50 ISO - TC



Overview of Threading Tools

Application	Thread Type	Thread Sketch	Thread Code	Pitch	Page
For general industry	Partial Profile 60°		60	0.5-5.0 (mm)	P129
	Partial Profile 55°		55	48-5 (TPI)	P130
	ISO Metric		ISO	1.0-5.0 (mm)	P131
	UN		UN	24-8 (TPI)	P133
Thread for pipe fittings and couplings for gas, water and sewage	Whitworth		W	19-11 (TPI)	P134
	NPT		NPT	27-8 (TPI)	P136
Thread for pipe fittings and couplings for gas, steam and water lines	BSPT		BSPT	28-11 (TPI)	P135
Thread for pipe couplings in food and firefighting industry	Round (DIN 405)		RD	10-4 (TPI)	P137

TC — Special Geometry

Raised Platform

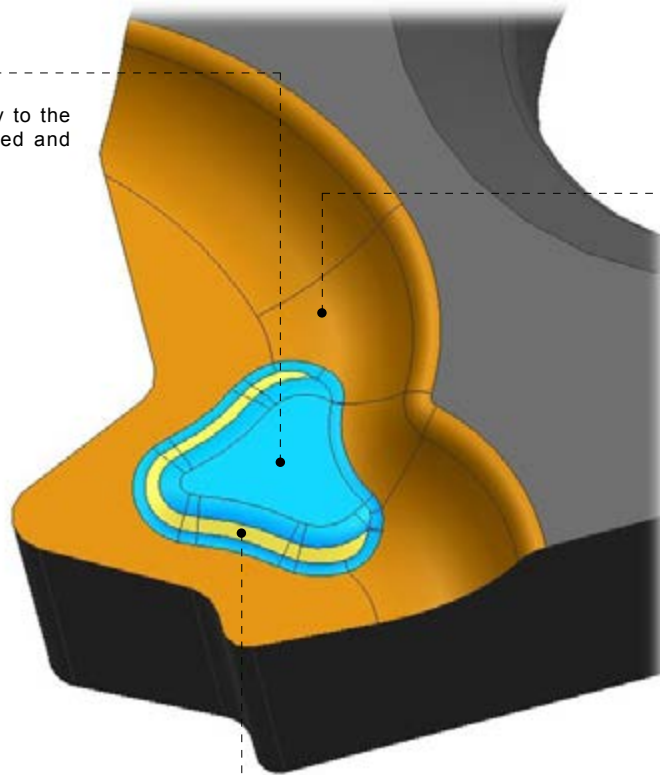
Good chip control, apply to the radial infeed, flank infeed and incremental infeed

Wide Chip Room

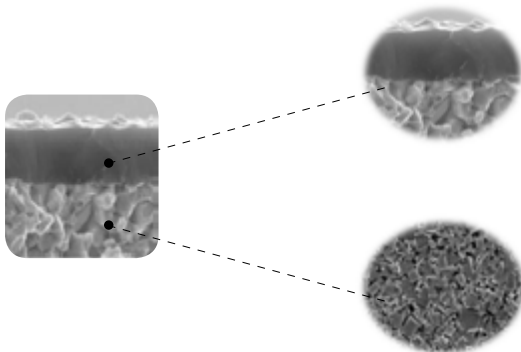
Smooth chip discharge due to wide chip room

Curved Surface

Increase the cooling area to avoid the carter wear



GM3225-General Grade for Thread Turning



New TiAlN nano-structure coating

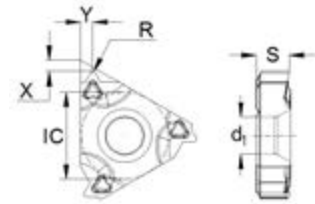
New TiAlN nano-structure coating with excellent heat resistance and bonding resistance

Micro-grain carbide substrate

Micro-grain carbide substrate with high wear resistance and good roughness, suitable for thread turning of general material.

