

How to choose your threading tool

1 Define your type of operation

Select the threading method, page C4:

- 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 C80.

3 Select tooling system and type of holder

Choose Coromant Capto or shank tool, depending on clamping possibilities in turret/spindle, on page G5.

Choose type of holder and coupling size or shank on page C7.

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 C45 for CoroThread 266 and page C57 for T-Max U-Lock.

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

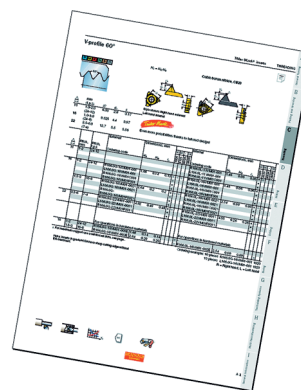
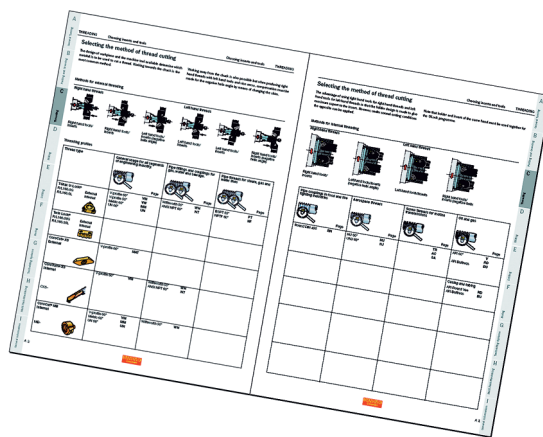
Threading holders are supplied as standard with a shim giving a +1° inclination angle.

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

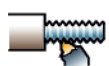
5 Select size, number of passes and speed

The recommendations are intended as starting values. (Page C70)

Cutting speed recommendations, see page C82.



For more technical information, see our Metalcutting Technical Guide.



External threading



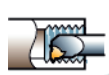
Coromant Capto® unit



Inserts



Conversion table, formulas and definitions



Internal threading



Shank holder



Spare parts/accessories



Grade descriptions



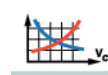
CoroTurn® SL internal adapters



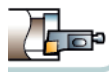
Boring bar



Sleeves



Technical information



Cartridges



Tooling system



How to choose tool, overview



Tailor Made options

THREADING

Applications

Threading profiles	C4
Methods for external and internal machining	C6

Products

Toolholder overview	C7
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CoroThread® 266 for threading C9

Inserts

Insert code key	C10
V-profile 60° and 55°	C11
Engineering industry MM, UN	C19
Pipe fittings WH, NT	C19
Pipe threads PT, NF	C24
Pipe couplings RN	C25
Aerospace threads MJ, UNJ	C27
Trapezoidal screw threads TR, AC, SA	C30
Oil and gas threads V-, RD, BU	C30

Holders

Toolholder code key	C35
Selecting shims	C45

T-Max U-Lock® for threading and grooving C47

Inserts

V-profile 60° and 55°	C47
Engineering industry MM, UN	C48
Pipe fittings WH, NT	C50

Holders

Selecting shims	C57
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T-Max Twin-Lock® for oil pipe threading

Code key	C58
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Inserts

Holders	C60
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CoroTurn® SL flexible system I1

Other systems for threading

CoroCut® XS, external tools for small part machining	B88
CoroTurn® XS, internal tools for small part machining	A309
CoroCut® MB, internal tools for precision machining	B95

Spare parts C63

Cutting data

Infeed recommendations	C70
Cutting speed recommendations	C82

Grade information C86

All types of threads

CoroThread® 266

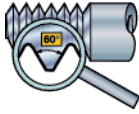
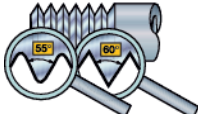
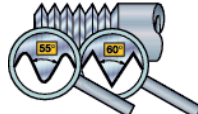






Ultra-rigid threading, insert sizes 16, 22 and 27 (3/8", 1/2" and 5/8")

T-Max U-Lock®

Insert size 11



Threading profiles

Thread type	General usage for all segments of engineering industry.	Pipe fittings and couplings for gas, water and sewage	Pipe threads for steam, gas and water lines
			
	Page	Page	Page
CoroThread® 266 266R/LG External 266R/LL Internal 	V-profile 60° VM C11 V-profile 55° VW C13 Metric 60° MM C14 UN 60° UN C17	Whitworth 55° WH C19 NPT 60° NT C21	BSPT 55° PT C22 NPTF 60° NF C23
T-Max® U-Lock R/L166.0L Internal 	V-profile 60° VM C47 V-profile 55° VW C47 Metric 60° MM C48 UN 60° UN C49	Whitworth 55° WH C50 NPT 60° NT C50	
T-Max Twin-Lock® R/L166.39G External R/L166.39L Internal 			
CoroCut® XS MATR/L External 	V-profile 60° B93		
CoroTurn® XS Internal  CXS-	V-profile 60° VM A322 Metric 60° MM A322 UN 60° UN A322	Whitworth 55° WH A322 NPT 60° NT A322	
CoroCut® MB Internal  MB-	V-profile 60° VM B103 Metric 60° MM B103 UN 60° UN B103	Whitworth 55° WH B103 NPT 60° NT B103	


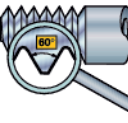
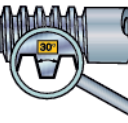
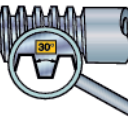
A General Turning
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 I CoroTurn® SL
 J General information

T-Max Twin-Lock®

Threading in oil and gas industry, primarily casing and tubing

Small part machining

CoroCut® XS for external and CoroTurn® XS for internal threading
CoroCut® MB for internal precision threading

 <p>Pipe couplings in food and firefighting industries</p> <p>Page</p>	 <p>Aerospace threads</p> <p>Page</p>	 <p>Screw threads for motion transmissions</p> <p>Page</p>	 <p>Oil and gas</p> <p>Page</p>
<p>Round DIN 405 RN C24</p>	<p>MJ 60° MJ C25 UNJ 60° NJ C26</p>	<p>ISO Trapezoidal TR C27 ACME AC C28 STUB-ACME SA C28</p>	<p>API 60° V C30 API Buttress RD C31 BU C32</p>
			<p>Casing and tubing API Round 60° RD C59 API-Buttress (BU) BU C59</p>
		<p>ISO Trapezoidal TR A322</p>	
		<p>ACME AC C28 STUB-ACME SA C29</p>	

Selecting the method of thread cutting

The machine tool and the design of the workpiece determine which method is to be used to cut a thread. Working towards the chuck is the most common method.

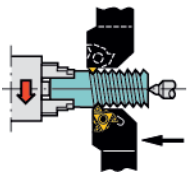
The advantage of using right hand tools for right hand threads and left hand tools for left hand threads is that the holder design is made to give maximum support to the insert.

Working away from the chuck is also possible but when producing right hand threads with left hand tools and vice versa, compensation must be made for the negative helix angle by means of changing the shim.

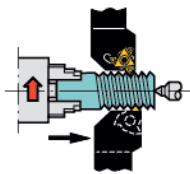
Note that a holder and insert of the same hand must be used together for the CoroThread and U-Lock programs.

Methods for external threading

Right hand threads

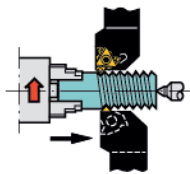


Right hand tools/inserts



Right hand tools/inserts

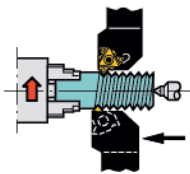
Pull threading



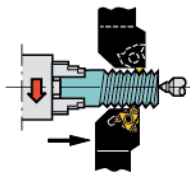
Left hand tools/inserts (negative helix angle)

Pull threading

Left hand threads

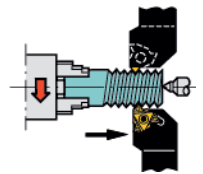


Left hand tools/inserts



Left hand tools/inserts

Pull threading

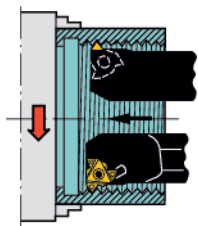


Right hand tools/inserts (negative helix angle)

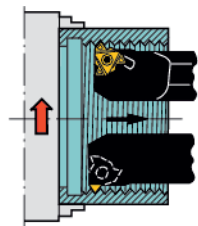
Pull threading

Methods for internal threading

Right hand threads



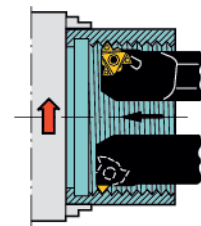
Right hand tools/inserts



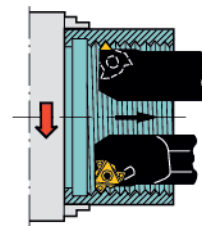
Left hand tools/inserts (negative helix angle)

Pull threading

Left hand threads



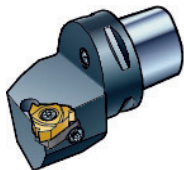
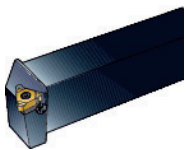

Left hand tools/inserts


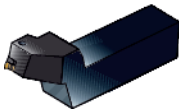

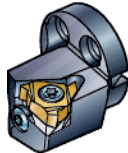


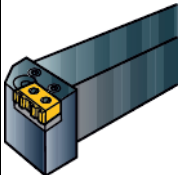
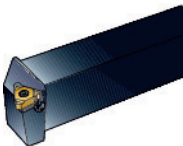
Right hand tools/inserts (negative helix angle)

Pull threading

External threading and circlip grooving

	General threading		For swiss machines	Threading of slender components and against live center	
				To be used with CoroThread 266 inserts	
	CoroThread® 266R/LFG	CoroThread® 266R/LFG	CoroThread® 266R/LFA	T-Max® U-Lock R/L166.5FA	T-Max® U-Lock R/L166.5FA
Insert size, mm (iC, inch)	16, 22, 27 (3/8, 1/2, 5/8)	16, 22, 27 (3/8, 1/2, 5/8)	16 (3/8)	16 (3/8)	16 (3/8)
Coromant Capto® sizes	C3-C8	–	–	C3-C6	–
Shank dim., mm	–	1616-4040	1010-1616	–	1212-2525
Shank size, inch	–	.750-1.500	.375-.750	–	.500-1.250
Page	C35	C36	C37	C51	C52

	Drop head design for upside down mounting			CoroThread® 266 SL- external cutting head
				
	CoroThread® 266R/LFGZ	CoroThread® 266R/LFGZ	T-Max® U-Lock R/L166.5FAZ	CoroThread® SL-266R/LFG
Insert size, mm (iC, inch)	16, 22, 27 (3/8, 1/2, 5/8)	16, 22 (3/8, 1/2)	16 (3/8)	16 (3/8)
Coromant Capto® sizes	C4-C6	–	C3-C6	–
Shank dim., mm	–	2525-3232	–	–
Shank size, inch	–	.750-1.250	–	–
Coupling size	–	–	–	20-40
Page	C35	C36	C51	I52

	T-Max Twin-Lock®	Small part machining QS™ holding system
		
	R166.39FG	QS-266 RFA
Insert size, mm (inch)	24 (.945)	16 (3/8)
Shank dim., mm	3232	1010-1616
Shank size, inch	1.260	.376-.825
Page	C60	C38

Internal threading and circlip grooving

	Coromant Capto			Carbide reinforced bars	Drop head design for upside down mounting
			Cylindrical, cylindrical with flats		
	CoroThread® 266R/LKF	T-Max® U-Lock R/L166.0KF	CoroThread® 266R/LKF	T-Max® U-Lock R/L166.0KF	T-Max® U-Lock R/L166.0KFZ
Insert size, mm (iC, inch)	16-22 (3/8-1/2)	11 (1/4)	16, 22, 27 (3/8, 1/2, 5/8)	11 (1/4)	11 (1/4)
Coromant Capto® sizes	C3-C6	C3-C4	–	–	C3-C4
Bar diameter, mm (inch)	–	–	20-50 (.750-2.000)	10-16 (.625-.750)	–
Page	C39	C53	C41	C55	C53
	SL cutting head		Cartridges		
					
	CoroThread® SL-266R/LKF	T-Max® U-Lock R/L566.0KFC	CoroThread® 266	CoroThread® SL-266RKF	
Insert size, mm (iC, inch)	16, 22, 27 (3/8, 1/2, 5/8)	11 (3/4)	16, 22 (3/8, 1/2)	22, 27 (1/2, 5/8)	
SL coupling size, mm	25-40	16-20	–	80	
Cartridge size	–	–	16CA-20CA	–	
Page	I53	I54	C44	I86	
T-Max Twin-Lock®	SL cutting head	Cartridge	T-Max P cartridge		
					
	T-Max Twin-Lock® R566.39KF	T-Max Twin-Lock® 466.39	T-Max Twin-Lock® R466.3KW		
Insert size, mm (inch)	24 (.945)	24 (.945)	16 (3/8)		
Coupling size, mm	40	–	–		
Cartridge size, mm (inch)	–	18 (.709)	20 (.787)		
Page	C60	C61	C62		

For cylindrical sleeves, see page A304.

