

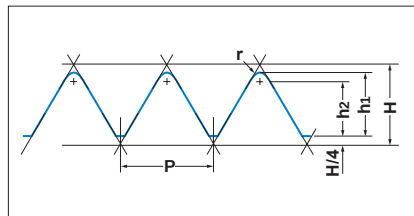
INSERTS

Application	Order Number	Coated	Carbide	Thread Pitch, Groove Width W ₃ (mm)	Dimensions (mm)						Geometry
		UP20M	UTi20T		L1	L2	L3	S1	C	Re	
Threading	MLT1001L	★	●	Pitch 1.5—2.0	7	5	—	2.38	—	0.1	MLT type
	1401L	★	●	Pitch 1.5—2.5	11.8	6.5	—	4.76	—	0.1	
	2001L	★	●	Pitch 1.5—3.5	16.8	9.03	—	6.35	—	0.1	
Grooving	MLG1012L		●	1.2	7	5	1.0	2.38	0.1	—	MLG...L
	1015L		●	1.5	7	5	1.0	2.38	0.1	—	
	1020L		●	2	7	5	1.0	2.38	0.1	—	
	MLG1415L		●	1.5	11.8	6.5	2.0	4.76	0.1	—	MLG...L
	1420L		●	2	11.8	6.5	2.0	4.76	0.1	—	
	1430L		●	3	11.8	6.5	2.0	4.76	0.1	—	
	2020L		●	2	16.8	9.03	3.0	6.35	0.1	—	
	2030L		●	3	16.8	9.03	3.0	6.35	0.1	—	
	2040L		●	4	16.8	9.03	3.0	6.35	0.1	—	

THREADING

STANDARD OF DEPTH OF CUT

- The chart on the right shows the cutting depths when machining internal 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
h ₁	0.43	0.58	0.72	0.87	1.01	1.15	1.44	1.73	2.02
h ₂	0.38	0.51	0.63	0.76	0.88	1.01	1.21	1.51	1.77
r (Nose Radius)	0.05	0.07	0.09	0.11	0.13	0.14	0.18	0.22	0.25
Number of Passes	1	0.10	0.15	0.18	0.20	0.23	0.25	0.25	0.30
	2	0.10	0.13	0.15	0.20	0.20	0.20	0.22	0.25
	3	0.10	0.10	0.12	0.15	0.20	0.15	0.20	0.22
	4	0.08	0.10	0.12	0.15	0.15	0.15	0.20	0.20
	5	0.05	0.05	0.10	0.10	0.10	0.15	0.15	0.20
	6		0.05	0.05	0.07	0.08	0.10	0.10	0.15
	7					0.05	0.10	0.10	0.12
	8						0.05	0.10	0.10
	9							0.07	0.10
	10							0.05	0.09
	11								0.05
	12								0.05

(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.