Partial Profile 60°

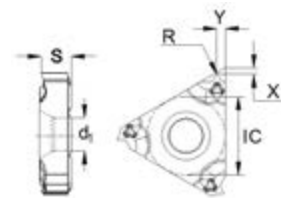
► External



Ordering Code	Pitch (mm)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	16 ERA60-TC	0.5-1.5	0.8	0.9	0.08	9.525	3.47	4	●
	16 ERAG60-TC	0.5-3.0	1.1	1.5	0.08	9.525	3.47	4	●
	16 ERG60-TC	1.75-3.0	1.2	1.7	0.25	9.525	3.47	4	●
	22 ERN60-TC	3.5-5.0	1.7	2.5	0.51	12.7	4.71	5	●

● Stock ○ Available Upon Order

► Internal

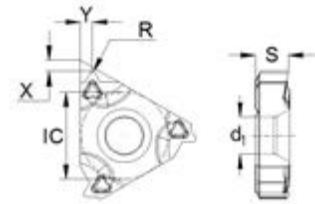



Ordering Code	Pitch (mm)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	11 IRA60-TC	0.5-1.5	0.8	0.9	0.08	6.35	3	3.2	●
	16 IRA60-TC	0.5-1.5	0.8	0.9	0.08	9.525	3.47	4	●
	16 IRAG60-TC	0.5-3.0	1.1	1.5	0.08	9.525	3.47	4	●
	16 IRG60-TC	1.75-3.0	1.2	1.7	0.13	9.525	3.47	4	●
	22 IRN60-TC	3.5-5.0	1.7	2.5	0.25	12.7	4.71	5	●

● Stock ○ Available Upon Order

Partial Profile 55°

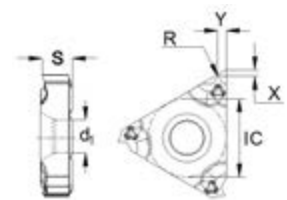
► External




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

● Stock ○ Available Upon Order

► Internal

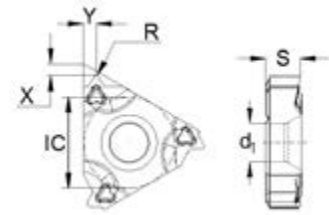



Ordering Code	Pitch (TPI)	Dimensions (mm)							Stock
		X	Y	R	IC	S	d1		
	11 IRA55-TC	48-16	0.8	0.9	0.08	6.35	3	3.2	●
	16 IRA55-TC	48-16	0.8	0.9	0.08	9.525	3.47	4	●
	16 IRAG55-TC	48-8	1.1	1.5	0.08	9.525	3.47	4	●
	16 IRG55-TC	14-8	1.2	1.7	0.21	9.525	3.47	4	●
	22 IRN55-TC	7-5	1.7	2.5	0.44	12.7	4.71	5	●

● Stock ○ Available Upon Order

Metric 60°

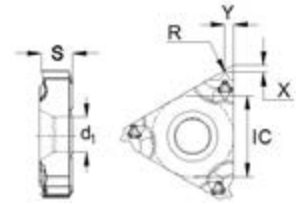
► External



Ordering Code	Pitch (mm)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	16 ER1.00ISO-TC	1.00	0.8	0.7	0.14	9.525	3.47	4	●
	16 ER1.25ISO-TC	1.25	0.8	0.9	0.18	9.525	3.47	4	●
	16 ER1.50ISO-TC	1.50	0.8	1.0	0.22	9.525	3.47	4	●
	16 ER1.75ISO-TC	1.75	1.2	1.2	0.25	9.525	3.47	4	●
	16 ER2.00ISO-TC	2.00	1.2	1.3	0.29	9.525	3.47	4	●
	16 ER2.50ISO-TC	2.50	1.2	1.5	0.36	9.525	3.47	4	●
	16 ER3.00ISO-TC	3.00	1.2	1.5	0.43	9.525	3.47	4	●
	22 ER3.50ISO-TC	3.50	1.6	2.3	0.45	12.7	4.71	5	●
	22 ER4.00ISO-TC	4.00	1.6	2.3	0.52	12.7	4.71	5	●
	22 ER4.50ISO-TC	4.50	1.7	2.4	0.58	12.7	4.71	5	●
22 ER5.00ISO-TC	5.00	1.7	2.5	0.63	12.7	4.71	5	●	