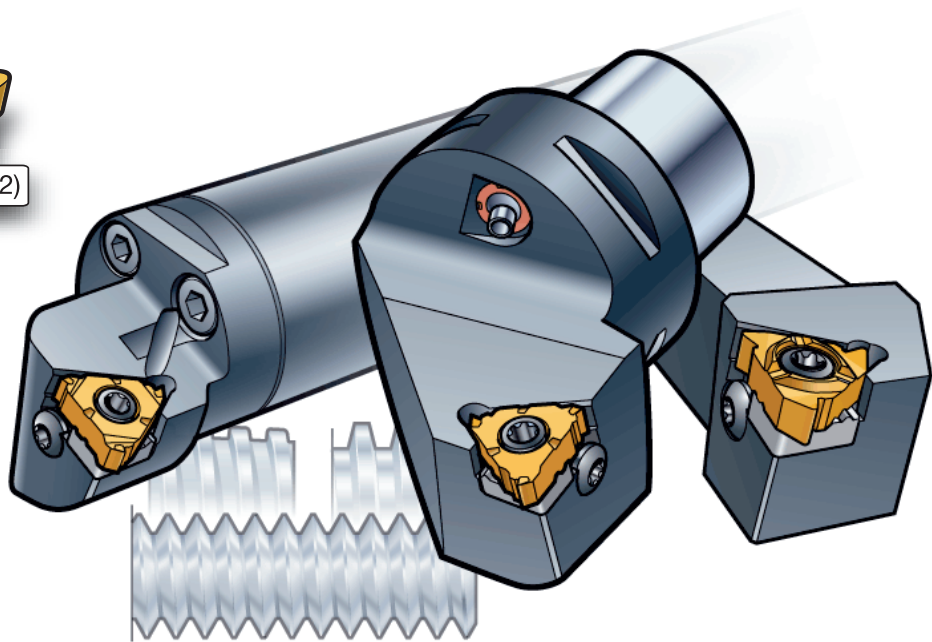
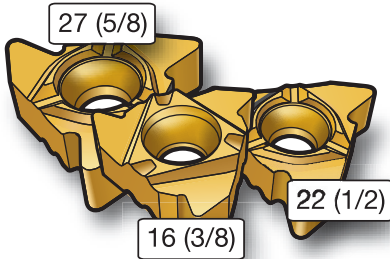
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CoroThread® 266

Ultra-rigid thread turning

For all types of threads
 Insert sizes: 3/8, 1/2 and 5/8 (16, 22 and 27 mm)
 (3/8, 1/2 and 5/8 inch)

Insert sizes



- Full profile - for high productivity



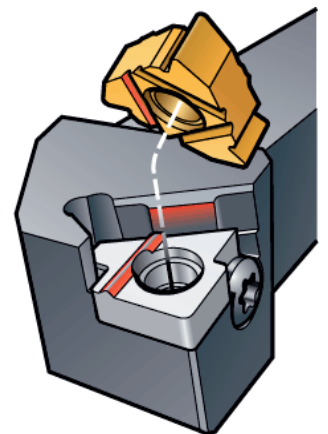
- V-profile - for minimum tool inventory



- Multi-point - for economic threading in mass production



Easy clamping of new inserts on guide rail.



Unique Tailor Made service

Enables you to order inserts for almost any thread form or pitch. See page J3.

Grades for all materials

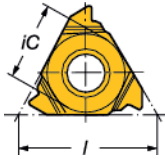
Basic grades GC1125
 GC1135
 GC1020

ISO application areas:



Code key for CoroThread® 266 inserts

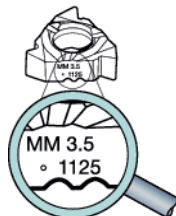
266	R	G	-	22	TR0	1	F	600		E
1	2	3		4	5	6	7	8	9	10

1 Main code	2 Hand of tool	3 Type of machining	4 Insert size/dimension
266 = CoroThread® 266	R = Right hand style L = Left hand style	G = Inserts for external threading L = Inserts for internal threading	16 = iC 3/8" = 9.52 mm 22 = iC 1/2" = 12.70 mm 27 = iC 5/8" = 15.88 mm 

5 Thread profile	6 Number of points per cutting edge
VM0 = V-profile 60° VW0 = V-Profile 55° MM0 = Metric 60° UN0 = UN 60° WH0 = Whitworth 55° NT0 = NPT 60° RN0 = Round 30° PT0 = BSPT 55° TR0 = Trapezoidal 30° AC0 = ACME 29° SA0 = STUB-ACME 29° NJ0 = UNJ 60° MJ0 = MJ 60° NF0 = NPTF 60° BU0 = Buttress RD0 = API Rd 60° V38 = V-0.038R V40 = V-0.040 V50 = V-0.050	Varies from 1 to 3 points. 1 = 1 point 2 = 2 points 3 = 3 points

7 Cutting edge condition	8 Pitch	9 Supplementary code
A = Edge rounded (ER) F = Sharp cutting edge C = Chip forming geometry	mm: pitch x 100 Inch: number of threads per inch x 10	Taper on diameter/inch per foot (i.p.f.) 1 = 1 i.p.f. 2 = 2 i.p.f. 3 = 3 i.p.f.

10 Tolerance of cutting edge position
M = ± 0.05 mm (.002 inch) axial E = ± 0.01 mm (.0004 inch) axial



1) Marking:
All inserts are marked with the profile, grade and pitch: internal inserts are identified with a circle. To prevent erasure, the marking is laser marked on the side of the inserts.

11 Cubic boron nitride inserts
E = Edge rounded (ER)

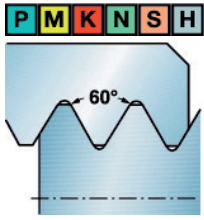


External right hand inserts
Internal left hand inserts

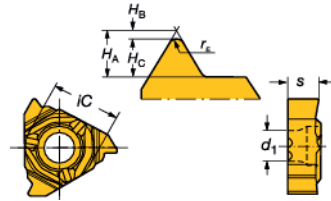


External left hand inserts
Internal right hand inserts

V-profile 60° Non-topping



$$H_C = H_A - H_B$$



Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

iC	Pitch, TPI	Pitch, mm	iC mm	d_1	s
16	3/8	24-8	9.53	4.4 (.173)	3.97 (.156)
22	1/2	7-4	12.7	5.55 (.217)	5.56 (.219)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

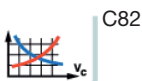
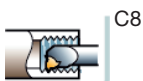
iC	Pitch, mm	Pitch, TPI	Ordering code	Dimensions, mm, inch				P		M		K		N		S		
				H_A mm	H_A in.	H_B mm	H_B in.	r_e mm	r_e in.	GC	GC	GC	GC	GC	GC	GC	GC	
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135
16	3/8	1-2.00	24-12	266R/LG-16VM01A001M	1.68	.0661	0.14	.0055	0.13	.0051	★	☆	★	★	★	★	★	
				266RG-16VM01C001M														
				266RG-16VM01F001E														
16	3/8	1.5-3	16-8	266R/LG-16VM01A002M	2.64	.1039	0.20	.0079	0.20	.0079	★	☆	★	★	★	★	★	
				266RG-16VM01C002M														
				266RG-16VM01F002E														
22	1/2	3.5-6	7-4	266R/LG-22VM01A001M	4.92	.1937	0.48	.0189	0.48	.0189	★	★	★	★	★	★	★	
				266RG-22VM01F001E														

Internal

iC	Pitch, mm	Pitch, TPI	Ordering code	Dimensions, mm, inch				P		M		K		N		S	
				H_A mm	H_A in.	H_B mm	H_B in.	r_e mm	r_e in.	GC	GC	GC	GC	GC	GC	GC	GC
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125
16	3/8	1-2.00	24-12	266R/LL-16VM01A001M	1.45	.0571	0.06	.0024	0.06	.0024	★	☆	★	★	★	★	★
				266RL-16VM01C001M													
				266RL-16VM01F001E													
16	3/8	1.5-3	16-8	266R/LL-16VM01A002M	2.54	.1000	0.09	.0035	0.09	.0035	★	☆	★	★	★	★	★
				266RL-16VM01C002M													
				266RL-16VM01F002E													
22	1/2	3.5-6	7-4	266R/LL-22VM01A001M	4.35	.1713	0.26	.0102	0.26	.0102	★	★	★	★	★	★	★
				266RL-22VM01F001E													

266R = Right hand, 266L = Left hand

★ = First choice



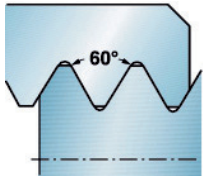
A General Turning
B Parting and Grooving
C Threading
G Tooling systems
H Multi-task machining
I CoroTurn® SL
J General information

V-profile 60° Non-topping

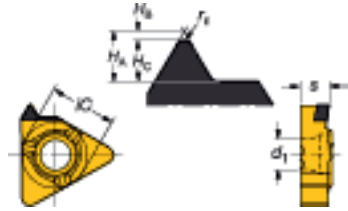
Advanced cutting materials

For threading in hardened materials

P M K N S H



$$H_C = H_A - H_B$$



Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

iC	Pitch, TPI	Pitch, mm	iC mm	d_1	s
16	3/8	24-8	1.0-3.0	9.53	4.4 (.173) 3.97 (.156)

External

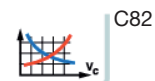
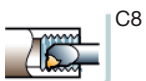
For ISO application areas, see bottom of the table.

iC	Pitch, mm	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)						H	
				H_A mm	H_A in.	H_B mm	H_B in.	r_e mm	r_e in.		
16	3/8	1-2.00	24-12	266RG-16VM01A001EE	1.68	.0661	0.14	.0055	0.13	.0051	★
		1.5-3	16-8	266RG-16VM01A002EE	2.64	.1039	0.20	.0079	0.20	.0079	★

Internal

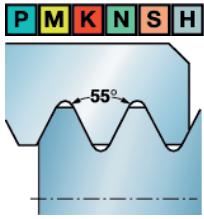
iC	Pitch, mm	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)						H	
				H_A mm	H_A in.	H_B mm	H_B in.	r_e mm	r_e in.		
16	3/8	1.5-3	16-8	266RL-16VM01A002EE	2.54	.1000	0.09	.0035	0.09	.0035	★

266R = Right hand
★ = First choice

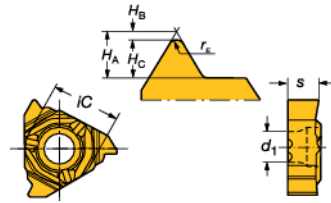


A General Turning B Parting and Grooving C Threading G Tooling systems H Multi-task machining I CoroTurn® SL J General information

V-profile 55° Non-topping



$$H_c = H_A - H_b$$



Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

	iC	Pitch, TPI	iC mm	d ₁	s
16	3/8	28-8	9.53	4.4 (.173)	3.97 (.156)
22	1/2	7-4	12.7	5.5 (.217)	5.56 (.219)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

External

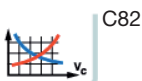
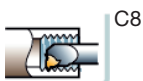
For ISO application areas, see bottom of the table.

	iC	Pitch, TPI	Ordering code	Dimensions, mm, inch						P		M		K		N		S		
				H _A mm	H _A in.	H _B mm	H _B in.	r _c mm	r _c in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125
16	3/8	28-14	266RG-16VW01A001M	1.68	.0661	0.13	.0051	0.11	.0043	★	★	★	★	★	★	★	★	★	★	
			266LG-16VW01A001M								★		★		★		★		★	
			266RG-16VW01C001M									★		★		★		★		★
		266RG-16VW01F001E																		
		14-8	266RG-16VW01A002M	2.79	.1098	0.26	.0102	0.23	.0091	★	★	★	★	★	★	★	★	★	★	★
			266LG-16VW01A002M									★		★		★		★		★
266RG-16VW01C002M										★		★		★		★		★		
266RG-16VW01F002E																				
22	1/2	7-4	266RG-22VW01A001M	5.23	.2059	0.53	.0209	0.48	.0189	★	★	★	★	★	★	★	★	★	★	
			266LG-22VW01A001M									★		★		★		★		★
			266RG-22VW01F001E																	
										P20	P25	M20	M25	K15	K20	N25	N20	N25	S20	S25

