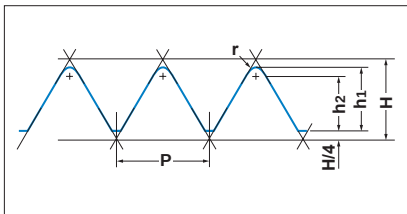


INSERTS

Type	Order Number	Class	Coated	Cermet	Carbide		ISO Pitch mm (thread/inch)	Dimensions (mm)			Geometry
			UP20M	NX2525	UTi20T	HTi10		D1	S1	Re	
Partial Profile 60°	MTTR436000	G		●	●		—0.8	12.7	4.76	0	MTTR/L(60°) Partial form   Right hand insert shown.
	R436001	G	★	●	●	★	1.0—1.75	12.7	4.76	0.1	
	L436001	G	★		●	★	1.0—1.75	12.7	4.76	0.1	
	R436002	G	★	●	●	★	2.0—2.5	12.7	4.76	0.2	
	L436002	G		●	●		2.0—2.5	12.7	4.76	0.2	
	R436003	G	★	●	●	★	3.0—3.5	12.7	4.76	0.3	
	L436003	G		●	●		3.0—3.5	12.7	4.76	0.3	
Partial Profile 55°	MTTR435501	G		●	★		(28—10)	12.7	4.76	0.1	MTTR/L(55°) Partial form   Right hand insert shown.
	R435502	G		●	●		(16—8)	12.7	4.76	0.2	
	R435503	G		●	●		(11—8)	12.7	4.76	0.3	

STANDARD OF DEPTH OF CUT

- The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- When using cermet grades or cutting stainless steel, please increase the number of passes by 2—3 times.



METRIC SCREW THREAD

P (Pitch)		0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50
h1		0.46	0.61	0.77	0.92	1.07	1.23	1.53	1.84	2.15	2.45	2.76
h2		0.35	0.47	0.59	0.70	0.82	0.94	1.17	1.41	1.65	1.87	2.11
r (Nose Radius)		0.11	0.14	0.18	0.22	0.25	0.29	0.36	0.43	0.50	0.58	0.65
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35	0.35	0.40
	2	0.13	0.15	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35
	3	0.10	0.10	0.12	0.15	0.20	0.20	0.20	0.25	0.25	0.25	0.30
	4	0.05	0.10	0.12	0.15	0.15	0.15	0.20	0.20	0.20	0.25	0.25
	5		0.06	0.10	0.10	0.12	0.15	0.15	0.20	0.20	0.25	0.25
	6			0.05	0.07	0.10	0.10	0.10	0.15	0.20	0.20	0.20
	7					0.05	0.08	0.10	0.15	0.15	0.20	0.20
	8						0.05	0.10	0.10	0.15	0.15	0.15
	9							0.08	0.10	0.10	0.15	0.15
	10							0.05	0.09	0.10	0.10	0.15
	11								0.05	0.10	0.10	0.10
	12									0.05	0.10	0.10
	13										0.05	0.10
	14											0.06

(Note) The first pass causes a high load on the cutting edge.
In order to avoid damage, keep the depth of cut to 0.4—0.5mm maximum.