● Stock ○ Available Upon Order

► Internal



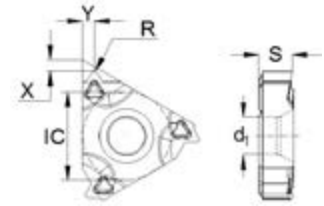
Ordering Code	Pitch (mm)	Dimensions (mm)						Stock
		X	Y	R	IC	S	d1	GM3225
11 IR1.00ISO-TC	1.00	0.8	0.7	0.07	6.35	3	3.2	●
11 IR1.25ISO-TC	1.25	0.8	0.9	0.09	6.35	3	3.2	●
11 IR1.50ISO-TC	1.50	0.8	1.0	0.11	6.35	3	3.2	●
11 IR1.75ISO-TC	1.75	0.9	1.1	0.13	6.35	3	3.2	●
11 IR2.00ISO-TC	2.00	0.9	1.1	0.15	6.35	3	3.2	●
16 IR1.00ISO-TC	1.00	0.8	0.7	0.07	9.525	3.47	4	●
16 IR1.25ISO-TC	1.25	0.8	0.9	0.09	9.525	3.47	4	●
16 IR1.50ISO-TC	1.50	0.8	1.0	0.11	9.525	3.47	4	●
16 IR1.75ISO-TC	1.75	1.2	1.2	0.13	9.525	3.47	4	●
16 IR2.00ISO-TC	2.00	1.2	1.3	0.15	9.525	3.47	4	●
16 IR2.50ISO-TC	2.50	1.2	1.5	0.18	9.525	3.47	4	●
16 IR3.00ISO-TC	3.00	1.2	1.5	0.22	9.525	3.47	4	●
22 IR3.50ISO-TC	3.50	1.6	2.3	0.22	12.7	4.71	5	●
22 IR4.00ISO-TC	4.00	1.6	2.3	0.25	12.7	4.71	5	●
22 IR4.50ISO-TC	4.50	1.6	2.4	0.28	12.7	4.71	5	●
22 IR5.00ISO-TC	5.00	1.6	2.3	0.32	12.7	4.71	5	●

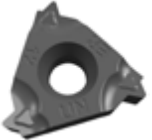


●Stock ○Available Upon Order

UN 60°

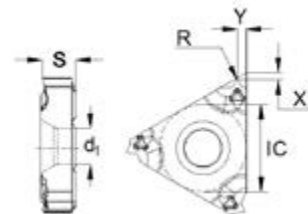
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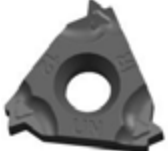


Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	16 ER24UN-TC	24	0.8	0.8	0.15	9.525	3.47	4	●
	16 ER20UN-TC	20	0.8	0.9	0.18	9.525	3.47	4	●
	16 ER18UN-TC	18	0.8	1.0	0.20	9.525	3.47	4	●
	16 ER16UN-TC	16	0.9	1.1	0.23	9.525	3.47	4	●
	16 ER14UN-TC	14	1.2	1.5	0.26	9.525	3.47	4	●
	16 ER12UN-TC	12	1.2	1.5	0.31	9.525	3.47	4	●
	16 ER10UN-TC	10	1.2	1.5	0.37	9.525	3.47	4	○
	16 ER8UN-TC	8	1.3	1.7	0.46	9.525	3.47	4	●

●Stock ○Available Upon Order

► Internal

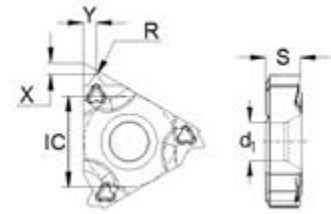


Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	11 IR20UN-TC	20	0.8	0.9	0.09	6.35	3	3.2	●
	11 IR18UN-TC	18	0.8	1.0	0.10	6.35	3	3.2	●
	16 IR24UN-TC	24	0.8	0.8	0.08	9.525	3.47	4	●
	16 IR20UN-TC	20	0.8	0.9	0.09	9.525	3.47	4	●
	16 IR18UN-TC	18	0.8	1.0	0.10	9.525	3.47	4	●
	16 IR16UN-TC	16	0.9	1.1	0.12	9.525	3.47	4	●
	16 IR14UN-TC	14	1.2	1.5	0.13	9.525	3.47	4	●
	16 IR12UN-TC	12	1.2	1.5	0.16	9.525	3.47	4	●
	16 IR10UN-TC	10	1.2	1.5	0.19	9.525	3.47	4	○
	16 IR8UN-TC	8	1.3	1.7	0.23	9.525	3.47	4	●