Internal

	iC	Pitch, TPI	Ordering code	Dimensions, mm, inch						P		M		K		N		S		
				H _A mm	H _A in.	H _B mm	H _B in.	r _c mm	r _c in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125
16	3/8	28-14	266RL-16VW01A001M	1.60	.0630	0.12	.0047	0.11	.0043	★	★	★	★	★	★	★	★	★	★	
			266LL-16VW01A001M																	
			266RL-16VW01C001M									★		★		★		★		★
		266RL-16VW01F001E																		
		14-8	266RL-16VW01A002M	2.80	.1102	0.25	.0098	0.23	.0091	★	★	★	★	★	★	★	★	★	★	★
			266LL-16VW01A002M																	
266RL-16VW01C002M										★		★		★		★		★		
266RL-16VW01F002E																				
22	1/2	7-4	266RL-22VW01A001M	5.18	.2039	0.53	.0209	0.47	.0185	★	★	★	★	★	★	★	★	★	★	
			266LL-22VW01A001M																	
			266RL-22VW01F001E																	
										P20	P25	M20	M25	K15	K20	N25	N20	N25	S20	S25

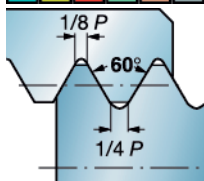
266R = Right hand, 266L = Left hand
★ = First choice



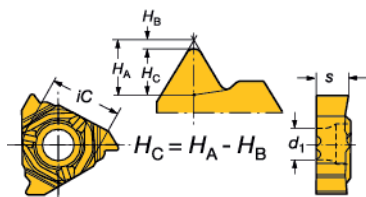
A General Turning
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Metric 60° Topping

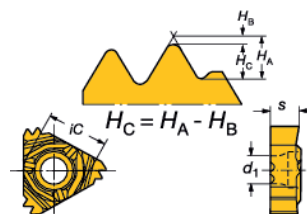
Threads for general usage in all segments of engineering industry



Single-point



Multi-point



ISO 965-1998 Tolerance class 6

Style shown: Right hand external, Left hand internal

266RG- 2A250E

2 = Two points
3 = Three points

Dimensions, mm (inch)

Δ	iC	Pitch, mm	iC mm	d_1	s
16	3/8	0.5-3.0	9.53	4.4 (.173)	3.97 (.156)
22	1/2	2.5-6.0	12.7	5.5 (.217)	5.56 (.219)



Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

Δ	iC	Pitch, mm	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S		
				H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC			
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135			
16	3/8	0.50	266RG-16MM01A050M	0.37	.0146	0.08	.0031	*	*	*	*	*	*	*	*	*	*	
			266LG-16MM01A050M					*	*	*	*	*	*	*	*	*	*	*
		0.75	266RG-16MM01A075M	0.56	.0220	0.11	.0043	*	*	*	*	*	*	*	*	*	*	*
			266LG-16MM01A075M					*	*	*	*	*	*	*	*	*	*	*
		0.80	266RG-16MM01F080E	0.60	.0236	0.11	.0043	*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM03A100M	0.75	.0295	0.15	.0059	*	*	*	*	*	*	*	*	*	*	*
		1.00	266RG-16MM01A100M					*	*	*	*	*	*	*	*	*	*	*
			266LG-16MM01A100M					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01C100M					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01F100E					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01A125M	0.93	.0366	0.19	.0075	*	*	*	*	*	*	*	*	*	*	*
			266LG-16MM01A125M					*	*	*	*	*	*	*	*	*	*	*
		1.25	266RG-16MM01C125M					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01F125E					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM02A150M	1.12	.0441	0.22	.0087	*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01A150M					*	*	*	*	*	*	*	*	*	*	*
		1.50	266LG-16MM01A150M					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01C150M					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01F150E					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01A175M	1.31	.0516	0.25	.0098	*	*	*	*	*	*	*	*	*	*	*
		1.75	266LG-16MM01A175M					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01C175M					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM01F175E					*	*	*	*	*	*	*	*	*	*	*
			266RG-16MM02A200M	1.50	.0591	0.29	.0114	*	*	*	*	*	*	*	*	*	*	*
2.00	266RG-16MM01A200M					*	*	*	*	*	*	*	*	*	*	*		
	266LG-16MM01A200M					*	*	*	*	*	*	*	*	*	*	*		
	266RG-16MM01C200M					*	*	*	*	*	*	*	*	*	*	*		
	266RG-16MM01F200E					*	*	*	*	*	*	*	*	*	*	*		
	266RG-16MM01A250M	1.87	.0736	0.36	.0142	*	*	*	*	*	*	*	*	*	*	*		
	266LG-16MM01A250M					*	*	*	*	*	*	*	*	*	*	*		
2.50	266RG-16MM01C250M					*	*	*	*	*	*	*	*	*	*	*		
	266RG-16MM01F250E					*	*	*	*	*	*	*	*	*	*	*		
	266RG-16MM01A300M	2.25	.0886	0.42	.0165	*	*	*	*	*	*	*	*	*	*	*		
	266LG-16MM01A300M					*	*	*	*	*	*	*	*	*	*	*		
3.00	266RG-16MM01C300M					*	*	*	*	*	*	*	*	*	*	*		
	266RG-16MM01F300E					*	*	*	*	*	*	*	*	*	*	*		
	266RG-16MM01A300M					*	*	*	*	*	*	*	*	*	*	*		
	266RG-16MM01C300M					*	*	*	*	*	*	*	*	*	*	*		

266R = Right hand, 266L = Left hand
* = First choice


Continued ...



A General Turning B Parting and Grooving C Threading G Tooling systems H Multi-task machining I CoroTurn® SL J General information

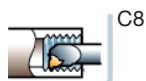
... Continued
External

For ISO application areas, see bottom of the table.

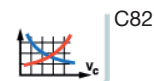
	iC	Pitch, mm	Ordering code	Dimensions, millimeter, inch (mm, in.)				P			M			K			N			S				
				H _A mm	H _A in.	H _B mm	H _B in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135
22	1/2	2.50	266RG-22MM02A250E	1.87	.0736	0.36	.0142	★			★			★		★			★					
		3.00	266RG-22MM02A300E	2.25	.0886	0.42	.0165	★			★			★		★			★					
		3.50	266RG-22MM01A350M	2.62	.1031	0.49	.0193	★	★		☆	★			☆	★		★			★	★		
			266LG-22MM01A350M					★			★				★		★				★			
			266RG-22MM01F350E					★			★				★		★				★			
		4.00	266RG-22MM01A400M	3.00	.1181	0.56	.0220	★	★		☆	★			☆	★		★			★	★		
			266LG-22MM01A400M					★			★				★		★				★			
			266RG-22MM01F400E					★			★				★		★				★			
		4.50	266RG-22MM01A450M	3.37	.1327	0.63	.0248	☆	★		☆	★			☆	★		☆	★		☆	★		
			266LG-22MM01A450M					★			★				★		★				★			
		5.00	266RG-22MM01A500M	3.76	.1480	0.71	.0280	☆	★		☆	★			☆	★		☆	★		☆	★		
			266LG-22MM01A500M					★			★				★		★				★			
		5.50	266RG-22MM01A550M	4.13	.1626	0.79	.0311	★	★		☆	★			☆	★		☆	★		☆	★		
			266LG-22MM01A550M					★			★				★		★				★			
		6.00	266RG-22MM01A600M	4.51	.1776	0.86	.0339	☆	★		☆	★			☆	★		☆	★		☆	★		
			266LG-22MM01A600M					★			★				★		★				★			
										P20	P25	P25	M20	M20	M25	K15	K15	K20	N25	N25	N25	S20	S20	S25

266R = Right hand, 266L = Left hand
★ = First choice

Continued ...



C8



C82



C86



C2



J3



I8

A
 General Turning
 B
 Parting and Grooving
 C
 Threading
 G
 Tooling systems
 H
 Multi-task machining
 I
 CoroTurn® SL
 J
 General information

... Continued
Internal

For ISO application areas, see bottom of the table.

△	iC	Pitch, mm	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S		
				H _A mm	H _A in.	H _B mm	H _B in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135
16	3/8	0.50	266RL-16MM01A050M	0.32	.0126	0.03	.0012	★	☆	★	☆	★	☆	★	☆	★	☆	
			266LL-16MM01A050M					★	☆	★	☆	★	☆	★	☆			
		0.75	266RL-16MM01A075M	0.47	.0185	0.04	.0016	★	☆	★	☆	★	☆	★	☆	★	☆	
			266LL-16MM01A075M					★	☆	★	☆	★	☆	★	☆			
		1.00	266RL-16MM03A100M	0.64	.0252	0.06	.0024	★	☆	★	☆	★	☆	★	☆	★	☆	★
			266RL-16MM01A100M					★	☆	★	☆	★	☆	★	☆			
	266LL-16MM01A100M		★					☆	★	☆	★	☆	★	☆				
	266RL-16MM01C100M		★					☆	★	☆	★	☆	★	☆				
	266RL-16MM01F100E		★					☆	★	☆	★	☆	★	☆				
	266RL-16MM01A125M		★					☆	★	☆	★	☆	★	☆				
	1.25	266LL-16MM01A125M	0.79	.0311	0.07	.0028	★	☆	★	☆	★	☆	★	☆	★	☆	★	
		266RL-16MM01C125M					★	☆	★	☆	★	☆	★	☆				
		266RL-16MM01F125E					★	☆	★	☆	★	☆	★	☆				
	1.50	266RL-16MM02A150M	0.96	.0378	0.09	.0035	★	☆	★	☆	★	☆	★	☆	★	☆	★	
		266RL-16MM01A150M					★	☆	★	☆	★	☆	★	☆				
		266LL-16MM01A150M					★	☆	★	☆	★	☆	★	☆				
		266RL-16MM01C150M					★	☆	★	☆	★	☆	★	☆				
		266RL-16MM01F150E					★	☆	★	☆	★	☆	★	☆				
		266RL-16MM01A175M					★	☆	★	☆	★	☆	★	☆				
	1.75	266LL-16MM01A175M	1.11	.0437	0.11	.0043	★	☆	★	☆	★	☆	★	☆	★	☆	★	
		266RL-16MM01C175M					★	☆	★	☆	★	☆	★	☆				
		266RL-16MM01F175E					★	☆	★	☆	★	☆	★	☆				
		266RL-16MM02A200M					★	☆	★	☆	★	☆	★	☆				
	2.00	266RL-16MM01A200M	1.27	.0500	0.12	.0047	★	☆	★	☆	★	☆	★	☆	★	☆	★	
266LL-16MM01A200M		★					☆	★	☆	★	☆	★	☆					
266RL-16MM01C200M		★					☆	★	☆	★	☆	★	☆					
266RL-16MM01F200E		★					☆	★	☆	★	☆	★	☆					
266RL-16MM01A250M		★					☆	★	☆	★	☆	★	☆					
266LL-16MM01A250M		★					☆	★	☆	★	☆	★	☆					
2.50	266RL-16MM01C250M	1.59	.0626	0.16	.0063	★	☆	★	☆	★	☆	★	☆	★	☆	★		
	266RL-16MM01F250E					★	☆	★	☆	★	☆	★	☆					
	266RL-16MM01A300M					★	☆	★	☆	★	☆	★	☆					
	266LL-16MM01A300M					★	☆	★	☆	★	☆	★	☆					
3.00	266RL-16MM01C300M	1.92	.0756	0.19	.0075	★	☆	★	☆	★	☆	★	☆	★	☆	★		
	266RL-16MM01F300E					★	☆	★	☆	★	☆	★	☆					
	266RL-22MM02A250E					★	☆	★	☆	★	☆	★	☆					
	266RL-22MM02A300E					★	☆	★	☆	★	☆	★	☆					
22	1/2	2.50	266RL-22MM01A350M	2.24	.0882	0.26	.0102	☆	★	☆	★	☆	★	☆	★	☆	★	
			266LL-22MM01A350M					☆	★	☆	★	☆	★	☆	★			
		4.00	266RL-22MM01A400M	2.56	.1008	0.30	.0118	★	☆	★	☆	★	☆	★	☆	★	☆	
			266LL-22MM01A400M					★	☆	★	☆	★	☆	★	☆			
		4.50	266RL-22MM01A450M	2.89	.1138	0.33	.0130	☆	★	☆	★	☆	★	☆	★	☆	★	
			266LL-22MM01A450M					☆	★	☆	★	☆	★	☆	★			
		5.00	266RL-22MM01A500M	3.21	.1264	0.38	.0150	★	☆	★	☆	★	☆	★	☆	★	☆	
			266LL-22MM01A500M					★	☆	★	☆	★	☆	★	☆			
		5.50	266RL-22MM01A550M	3.54	.1394	0.40	.0157	☆	★	☆	★	☆	★	☆	★	☆	★	☆
			266LL-22MM01A550M					☆	★	☆	★	☆	★	☆	★			
		6.00	266RL-22MM01A600M	3.86	.1520	0.47	.0185	☆	★	☆	★	☆	★	☆	★	☆	★	☆
			266LL-22MM01A600M					☆	★	☆	★	☆	★	☆	★			

266R = Right hand, 266L = Left hand
★ = First choice



A
General Turning
B
Parting and Grooving
C
Threading
G
Tooling systems
H
Multi-task machining
I
CoroTurn® SL
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General information

... Continued
External

For ISO application areas, see bottom of the table.

△	iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S	
				H _A mm	H _A in.	H _B mm	H _B in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
								1020	1125	1020	1125	1020	1125	1020	1125	1020	1125
16	3/8	8	266RG-16UN01A080M	2.38	.0937	0.41	.0161	★	☆	★	☆	★	☆	★	☆	★	☆
			266LG-16UN01A080M					★	☆			★	☆			★	☆
			266RG-16UN01C080M					★	☆	★	☆	★	☆	★	☆	★	☆
			266RG-16UN01F080E					★	☆	★	☆	★	☆	★	☆	★	☆
22	1/2	7	266RG-22UN01A070M	2.70	.1063	0.49	.0193	★		★		★		★		★	
		6	266RG-22UN01A060M	3.16	.1244	0.57	.0224	★		★		★		★		★	
		5	266RG-22UN01A050M	3.81	.1500	0.69	.0272	★		★		★		★		★	
		4.5	266RG-22UN01A045M	4.23	.1665	0.77	.0303	★		★		★		★		★	
		4	266RG-22UN01A040M	4.76	.1874	0.87	.0343	★		★		★		★		★	
								P20	P25	M20	M25	K15	K20	N25	N20	S20	S25

266R = Right hand, 266L = Left hand
★ = First choice

Internal

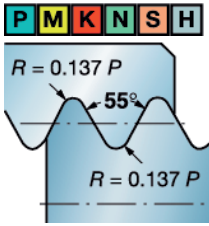
△	iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S	
				H _A mm	H _A in.	H _B mm	H _B in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
								1020	1125	1020	1125	1020	1125	1020	1125	1020	1125
16	3/8	32	266RL-16UN01A320M	0.50	.0197	0.04	.0016	★		★		★		★		★	
		28	266RL-16UN01A280M	0.58	.0228	0.05	.0020	★		★		★		★		★	
		24	266RL-16UN01A240M	0.67	.0264	0.06	.0024	★		★		★		★		★	
		20	266RL-16UN01A200M	0.80	.0315	0.07	.0028	★	☆	★	☆	★	☆	★	☆	★	☆
			266LL-16UN01A200M					★	☆	★	☆	★	☆	★	☆	★	☆
			266RL-16UN01C200M					★		★		★		★		★	
		18	266RL-16UN01A180M	0.89	.0350	0.08	.0031	★	☆	★	☆	★	☆	★	☆	★	☆
			266LL-16UN01A180M					★	☆	★	☆	★	☆	★	☆	★	☆
			266RL-16UN01C180M					★		★		★		★		★	
		16	266RL-16UN01A160M	1.00	.0394	0.09	.0035	★	☆	★	☆	★	☆	★	☆	★	☆
			266LL-16UN01A160M					★	☆	★	☆	★	☆	★	☆	★	☆
			266RL-16UN02A160M					★		★		★		★		★	
			266RL-16UN01C160M					★		★		★		★		★	
			266RL-16UN01F160E					★		★		★		★		★	
		14	266RL-16UN01A140M	1.13	.0445	0.11	.0043	★	☆	★	☆	★	☆	★	☆	★	☆
			266LL-16UN01A140M					★	☆	★	☆	★	☆	★	☆	★	☆
			266RL-16UN01C140M					★		★		★		★		★	
		12	266RL-16UN01A120M	1.33	.0524	0.13	.0051	★	☆	★	☆	★	☆	★	☆	★	☆
			266LL-16UN01A120M					★	☆	★	☆	★	☆	★	☆	★	☆
			266RL-16UN02A120M					★		★		★		★		★	
266RL-16UN01C120M						★		★		★		★		★			
	266RL-16UN01F120E					★		★		★		★		★			
11	266RL-16UN01A110M	1.45	.0571	0.14	.0055	★	☆	★	☆	★	☆	★	☆	★	☆		
	266LL-16UN01A110M					★	☆	★	☆	★	☆	★	☆	★	☆		
10	266RL-16UN01A100M	1.59	.0626	0.16	.0063	★	☆	★	☆	★	☆	★	☆	★	☆		
	266LL-16UN01A100M					★	☆	★	☆	★	☆	★	☆	★	☆		
9	266R/LL-16UN01A090M	1.77	.0697	0.18	.0071	★		★		★		★		★			
	266RL-16UN01A080M	2.00	.0787	0.20	.0079	★	☆	★	☆	★	☆	★	☆	★	☆		
	266LL-16UN01A080M					★		★		★		★		★			
	266RL-16UN01C080M					★		★		★		★		★			
22	1/2	7	266RL-22UN01A070M	2.31	.0909	0.26	.0102	★		★		★		★		★	
		6	266RL-22UN01A060M	2.70	.1063	0.32	.0126	★		★		★		★		★	
		5	266RL-22UN01A050M	3.25	.1280	0.38	.0150	★		★		★		★		★	
		4.5	266RL-22UN01A045M	3.62	.1425	0.41	.0161	★		★		★		★		★	
		4	266RL-22UN01A040M	4.08	.1606	0.49	.0193	★		★		★		★		★	
								P20	P25	M20	M25	K15	K20	N25	N20	S20	S25

266R = Right hand, 266L = Left hand
★ = First choice



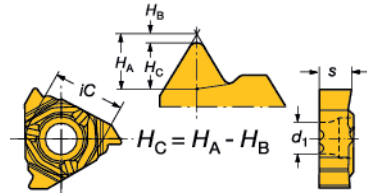
Whitworth 55° (BSW, BSF, BSP) Topping

Threads for pipe fittings and couplings for gas, water and sewage



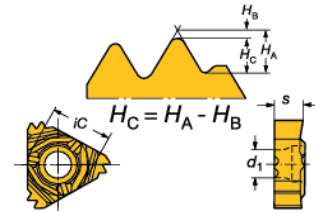
ISO 228-1982
BS 2779-1973
BS 84-1956
Class A tolerance

Single-point



Pipe threads 55°
External: G thread
Internal: G/R_p threads
Style shown: Right hand external, Left hand internal

Multi-point



266RG-22WH0 2A110E

1
2 = Two points
3 = Three points

Dimensions, mm (inch)

iC	Pitch, TPI	iC mm	d_1	s
16	3/8	28-8	9.53	4.4 (.173)
22	1/2	11-4	12.7	5.5 (.217)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P			M			K			N			S			
			H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC		
			1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135		
16	3/8	28	266RG-16WH01A280M	0.72	.0283	0.13	.0051	★	★	★	★	★	★	★	★	★	★	★	★	★		
		26	266RG-16WH01A260M	0.77	.0303	0.14	.0055	★	★	★	★	★	★	★	★	★	★	★	★	★		
		20	266RG-16WH01A200M	1.01	.0398	0.18	.0071	★	★	★	★	★	★	★	★	★	★	★	★	★	★	
		19	266RG-16WH01A190M	1.06	.0417	0.19	.0075	★	★	★	★	★	★	★	★	★	★	★	★	★	★	
			266LG-16WH01A190M					★	★	★	★	★	★	★	★	★	★	★	★	★	★	
			266RG-16WH03A190M					★	★	★	★	★	★	★	★	★	★	★	★	★	★	★
			266RG-16WH01C190M					★	★	★	★	★	★	★	★	★	★	★	★	★	★	★
			266RG-16WH01F190E					★	★	★	★	★	★	★	★	★	★	★	★	★	★	★
		18	266RG-16WH01A180M	1.12	.0441	0.20	.0079	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★
		16	266RG-16WH01A160M	1.26	.0496	0.23	.0091	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★
		14	266RG-16WH01A140M	1.44	.0567	0.26	.0102	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★
			266LG-16WH01A140M					★	★	★	★	★	★	★	★	★	★	★	★	★	★	★
			266RG-16WH02A140M					★	★	★	★	★	★	★	★	★	★	★	★	★	★	★
			266RG-16WH01C140M					★	★	★	★	★	★	★	★	★	★	★	★	★	★	★
	266RG-16WH01F140E					★	★	★	★	★	★	★	★	★	★	★	★	★	★	★		
	12	266RG-16WH01A120M	1.68	.0661	0.31	.0122	★	★	★	★	★	★	★	★	★	★	★	★	★	★		
	11	266RG-16WH01A110M	1.83	.0720	0.34	.0134	★	★	★	★	★	★	★	★	★	★	★	★	★	★		
		266LG-16WH01A110M					★	★	★	★	★	★	★	★	★	★	★	★	★	★		
		266RG-16WH01C110M					★	★	★	★	★	★	★	★	★	★	★	★	★	★		
		266RG-16WH01F110E					★	★	★	★	★	★	★	★	★	★	★	★	★	★		
	10	266RG-16WH01A100M	2.02	.0795	0.37	.0146	★	★	★	★	★	★	★	★	★	★	★	★	★	★		
	9	266RG-16WH01A090M	2.24	.0882	0.42	.0165	★	★	★	★	★	★	★	★	★	★	★	★	★	★		
	8	266RG-16WH01A080M	2.52	.0992	0.47	.0185	★	★	★	★	★	★	★	★	★	★	★	★	★	★		
22	1/2	11	266RG-22WH02A110E	1.83	.0720	0.34	.0134	★	★	★	★	★	★	★	★	★	★	★	★	★		
		7	266RG-22WH01A070M	2.88	.1134	0.54	.0213	★	★	★	★	★	★	★	★	★	★	★	★	★		
		6	266RG-22WH01A060M	3.37	.1327	0.64	.0252	★	★	★	★	★	★	★	★	★	★	★	★	★		
		5	266RG-22WH01A050M	4.04	.1591	0.77	.0303	★	★	★	★	★	★	★	★	★	★	★	★	★	★	
		4.5	266RG-22WH01A045M	4.49	.1768	0.85	.0335	★	★	★	★	★	★	★	★	★	★	★	★	★	★	
	4	266RG-22WH01A040M	5.06	.1992	0.96	.0378	★	★	★	★	★	★	★	★	★	★	★	★	★	★		

266R = Right hand, 266L = Left hand
★ = First choice


Continued ...



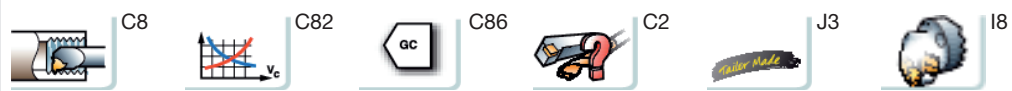
A
General Turning
B
Parting and Grooving
C
Threading
G
Tooling systems
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General information

... Continued
Internal

For ISO application areas, see bottom of the table.