●Stock ○Available Upon Order

Whitworth 55°

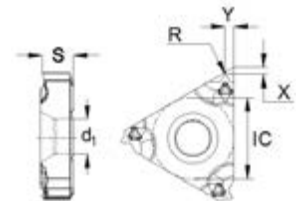
► External



Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	16 ER19W-TC	19	0.8	1.0	0.17	9.525	3.47	4	●
	16 ER14W-TC	14	1.2	1.5	0.24	9.525	3.47	4	●
	16 ER11W-TC	11	1.2	1.5	0.30	9.525	3.47	4	●

● Stock ○ Available Upon Order

► Internal

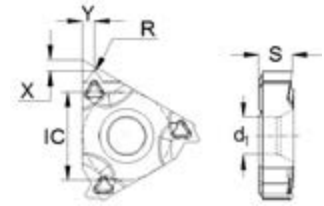



Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	16 IR19W-TC	19	0.8	1.0	0.17	9.525	3.47	4	●
	16 IR14W-TC	14	1.2	1.5	0.24	9.525	3.47	4	●
	16 IR11W-TC	11	1.2	1.5	0.30	9.525	3.47	4	●

● Stock ○ Available Upon Order

BSPT 55°

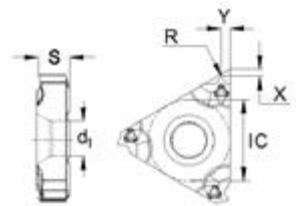
► External




Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	16 ER28BSPT-TC	28	0.7	0.8	0.11	9.525	3.47	4	●
	16 ER19BSPT-TC	19	0.8	1.0	0.17	9.525	3.47	4	●
	16 ER14BSPT-TC	14	1.2	1.5	0.24	9.525	3.47	4	●
	16 ER11BSPT-TC	11	1.2	1.5	0.30	9.525	3.47	4	●

● Stock ○ Available Upon Order

► Internal

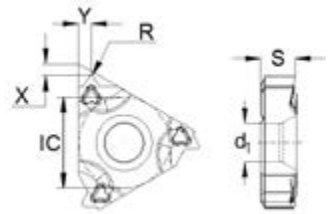



Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	11 IR19BSPT-TC	19	0.8	1.0	0.18	6.35	3	3.2	●
	11 IR14BSPT-TC	14	0.9	1.1	0.24	6.35	3	3.2	●
	16 IR28BSPT-TC	28	0.7	0.8	0.11	9.525	3.47	4	●
	16 IR19BSPT-TC	19	0.8	1.0	0.17	9.525	3.47	4	●
	16 IR14BSPT-TC	14	1.2	1.5	0.24	9.525	3.47	4	●
	16 IR11BSPT-TC	11	1.2	1.5	0.30	9.525	3.47	4	●

● Stock ○ Available Upon Order

NPT 60°

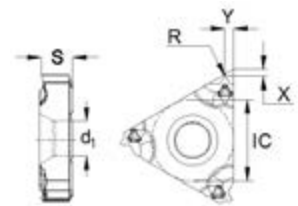
► External




Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	16 ER27NPT-TC	27	0.7	0.8	0.13	9.525	3.47	4	●
	16 ER18NPT-TC	18	0.8	1.0	0.20	9.525	3.47	4	●
	16 ER14NPT-TC	14	1.2	1.5	0.22	9.525	3.47	4	●
	16 ER11.5NPT-TC	11.5	1.2	1.5	0.25	9.525	3.47	4	●
	16 ER8NPT-TC	8	1.3	1.8	0.30	9.525	3.47	4	●

● Stock ○ Available Upon Order

► Internal

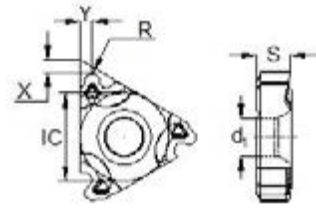



Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	11 IR18NPT-TC	18	0.8	1.0	0.20	6.35	3	3.2	●
	16 IR27NPT-TC	27	0.7	0.8	0.13	9.525	3.47	4	●
	16 IR18NPT-TC	18	0.8	1.0	0.20	9.525	3.47	4	●
	16 IR14NPT-TC	14	1.2	1.5	0.22	9.525	3.47	4	●
	16 IR11.5NPT-TC	11.5	1.2	1.5	0.25	9.525	3.47	4	●
	16 IR8NPT-TC	8	1.3	1.8	0.30	9.525	3.47	4	●

● Stock ○ Available Upon Order

Round30°

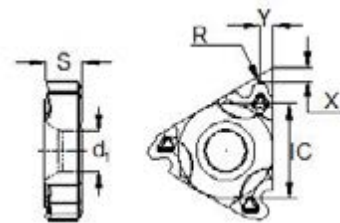
► External




Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	16 ER10RD-TC	10	1.1	1.2	0.60	9.525	3.47	4	○
	16 ER8RD-TC	8	1.4	1.3	0.75	9.525	3.47	4	●
	16 ER6RD-TC	6	1.4	1.5	1.00	9.525	3.47	4	●
	22 ER4RD-TC	4	2.2	2.3	1.51	12.7	4.71	5	○

● Stock ○ Available Upon Order

► Internal



Ordering Code	Pitch (TPI)	Dimensions (mm)						Stock	
		X	Y	R	IC	S	d1	GM3225	
	16 IR10RD-TC	10	1.1	1.2	0.55	9.525	3.47	4	○
	16 IR8RD-TC	8	1.4	1.3	0.70	9.525	3.47	4	●
	16 IR6RD-TC	6	1.4	1.5	0.936	9.525	3.47	4	●
	22 IR4RD-TC	4	2.2	2.3	1.40	12.7	4.71	5	○

● Stock ○ Available Upon Order

Cutting Speed Recommendation Table

Workpiece Material			Material Hardness	Cutting Speed Vc (m/min)	
				Grade	
				GM3225	
P	Carbon Steel	Low-carbon (C=0.1-0.25%)	HB125	160 (120-230)	
		Medium-carbon (C=0.25-0.55%)	HB150	150 (100-195)	
		High-carbon (C=0.55-0.80%)	HB170	140 (90-180)	
	Low-alloy Steel	Non-hardened	HB180	130 (100-180)	
		Hardened and tempered	HB275	100 (75-140)	
		Hardened and tempered	HB350	80 (60-130)	
	High-alloy Steel	Annealed	HB200	110 (80-140)	
		Hardened and tempered	HB325	90 (70-115)	
	Cast Steel	Unalloyed	HB180	200 (180-220)	
		Low-alloy	HB200	110 (70-150)	
		High-alloy	HB225	100 (60-120)	
		Manganese steel (12-14% Mn)	HB250	40 (40-50)	
M	Stainless Steel	Austenitic	HB180	120 (90-140)	
		Ferrite/Martensite	HB200	140 (70-170)	
		Duplex stainless steel	HB230	90 (60-120)	
K	Malleable Cast Iron	Ferrite	HB130	130 (110-170)	
		Pearlite	HB230	100 (85-145)	
	Gray Cast Iron	Low tensile strength	HB180	120 (100-160)	
		High tensile strength	HB260	100 (80-140)	
	Nodular Cast Iron	Ferrite	HB160	125 (110-160)	
		Pearlite	HB250	100 (80-120)	
N	Wrought Aluminum Alloys	Non aging	HB60	500 (350-700)	
		Aged	HB100	400 (300-500)	
	Cast Aluminum Alloys	Non aging	HB75	450 (300-500)	
		Aged	HB90	290 (200-400)	
		Containing silicon (13-22% Si)	HB130	200 (100-300)	
	Copper and Copper Alloys	Brass	HB90	220 (100-300)	
		Bronze and non-lead copper	HB100	180 (80-255)	
S	Heat-resistant Alloys	Iron base	Annealed	HB200	45 (35-60)
			Aged	HB280	35 (25-50)
		Nickel base and cobalt base	Annealed	HB250	25 (15-30)
			Aged	HB350	15 (10-25)
	Titanium Alloys	Cast	HB320	13 (10-20)	
		Commercial pure (99.5% Ti)	400Rm	150 (140-170)	
H	High Hardness Materials	α + β alloys	1050Rm	60 (50-70)	
		Hardened steel	HRC55	45 (40-50)	
		Chilled cast iron	HB400	40 (30-50)	

Cutting Passes and Radial Infeed Recommendation Table

► ISO Metric / External

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

► ISO Metric / External

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

► UN / External

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

► UN / Internal

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

► Whitworth / External & Internal

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

► BSPT / External & Internal

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

► NPT /External& Internal

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

► Round / External

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

► Round / Internal

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

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