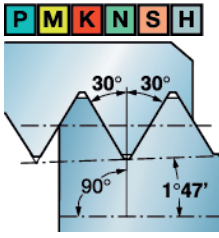
	iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S		
				H _A mm	H _A in.	H _B mm	H _B in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135
16	3/8	26	266RL-16WH01A260M	0.78	.0307	0.13	.0051	★				★						
		20	266RL-16WH01A200M	0.99	.0390	0.17	.0067	★				★						
		19	266RL-16WH01A190M	1.05	.0413	0.18	.0071	★	☆			★	☆			★		
		18	266RL-16WH01A180M	1.11	.0437	0.19	.0075	★				★						
		16	266RL-16WH01A160M	1.25	.0492	0.22	.0087	★				★						
		14	266RL-16WH01A140M	1.43	.0563	0.25	.0098	★	☆			★	☆			★		
			266LL-16WH01A140M					★				★				★		
			266RL-16WH02A140M					★				★				★		
			266RL-16WH01C140M						★				★			★		
			266RL-16WH01F140E						★				★			★		
		12	266RL-16WH01A120M	1.67	.0657	0.30	.0118	★				★				★		
		11	266RL-16WH01A110M	1.83	.0720	0.33	.0130	★	☆			★	☆			★		
			266LL-16WH01A110M					★				★				★		
			266RL-16WH01C110M						★				★			★		
	266RL-16WH01F110E						★				★			★				
10	266RL-16WH01A100M	2.02	.0795	0.37	.0146	★				★				★				
9	266RL-16WH01A090M	2.24	.0882	0.41	.0161	★				★				★				
8	266RL-16WH01A080M	2.53	.0996	0.47	.0185	★	☆			★	☆			★				
22	1/2	11	266RL-22WH02A110E	1.83	.0720	0.33	.0130	★			★			★				
		7	266RL-22WH01A070M	2.88	.1134	0.53	.0209	★			★			★				
		6	266RL-22WH01A060M	3.36	.1323	0.62	.0244	★			★			★				
		5	266RL-22WH01A050M	4.03	.1587	0.76	.0299	★			★			★				
		4.5	266RL-22WH01A045M	4.48	.1764	0.85	.0335	★			★			★				
4	266RL-22WH01A040M	5.04	.1984	0.96	.0378	★			★				★					
							P20	P25	M20	M25	K15	K20	N25	N20	S20	S25		

266R = Right hand, 266L = Left hand
★ = First choice



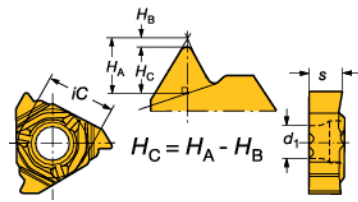
NPT 60° NPSC, NPTR, LINE PIPE¹⁾ Topping

Threads for pipe fittings and couplings for gas, water and sewage



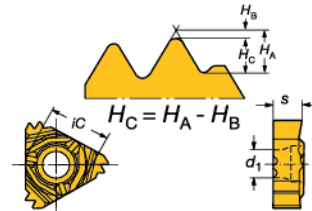
ANSI B.1.20.1-1983

Single-point



Style shown: Right hand external, Left hand internal

Multi-point



266RG-22NT0 2A115E

2 = Two points

Dimensions, mm (inch)

iC	Pitch, TPI	iC mm	d_1	s
16	3/8	27-8	9.53	4.4 (.173)
22	1/2	11-4	12.7	5.5 (.217)



Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S	
			H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
			1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125
16	3/8	27	266RG-16NT01A270M	0.76	.0299	0.05	.0020	★	★	★	★	★	★	★	★	★
			266LG-16NT01A270M					★	★	★	★	★	★	★	★	★
		18	266RG-16NT01A180M	1.14	.0449	0.08	.0031	★	★	★	★	★	★	★	★	★
			266LG-16NT01A180M					★	★	★	★	★	★	★	★	★
		14	266RG-16NT01A140M	1.46	.0575	0.09	.0035	★	★	★	★	★	★	★	★	★
			266LG-16NT01A140M					★	★	★	★	★	★	★	★	★
		266RG-16NT01C140M					★	★	★	★	★	★	★	★	★	
		266RG-16NT01F140E					★	★	★	★	★	★	★	★	★	
		11.5	266RG-16NT01A115M	1.79	.0705	0.11	.0043	★	★	★	★	★	★	★	★	★
			266LG-16NT01A115M					★	★	★	★	★	★	★	★	★
			266RG-16NT01C115M					★	★	★	★	★	★	★	★	★
			266RG-16NT01F115E					★	★	★	★	★	★	★	★	★
22	1/2	8	266RG-16NT01A080M	2.57	.1012	0.14	.0055	★	★	★	★	★	★	★	★	
			266LG-16NT01A080M					★	★	★	★	★	★	★	★	★
		11.5	266RG-22NT02A115E	1.79	.0705	0.11	.0043	★	★	★	★	★	★	★	★	

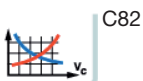
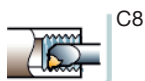
Internal

iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S	
			H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	
			1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125
16	3/8	14	266RL-16NT01A140M	1.46	.0575	0.09	.0035	★	★	★	★	★	★	★	★	
			266LL-16NT01A140M					★	★	★	★	★	★	★	★	
			266RL-16NT01C140M					★	★	★	★	★	★	★	★	
			266RL-16NT01F140E					★	★	★	★	★	★	★	★	
			11.5	266RL-16NT01A115M	1.79	.0705	0.11	.0043	★	★	★	★	★	★	★	★
				266LL-16NT01A115M					★	★	★	★	★	★	★	★
			266RL-16NT01C115M					★	★	★	★	★	★	★	★	
			266RL-16NT01F115E					★	★	★	★	★	★	★	★	
			8	266RL-16NT01A080M	2.57	.1012	0.14	.0055	★	★	★	★	★	★	★	★
			266LL-16NT01A080M					★	★	★	★	★	★	★	★	
			11.5	266RL-22NT02A115E	1.79	.0705	0.11	.0043	★	★	★	★	★	★	★	★

1) The insert can give a slightly bigger truncation for LINE PIPE 14 TPI.

266R = Right hand, 266L = Left hand

★ = First choice

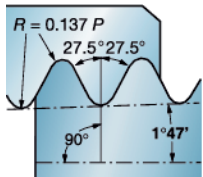


A General Turning
B Parting and Grooving
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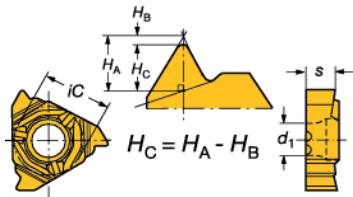
BSPT 55° Topping

Pipe threads for steam, gas and water lines

P M K N S H



ISO 7/1
BS21:1985



Pipe threads
External: R thread
Internal: R_c thread
Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

	<i>iC</i>	Pitch, TPI	<i>iC</i> mm	<i>d</i> ₁	<i>s</i>
16	3/8	28-8	9.53	4.4 (.173)	3.97 (.156)



Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

	<i>iC</i>	Pitch, TPI	Ordering code	Dimensions, mm, inch				P		M		K		N		S	
				<i>H</i> _A mm	<i>H</i> _A in.	<i>H</i> _B mm	<i>H</i> _B in.	GC	GC	GC	GC	GC	GC	GC	GC		
				1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	1125	1135		
16	3/8	28	266RG-16PT01A280E	0.70	.0276	0.13	.0051	★	☆	★	☆	★	☆	★	☆	★	☆
		19	266RG-16PT01A190E	1.04	.0409	0.19	.0075	★	☆	★	☆	★	☆	★	☆	★	☆
			266LG-16PT01A190E					★	☆	★	☆	★	☆	★	☆	★	☆
		14	266RG-16PT01A140E	1.41	.0555	0.26	.0102	★	☆	★	☆	★	☆	★	☆	★	☆
			266LG-16PT01A140E					★	☆	★	☆	★	☆	★	☆	★	☆
		11	266RG-16PT01A110E	1.80	.0709	0.34	.0134	★	☆	★	☆	★	☆	★	☆	★	☆
		8	266RG-16PT01A080E	2.47	.0972	0.47	.0185	★	☆	★	☆	★	☆	★	☆	★	☆
								P20	P25	M20	M25	K15	K20	N20	N25	S20	S25

Internal

	<i>iC</i>	Pitch, TPI	Ordering code	Dimensions, mm, inch				P		M		K		N		S	
				<i>H</i> _A mm	<i>H</i> _A in.	<i>H</i> _B mm	<i>H</i> _B in.	GC	GC	GC	GC	GC	GC	GC	GC		
				1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	1125	1135		
16	28	28	266RL-16PT01A280E	0.71	.0280	0.12	.0047	★	☆	★	☆	★	☆	★	☆	★	☆
		19	266R/LL-16PT01A190E	1.03	.0406	0.18	.0071	★	☆	★	☆	★	☆	★	☆	★	☆
			266LL-16PT01A190E					★	☆	★	☆	★	☆	★	☆	★	☆
		14	266RL-16PT01A140E	1.40	.0551	0.25	.0098	★	☆	★	☆	★	☆	★	☆	★	☆
			266LL-16PT01A140E					★	☆	★	☆	★	☆	★	☆	★	☆
		11	266RL-16PT01A110E	1.80	.0709	0.33	.0130	★	☆	★	☆	★	☆	★	☆	★	☆
		8	266RL-16PT01A080E	2.48	.0976	0.47	.0185	★	☆	★	☆	★	☆	★	☆	★	☆
								P20	P25	M20	M25	K15	K20	N20	N25	S20	S25

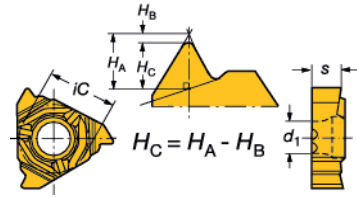
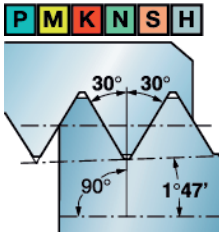
266R = Right hand, 266L = Left hand
★ = First choice



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NPTF 60° Topping

Pipe threads for steam, gas and water lines.



ANSI B1.20.3-1976
Tolerance class 2

Style shown: Right hand external
Left hand internal

Dimensions, mm (inch)

	iC	Pitch, TPI	iC mm	d_1	s
16	3/8	27-8	9.53	4.4 (.173)	3.97 (.156)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

External

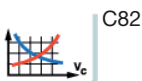
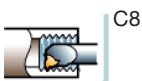
For ISO application areas, see bottom of the table.

	iC	Pitch, TPI	Ordering code	Dimensions, mm, inch				Material				
				H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC
16	3/8	27	266RG-16NF01A270E	0.75	.0295	0.11	.0043	★	★	★	★	★
		18	266RG-16NF01A180E	1.14	.0449	0.13	.0051	★	★	★	★	★
		14	266RG-16NF01A140E	1.49	.0587	0.13	.0051	★	★	★	★	★
		11.5	266RG-16NF01A115E	1.81	.0713	0.17	.0067	★	★	★	★	★
		8	266RG-16NF01A080E	2.60	.1024	0.21	.0083	★	★	★	★	★
								P20	M20	K15	N20	S20

Internal

	iC	Pitch, TPI	Ordering code	Dimensions, mm, inch				Material				
				H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC
16	3/8	14	266RL-16NF01A140E	1.49	.0587	0.13	.0051	★	★	★	★	★
		11.5	266RL-16NF01A115E	1.81	.0713	0.17	.0067	★	★	★	★	★
		8	266RL-16NF01A080E	2.60	.1024	0.21	.0083	★	★	★	★	★
								P20	M20	K15	N20	S20

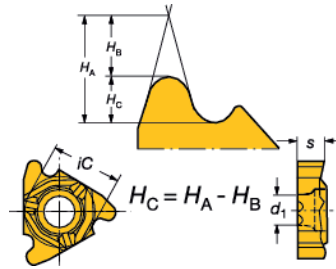
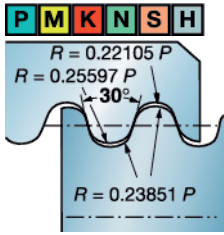
266R = Right hand, 266L = Left hand
★ = First choice



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Round 30° Topping

Threads for pipe couplings in food and firefighting industry.



Style shown: Right hand external, Left hand internal

DIN 405.
Tolerance class 7 on effective dia.
Tolerance class 6 on major (external) and minor (internal) dia.

Dimensions, mm (inch)

	iC	Pitch, TPI	iC mm	d_1	s
16	3/8	10-8	9.53	4.4 (.173)	3.97 (.156)
22	1/2	4	12.7	5.5 (.217)	5.56 (.219)



Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

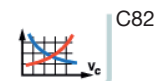
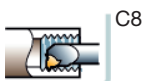
\triangle	iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S		
				H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC			
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135			
16	3/8	10	266R/LG-16RN01A100M	2.97	.1169	1.72	.0677	★		★		★		★		★		
			266RG-16RN01F100E															
			266R/LG-16RN01A080M	3.72	.1465	2.14	.0843	★		★		★		★		★		★
	6	266R/LG-16RN01A060M	4.98	.1961	2.86	.1126	★		★		★		★		★		★	
		266RG-16RN01F080E																
		266RG-16RN01F060E																
22	1/2	4	266R/LG-22RN01A040M	7.45	.2933	4.30	.1693	★		★		★		★		★		
			266RG-22RN01F040E															
								P20	P25	M20	M25	K15	K20	N25	N20	N25	S20	S25

Internal

\triangle	iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S		
				H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC			
				1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135			
16	3/8	10	266R/LL-16RN01A100M	2.87	.1130	1.58	.0622	★		★		★		★		★		
			266RL-16RN01F100E															
			266R/LL-16RN01A080M	3.59	.1413	2.00	.0787	★		★		★		★		★		★
	6	266R/LL-16RN01A060M	4.79	.1886	2.66	.1047	★		★		★		★		★		★	
		266RL-16RN01F080E																
		266RL-16RN01F060E																
22	1/2	4	266R/LL-22RN01A040M	7.17	.2823	3.98	.1567	★		★		★		★		★		
			266RL-22RN01F040E															
								P20	P25	M20	M25	K15	K20	N25	N20	N25	S20	S25

266R = Right hand, 266L = Left hand

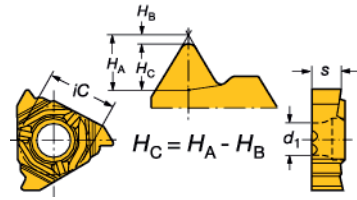
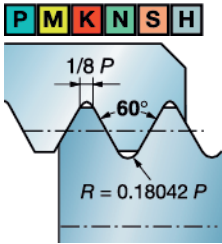
★ = First choice



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MJ 60° Topping

Aerospace threads



ISO 5855-1983

Tolerance class 4 on pitch diameter.
Tolerance class 6 on major (external) and minor (internal) dia.

Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

\triangle	iC	Pitch, mm	iC mm	d_1	s
16	3/8	1.5-2.0	9.53	4.4 (.173)	3.97 (.156)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

\triangle	iC	Pitch, mm	Ordering code	Dimensions, mm, inch				P	M	K	N	S
				H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC
16	3/8	1.50	266R/LG-16MJ01A150E	1.12	.0441	0.25	.0098	★	★	★	★	★
		2.00	266R/LG-16MJ01A200E	1.50	.0591	0.34	.0134	★	★	★	★	★
								P20	M20	K15	N20	S20

266R = Right hand, 266L = Left hand
★ = First choice

Internal

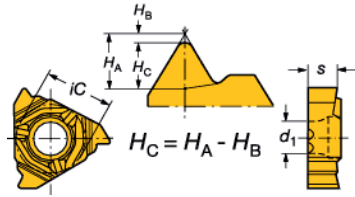
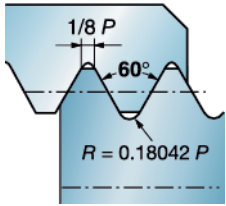
Note: To turn an internal MJ thread, use a CoroTurn 107 boring bar and insert to turn correct internal diameter and then produce the thread with a corresponding ISO metric 60° (MM) insert.



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UNJ 60° Topping

Aerospace threads



ISO 3161-1977
BS 4084-1978
Tolerance class 3A

Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

i_C	Pitch, TPI	i_C mm	d_1	s
16	3/8	32-8	4.4 (.173)	3.97 (.156)



Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

i_C	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				Material						
			H_A mm	H_A in.	H_B mm	H_B in.	P	M	K	N	S		
			GC	GC	GC	GC	GC	GC	GC				
16	3/8	32	266RG-16NJ01A320E	0.59	.0232	0.13	.0051	★	★	★	★	★	★
		28	266RG-16NJ01A280E	0.67	.0264	0.15	.0059	★	★	★	★	★	★
		24	266RG-16NJ01A240E	0.79	.0311	0.18	.0071	★	★	★	★	★	★
		20	266RG-16NJ01A200E	0.94	.0370	0.21	.0083	★	★	★	★	★	★
		18	266RG-16NJ01A180E	1.05	.0413	0.23	.0091	★	★	★	★	★	★
		16	266RG-16NJ01A160E	1.18	.0465	0.26	.0102	★	★	★	★	★	★
		14	266RG-16NJ01A140E	1.35	.0531	0.30	.0118	★	★	★	★	★	★
		12	266RG-16NJ01A120E	1.58	.0622	0.36	.0142	★	★	★	★	★	★
		10	266RG-16NJ01A100E	1.89	.0744	0.42	.0165	★	★	★	★	★	★
8	266RG-16NJ01A080E	2.38	.0937	0.53	.0209	★	★	★	★	★	★		
								P20	M20	K15	N20	S20	

266R = Right hand, 266L = Left hand
★ = First choice

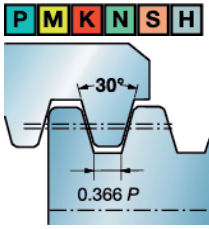
Internal

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.

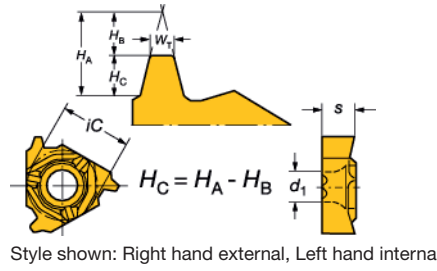


ISO Trapezoidal 30° Chamfered crest form

Trapezoidal screw threads for motion transmission



ISO 2901-2904
DIN 103-1977
Tolerance class 7



Dimensions, mm (inch)

	i_C	Pitch, mm	i_C mm	d_1	s
16	3/8	1.5-3.0	9.53	4.4 (.173)	3.97 (.156)
22	1/2	4.0-7.0	12.7	5.5 (.217)	5.56 (.219)
27	5/8	8.0	15.88	6.5 (.256)	7.0 (.276)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

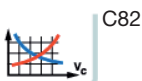
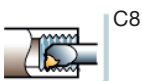
\triangle	i_C	Pitch, mm	Ordering code	Dimensions, millimeter, inch (mm, in.)						P		M		K		N		S	
				H_A mm	H_A in.	H_B mm	H_B in.	W_T mm	W_T in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
				1020	1135	1020	1135	1020	1135	1020	1135	1020	1135	1020	1135	1020	1135		
16	3/8	1.50	266R/LG-16TR01F150E	1.85	.0728	0.88	.0346	0.47	.0185	★	★	★	★	★	★	★	★	★	★
		2.00	266R/LG-16TR01F200E	2.44	.0961	1.13	.0445	0.61	.0240	★	★	★	★	★	★	★	★	★	★
		3.00	266R/LG-16TR01F300E	3.63	.1429	1.82	.0717	0.98	.0386	★	★	★	★	★	★	★	★	★	★
22	1/2	4.00	266R/LG-22TR01F400E	4.82	.1898	2.50	.0984	1.34	.0528	★	★	★	★	★	★	★	★	★	★
		5.00	266R/LG-22TR01F500E	6.01	.2366	3.18	.1252	1.70	.0669	★	★	★	★	★	★	★	★	★	★
		6.00	266R/LG-22TR01F600E	7.20	.2835	3.62	.1425	1.94	.0764	★	★	★	★	★	★	★	★	★	★
		7.00	266R/LG-22TR01F700E	8.38	.3299	4.31	.1697	2.31	.0909	★	★	★	★	★	★	★	★	★	★
27	5/8	8.00	266RG-27TR01F800E	9.57	.3768	5.00	.1969	2.68	.1055	★	★	★	★	★	★	★	★	★	★
										P20	P25	M20	M25	K15	K20	N25	N25	S20	S25

Internal

\triangle	i_C	Pitch, mm	Ordering code	Dimensions, millimeter, inch (mm, in.)						P		M		K		N		S	
				H_A mm	H_A in.	H_B mm	H_B in.	W_T mm	W_T in.	GC	GC	GC	GC	GC	GC	GC	GC		
				1020	1135	1020	1135	1020	1135	1020	1135	1020	1135	1020	1135				
16	3/8	2.00	266R/LL-16TR01F200E	2.41	.0949	1.08	.0425	0.58	.0228	★	★	★	★	★	★	★	★	★	★
		3.00	266R/LL-16TR01F300E	3.59	.1413	1.76	.0693	0.94	.0370	★	★	★	★	★	★	★	★	★	★
22	1/2	4.00	266R/LL-22TR01F400E	4.77	.1878	2.45	.0965	1.31	.0516	★	★	★	★	★	★	★	★	★	★
		5.00	266R/LL-22TR01F500E	5.96	.2346	3.13	.1232	1.68	.0661	★	★	★	★	★	★	★	★	★	★
		6.00	266R/LL-22TR01F600E	7.14	.2811	3.56	.1402	1.91	.0752	★	★	★	★	★	★	★	★	★	★
27	5/8	8.00	266RL-27TR01F800E	8.32	.3276	4.25	.1673	2.28	.0898	★	★	★	★	★	★	★	★	★	★
										P20	P25	M20	M25	K15	K20	N25	N25	S20	S25

266R = Right hand, 266L = Left hand

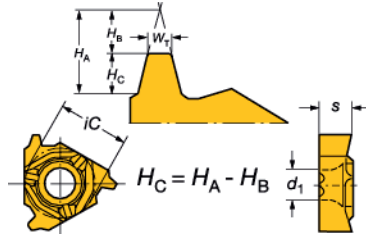
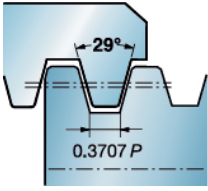
★ = First choice



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ACME 29° Chamfered crest form

Trapezoidal screw threads for motion transmission



Style shown: Right hand external, Left hand internal

ANSI B1.5-1988
Tolerance class 2G

Dimensions, mm (inch)

Δ	i_C	Pitch, TPI	i_C mm	d_1	s
16	3/8	16-8	9.53	4.4 (.173)	3.97 (.156)
22	1/2	6-4	12.7	5.5 (.217)	5.56 (.219)
27	5/8	3	15.9	6.5 (.256)	7.0 (.276)



Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

Δ	i_C	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)						Material Selection									
				H_A		H_B		W_T		P	M	K	N	S					
				mm	in.	mm	in.	mm	in.	GC	GC	GC	GC	GC	GC	GC	GC		
16	3/8	16	266RG-16AC01F160E	1.98	.0780	1.04	.0409	0.54	.0213	1020	1135	1020	1135	1020	1135	1020	1135	1020	1135
		14	266RG-16AC01F140E	2.26	.0890	1.21	.0476	0.63	.0248	★	★	★	★	★	★	★	★	★	★
		12	266R/LG-16AC01F120E	2.64	.1039	1.43	.0563	0.74	.0291	★	★	★	★	★	★	★	★	★	★
		10	266R/LG-16AC01F100E	3.16	.1244	1.61	.0634	0.83	.0327	★	★	★	★	★	★	★	★	★	★
		8	266R/LG-16AC01F080E	3.94	.1551	2.08	.0819	1.08	.0425	★	★	★	★	★	★	★	★	★	★
22	1/2	6	266R/LG-22AC01F060E	5.25	.2067	2.84	.1118	1.47	.0579	★	★	★	★	★	★	★	★	★	★
		5	266R/LG-22AC01F050E	6.29	.2476	3.47	.1366	1.79	.0705	★	★	★	★	★	★	★	★	★	★
		4	266R/LG-22AC01F040E	7.87	.3098	4.41	.1736	2.28	.0898	★	★	★	★	★	★	★	★	★	★
27	5/8	3	266RG-27AC01F030E	10.47	.4122	5.95	.2343	3.08	.1213	★	★	★	★	★	★	★	★	★	★
										P20	P25	M20	M25	K15	K20	N25	N25	S20	S25

Internal

Δ	i_C	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)						Material Selection									
				H_A		H_B		W_T		P	M	K	N	S					
				mm	in.	mm	in.	mm	in.	GC	GC	GC	GC	GC	GC	GC	GC		
16	3/8	16	266RL-16AC01F160E	1.97	.0776	1.00	.0394	0.52	.0205	1020	1135	1020	1135	1020	1135	1020	1135	1020	1135
		14	266RL-16AC01F140E	2.25	.0886	1.16	.0457	0.60	.0236	★	★	★	★	★	★	★	★	★	★
		12	266R/LL-16AC01F120E	2.62	.1031	1.37	.0539	0.71	.0280	★	★	★	★	★	★	★	★	★	★
		10	266R/LL-16AC01F100E	3.13	.1232	1.54	.0606	0.80	.0315	★	★	★	★	★	★	★	★	★	★
		8	266R/LL-16AC01F080E	3.90	.1535	2.00	.0787	1.03	.0406	★	★	★	★	★	★	★	★	★	★
22	1/2	6	266R/LL-22AC01F060E	5.19	.2043	2.76	.1087	1.43	.0563	★	★	★	★	★	★	★	★	★	★
		5	266R/LL-22AC01F050E	6.22	.2449	3.37	.1327	1.74	.0685	★	★	★	★	★	★	★	★	★	★
		4	266R/LL-22AC01F040E	7.77	.3059	4.28	.1685	2.21	.0870	★	★	★	★	★	★	★	★	★	★
27	5/8	3	266RL-27AC01F030E	10.31	.4059	5.80	.2283	3.00	.1181	★	★	★	★	★	★	★	★	★	★
										P20	P25	M20	M25	K15	K20	N25	N25	S20	S25

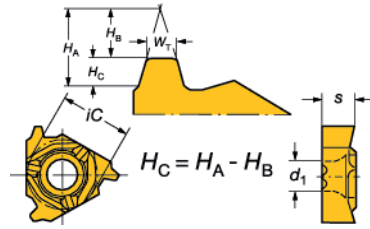
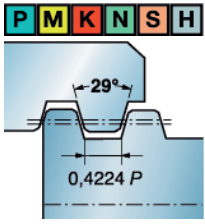
266R = Right hand, 266L = Left hand
★ = First choice



A General Turning B Parting and Grooving C Threading G Tooling systems H Multi-task machining I CoroTurn® SL J General information

STUB-ACME 29° Chamfered crest form

Trapezoidal screw threads for motion transmission



Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

Δ	i_C	Pitch, TPI	i_C mm	d_1	s
16	3/8	16-8	9.53	4.4 (.173)	3.97 (.156)
22	1/2	6-4	12.7	5.5 (.217)	5.56 (.219)
27	5/8	3	15.9	6.5 (.256)	7.0 (.276)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

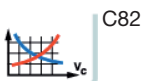
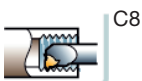
Δ	i_C	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)						Material									
				H_A mm	H_A in.	H_B mm	H_B in.	W_f mm	W_f in.	P	M	K	N	S					
				GC	GC	GC	GC	GC	GC	GC	GC	GC	GC						
16	3/8	16	266R/LG-16SA01F160E	1.86	.0732	1.21	.0476	0.63	.0248	1020	1135	1020	1135	1020	1135	1020	1135		
		14	266R/LG-16SA01F140E	2.12	.0835	1.40	.0551	0.72	.0283	★	★	★	★	★	★	★	★		
		12	266R/LG-16SA01F120E	2.47	.0972	1.65	.0650	0.85	.0335	★	★	★	★	★	★	★	★		
		10	266R/LG-16SA01F100E	2.95	.1161	1.87	.0736	0.97	.0382	★	★	★	★	★	★	★	★		
		8	266R/LG-16SA01F080E	3.67	.1445	2.39	.0941	1.24	.0488	★	★	★	★	★	★	★	★		
22	1/2	6	266R/LG-22SA01F060E	4.86	.1913	3.27	.1287	1.69	.0665	★	★	★	★	★	★	★	★		
		5	266R/LG-22SA01F050E	5.83	.2295	3.98	.1567	2.06	.0811	★	★	★	★	★	★	★	★		
		4	266R/LG-22SA01F040E	7.27	.2862	5.05	.1988	2.61	.1028	★	★	★	★	★	★	★	★		
27	5/8	3	266RG-27SA01F030E	9.66	.3803	6.81	.2681	3.52	.1386	★	★	★	★	★	★	★	★		
										P20	P25	M20	M25	K15	K20	N25	N25	S20	S25

Internal

Δ	i_C	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)						Material									
				H_A mm	H_A in.	H_B mm	H_B in.	W_f mm	W_f in.	P	M	K	N	S					
				GC	GC	GC	GC	GC	GC	GC	GC	GC	GC						
16	3/8	16	266RL-16SA01F160E	1.81	.0713	1.15	.0453	0.59	.0232	1020	1135	1020	1135	1020	1135	1020	1135		
		14	266RL-16SA01F140E	2.07	.0815	1.34	.0528	0.72	.0283	★	★	★	★	★	★	★	★		
		12	266R/LL-16SA01F120E	2.40	.0945	1.59	.0626	0.85	.0335	★	★	★	★	★	★	★	★		
		10	266R/LL-16SA01F100E	2.88	.1134	1.80	.0709	0.93	.0366	★	★	★	★	★	★	★	★		
		8	266R/LL-16SA01F080E	3.59	.1413	2.31	.0909	1.24	.0488	★	★	★	★	★	★	★	★		
22	1/2	6	266R/LL-22SA01F060E	4.77	.1878	3.18	.1252	1.64	.0646	★	★	★	★	★	★	★	★		
		5	266R/LL-22SA01F050E	5.71	.2248	3.87	.1524	2.00	.0787	★	★	★	★	★	★	★	★		
		4	266R/LL-22SA01F040E	7.13	.2807	4.91	.1933	2.54	.1000	★	★	★	★	★	★	★	★		
27	5/8	3	266RL-27SA01F030E	9.49	.3736	6.64	.2614	3.43	.1350	★	★	★	★	★	★	★	★		
										P20	P25	M20	M25	K15	K20	N25	N25	S20	S25

266R = Right hand, 266L = Left hand

★ = First choice



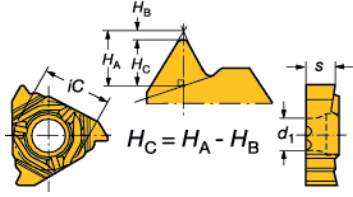
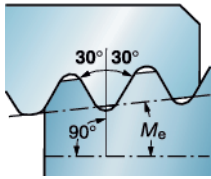
A General Turning
B Parting and Grooving
C Threading
G Tooling systems
H Multi-task machining
I CoroTurn® SL
J General information

API 60° Topping for shouldered connections

V-0.038R, V-0.040, V-0.050

Threads for oil and gas

P M K N S H



Style shown: Right hand external, Left hand internal

Me = Cone
 2 i.p.f - 4°46'
 3 i.p.f - 7°07'
 API spec. 7

Dimensions, mm (inch)

iC	Pitch, TPI	iC mm	d_1	s
22	1/2	4-5	5.5 (.217)	5.57 (.219)
27	5/8	4-5	6.5 (.256)	7.0 (.276)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

External

For ISO application areas, see bottom of the table.

iC	Pitch, TPI	Taper on dia.	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S			
				H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC				
				1020	1125	1020	1125	1020	1125	1020	1125	1020	1125						
22	1/2	2	V-0.038R																
			266RG-22V381A0402E	4.03	.1587	0.95	.0374	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		3	266RG-22V381A0403E	4.02	.1583	0.95	.0374	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		3	V-0.040																
			266RG-22V401A0503E	3.47	.1368	0.50	.0197	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	V-0.050																		
	5/8	2	266RG-22V501A0402E	4.36	.1717	0.62	.0244	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
			266RG-22V501A0403E	4.35	.1713	0.62	.0244	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		3	V-0.038R																
			266RG-27V381A0402E	4.03	.1587	0.95	.0374	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
266RG-27V381A0403E			4.02	.1583	0.95	.0374	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
5/8	2	V-0.040																	
		266RG-27V401A0503E	3.47	.1368	0.50	.0197	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		
	3	V-0.050																	
		266RG-27V501A0402E	4.36	.1717	0.62	.0244	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		266RG-27V501A0403E	4.35	.1713	0.62	.0244	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	

Internal

iC	Pitch, TPI	Taper on dia.	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S			
				H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC				
				1020	1125	1020	1125	1020	1125	1020	1125	1020	1125						
22	1/2	2	V-0.038R																
			266RL-22V381A0402E	4.03	.1587	0.95	.0374	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		
		3	266RL-22V381A0403E	4.02	.1583	0.95	.0374	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		
		3	V-0.040																
			266RL-22V401A0503E	3.47	.1368	0.50	.0197	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
	V-0.050																		
	5/8	2	266RL-22V501A0402E	4.36	.1717	0.62	.0244	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
			266RL-22V501A0403E	4.35	.1713	0.62	.0244	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		3	V-0.038R																
			266RL-27V381A0402E	4.03	.1587	0.95	.0374	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
266RL-27V381A0403E			4.02	.1583	0.95	.0374	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
5/8	2	V-0.040																	
		266RL-27V401A0503E	3.47	.1368	0.50	.0197	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		
	3	V-0.050																	
		266RL-27V501A0402E	4.36	.1717	0.62	.0244	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		266RL-27V501A0403E	4.35	.1713	0.62	.0244	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	

266R = Right hand, 266L = Left hand

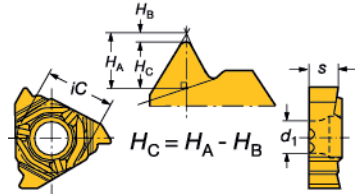
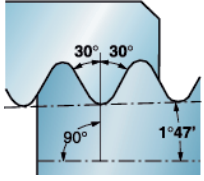
☆ = First choice



A General Turning B Parting and Grooving C Threading G Tooling systems H Multi-task machining I CoroTurn® SL J General information

API Round 60° Topping

Threads for oil and gas



API spec. 5B

Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

iC	Pitch, TPI	iC mm	d_1	s
16	3/8	9.53	4.4 (.173)	3.97 (.156)
22	1/2	12.7	5.5 (.217)	5.56 (.219)



Even more possibilities thanks to tailored design! See page J3.

External

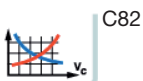
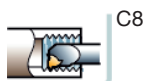
For ISO application areas, see bottom of the table.

iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S					
			H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC						
			1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135			
16	3/8	10	266RG-16RD01A100E	1.76	.0693	0.36	.0142	★		★		★		★		★				
			266RG-16RD01C100M					★		★		★		★		★				
		8	266RG-16RD01A080E	2.23	.0878	0.43	.0169	★		★		★		★		★				
			266RG-16RD01C080M					★		★		★		★		★				
22	1/2	10	266RG-22RD01A100E	1.76	.0693	0.36	.0142	☆	★	☆	★	☆	★	☆	★					
			266RG-22RD01C100M					☆	★	☆	★	☆	★	☆	★					
		8	266RG-22RD01A080E	2.23	.0878	0.43	.0169	☆	★	☆	★	☆	★	☆	★					
			266RG-22RD01C080M					☆	★	☆	★	☆	★	☆	★					
						P20	P20	P25	M20	M20	M25	K15	K15	K20	N25	N20	N25	S20	S20	S25

Internal

iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				P		M		K		N		S					
			H_A mm	H_A in.	H_B mm	H_B in.	GC	GC	GC	GC	GC	GC	GC	GC						
			1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135	1020	1125	1135			
16	3/8	10	266RL-16RD01A100E	1.76	.0693	0.36	.0142	★		★		★		★		★				
			266RL-16RD01C100M					★		★		★		★		★				
		8	266RL-16RD01A080E	2.24	.0882	0.43	.0169	★		★		★		★		★				
			266RL-16RD01C080M					★		★		★		★		★				
22	1/2	10	266RL-22RD01A100E	1.76	.0693	0.36	.0142	☆	★	☆	★	☆	★	☆	★					
			266RL-22RD01C100M					☆	★	☆	★	☆	★	☆	★					
		8	266RL-22RD01A080E	2.24	.0882	0.43	.0169	☆	★	☆	★	☆	★	☆	★					
			266RL-22RD01C080M					☆	★	☆	★	☆	★	☆	★					
						P20	P20	P25	M20	M20	M25	K15	K15	K20	N25	N20	N25	S20	S20	S25

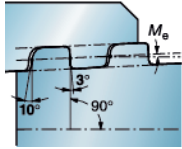
266R = Right hand
★ = First choice



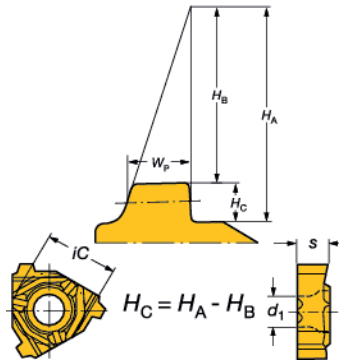
A
General Turning
B
Parting and Grooving
C
Threading
G
Tooling systems
H
Multi-task machining
I
CoroTurn® SL
J
General information

API Topping for casing and tubing

Threads for oil and gas



M_b = Cone
 3/4 i.p.f. – 1°47' for diameter 4 1/2 – 13 3/8"
 1 i.p.f. – 2°23' for diameter ≥ 16"
 Buttress
 API spec. 5B
 Style shown: Right hand external, Left hand internal



Dimensions, mm (inch)

	iC	Pitch, TPI	iC mm	d ₁	s
22	1/2	5	12.7	5.5 (.217)	5.57 (.219)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

External

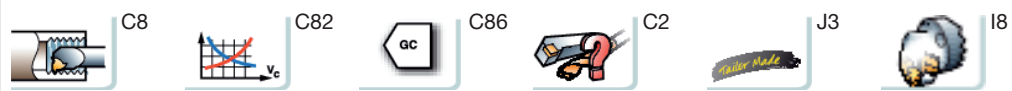
For ISO application areas, see bottom of the table.

	iC	Pitch, TPI	Taper on dia.	i.p.f.	Ordering code	Dimensions, mm, inch				Material										
						H _A mm	H _A in.	H _B mm	H _B in.	W _p mm	W _p in.	P	M	K	N	S				
						GC	GC	GC	GC	GC	GC	GC	GC	GC	GC					
22	1/2	5		1	266RG-22BU01A0501E	12.06	.4748	10.60	.4173	2.61	2.6100	☆	★	☆	★	☆	★	☆	★	
				3/4	266RG-22BU01A050E	12.05	.4744	10.47	.4122	2.58	2.5800	☆	★	☆	★	☆	★	☆	★	☆
												P20	M20	M20	K15	K15	N25	N20	S20	S20

Internal

	iC	Pitch, TPI	Taper on dia.	i.p.f.	Ordering code	Dimensions, mm, inch				Material										
						H _A mm	H _A in.	H _B mm	H _B in.	W _p mm	W _p in.	P	M	K	N	S				
						GC	GC	GC	GC	GC	GC	GC	GC	GC	GC					
22	1/2	5		1	266RL-22BU01A0501E	12.04	.4740	10.62	.4181	2.61	2.6100	☆	★	☆	★	☆	★	☆	★	
				3/4	266RL-22BU01A050E	12.18	.4795	10.60	.4173	2.61	2.6100	☆	★	☆	★	☆	★	☆	★	☆
												P20	M20	M20	K15	K15	N25	N20	S20	S20

266R = Right hand
 ★ = First choice



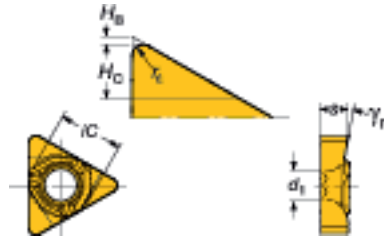
CoroThread® 266

Blanks

Dimensions, mm (inch)

	<i>iC</i>	mm	Pitch, TPI	<i>iC</i> mm	<i>d₁</i>	<i>s</i>
16	3/8	0.2 - 3.0	64-8	9.53	4.4 (.173)	3.97 (.156)

Dimension *H_c* x *l_a* is grinding area for specific profiles



External

For ISO application areas, see bottom of the table.

	<i>iC</i>	Ordering code	Dimensions, millimeter, inch (mm, in.)															
			<i>H_B</i> mm	<i>H_B</i> in.	<i>H_C</i> mm	<i>H_C</i> in.	<i>r_c</i> mm	<i>r_c</i> in.	<i>γ_n</i>	P	M	K	N	S				
16	3/8	266R/LG-160000-300-BG	0.70	.0276	3.20	.1262	1.00	.0394	10°	H13A	H13A	H13A	H13A	H13A	M25	K20	N25	S25

Internal

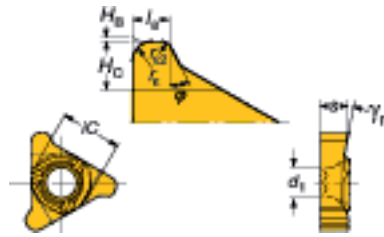
	<i>iC</i>	Ordering code	Dimensions, millimeter, inch (mm, in.)															
			<i>H_B</i> mm	<i>H_B</i> in.	<i>H_C</i> mm	<i>H_C</i> in.	<i>r_c</i> mm	<i>r_c</i> in.	<i>γ_n</i>	P	M	K	N	S				
16	3/8	266R/LL-160000-300-BG	0.70	.0276	2.70	.1062	1.00	.0394	15°	H13A	H13A	H13A	H13A	H13A	M25	K20	N25	S25

266R = Right hand
★ = First choice

Dimensions, mm (inch)

	<i>iC</i>	mm	Pitch, TPI	<i>iC</i> mm	<i>d₁</i>	<i>s</i>
22	1/2	3.0-6.0	8-4	12.7	5.5 (.217)	5.57 (.219)
27	5/8	6.0-8.0	4-3	15.88	6.5 (.256)	7.0 (.276)

Dimension *H_c* x *l_a* is grinding area for specific profiles



External

For ISO application areas, see bottom of the table.

	<i>iC</i>	Ordering code	Dimensions, millimeter, inch (mm, in.)															
			<i>H_B</i> mm	<i>H_B</i> in.	<i>H_C</i> mm	<i>H_C</i> in.	<i>r_c</i> mm	<i>r_c</i> in.	<i>r_{c2}</i> mm	<i>r_{c2}</i> in.	<i>l_a</i> mm	<i>l_a</i> in.	<i>γ_n</i>	P	M	K	N	S
22	1/2	266R/LG-220000-600-BG	0.30	.0118	4.80	.1890	2.00	.0787	1.00	.039	3.5	.138	10°	H13A	H13A	H13A	H13A	H13A
27	5/8	266RG-270000-800-BG	0.30	.0118	5.80	.2283	2.00	.0787	1.00	.039	6.5	.256	10°	H13A	H13A	H13A	H13A	H13A

Internal

	<i>iC</i>	Ordering code	Dimensions, millimeter, inch (mm, in.)															
			<i>H_B</i> mm	<i>H_B</i> in.	<i>H_C</i> mm	<i>H_C</i> in.	<i>r_c</i> mm	<i>r_c</i> in.	<i>r_{c2}</i> mm	<i>r_{c2}</i> in.	<i>l_a</i> mm	<i>l_a</i> in.	<i>γ_n</i>	P	M	K	N	S
22	1/2	266R/LL-220000-600-BG	0.40	.0157	4.80	.1890	2.00	.0787	1.00	.039	3.50	.138	15°	H13A	H13A	H13A	H13A	H13A
27	5/8	266RL-270000-800-BG	0.30	.0118	5.80	.2283	2.00	.0787	1.00	.039	6.50	.256	10°	H13A	H13A	H13A	H13A	H13A

266R = Right hand
★ = First choice

Note: Precaution should be taken when grinding cemented carbide products. See page J7 for safety information.



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Code key for CoroThread® 266 tools

Shank holders, inch

266	R	FG	Z	16	4	D
1	2	4	5	6	3	11

Boring bar, inch

266	R	KF	Z	D 20	- 4
1	2	4	5	6	3

Coromant Capto cutting unit and boring bars

C5	-	266	R	FG	Z	35	060	-	22
9		1	2	4	5	10	11		3

Shank holders, metric

266	R	FG	Z	3232	-	22
1	2	4	5	6		3

Boring bar, metric

266	R	KF	Z	32	-	22	-	R	E
1	2	4	5	6		3		7	8

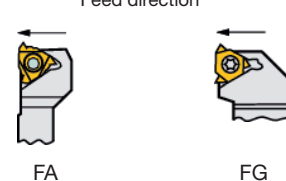


CoroThread® 266 SL cutting head


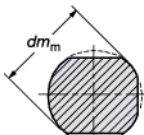
SL	-	266	R	KF	-	40	32	27	-	22
12		1	2	4		13	11	10		3

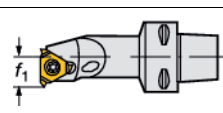
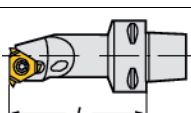
Cartridge


266	R	KF	-	20	C	A	-	22
1	2	4		14	15	16		3

1 Main code 266 = CoroThread® 266	2 Hand of tool R = Right hand style L = Left hand style	3 Insert size/dimension Shank holders Inch 3 = 3/8" = iC 4 = 1/2" = iC 5 = 5/8" = iC Metric 16 = iC 3/8" = 9.52 mm 22 = iC 1/2" = 12.70 mm 27 = iC 5/8" = 15.88 mm
---	--	--

4 Type of tool and holder style External  FA FG Internal  KF	5 Holder for upside down mounting Z = Drop head design for upside down mounting 
--	--

6 Shank dimension External Inch Shank size 16 = 1 x 1" 20 = 1 1/4 x 1 1/4" 24 = 1 1/2 x 1 1/2" Metric Shank size $h \times b$ 	Internal Inch Shank diameter D12 = .750" D24 = 1.500" D16 = 1.000" D32 = 2.000" D20 = 1.250" Metric Shank diameter dm_m 	7 Type of shank R = Round shank
---	---	---

8 Type of bar E = Carbide shank bar	9 Coromant Capto® size C = Coromant Capto D_{5m} size code C3 D5m = 32 mm C4 D5m = 40 mm C5 D5m = 50 mm C6 D5m = 63 mm C8 D5m = 80 mm	10 f_1 dimension 	11 Tool length, l_1 dimension  Inch D = 6.000" E = 7.000" Metric l_1 -dimension in mm
---	---	--	---

12 Cutting unit SL-System	13 SL coupling size dm_m - dimension (bar dia.)	14 Cutting edge height, h_1 (mm) 	15 Type of tool C = Cartridge
			16 Type of design A = letter for alternative designs according to ISO 5611.

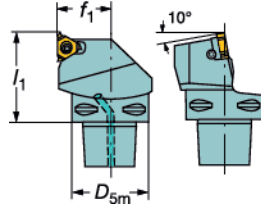
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CoroThread® 266 Coromant Capto® cutting units

Screw clamp design

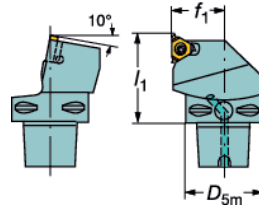


Cx-266R/LFG



Cx-266R/LFGZ

For upside down mounting



	iC	Angle of inclination with different shims, see page C45.
16	3/8	
22	1/2	
27	5/8	



x and z, see infeed tables on pages C70.

Coolant inlet: Radial through the taper

Right hand style shown

Main application	Insert size		Ordering code	Dimensions, mm, inch						Nm ¹⁾
	\triangle	iC		D_{5m} mm	D_{5m} in.	f_1 mm	f_1 in.	h mm	h in.	
	16	3/8	C3-266R/LFG-22040-16	32	1.260	22.0	.866	40.0	1.575	3.0
			C4-266R/LFG-27050-16	40	1.575	27.0	1.063	50.0	1.968	3.0
			C5-266R/LFG-35060-16	50	1.968	35.0	1.378	60.0	2.362	3.0
			C6-266R/LFG-45065-16	63	2.480	45.0	1.772	65.0	2.559	3.0
	C8-266R/LFG-55080-16	80	3.150	55.0	2.165	80.0	3.150	3.0		
	22	1/2	C3-266R/LFG-22040-22	32	1.260	22.0	.866	40.0	1.575	5.0
			C4-266R/LFG-27050-22	40	1.575	27.0	1.063	50.0	1.968	5.0
			C5-266R/LFG-35060-22	50	1.968	35.0	1.378	60.0	2.362	5.0
C6-266R/LFG-45065-22			63	2.480	45.0	1.772	65.0	2.559	5.0	
C8-266R/LFG-55080-22	80	3.150	55.0	2.165	80.0	3.150	5.0			
27	5/8	C6-266R/LFG-45065-27	63	2.480	45.0	1.772	65.0	2.559	7.5	
	16	3/8	C4-266RFGZ27050-16	40	1.575	27.0	1.063	50.0	1.968	3.0
			C5-266RFGZ35060-16	50	1.968	35.0	1.378	60.0	2.362	3.0
			C6-266RFGZ45065-16	63	2.480	45.0	1.772	65.0	2.559	3.0
	22	1/2	C4-266R/LFGZ27050-22	40	1.575	27.0	1.063	50.0	1.968	5.0
			C5-266R/LFGZ35060-22	50	1.968	35.0	1.378	60.0	2.362	5.0
			C6-266R/LFGZ45065-22	63	2.480	45.0	1.772	65.0	2.559	5.0
27	5/8	C6-266R/LFGZ45065-27	63	2.480	45.0	1.772	65.0	2.559	7.5	

¹⁾ Insert tightening torque, Nm.

266R = Right hand, 266L = Left hand

Angle of inclination with different shims, see page C45.

Main spare parts

Insert size		Insert screw		Key (Torx Plus)		Shim for right hand external toolholder		Shim for left hand external toolholder		Shim screw	
\triangle	iC					Inclination angle +1° ²⁾		Inclination angle +1° ²⁾			
16	3/8	5513 020-13	5680 049-05 (15IP/10IP)			5322 389-11		5322 390-11		5512 032-05	
22	1/2	5513 020-26	5680 043-14 (20IP)			5322 379-11		5322 380-11		5512 032-04	
27	5/8	5513 020-66	5680 043-15 (25IP)			5322 387-11		5322 388-11		5512 032-03	

²⁾ For optional shims, see page C45.

Coromant Capto Size	Optional nozzles (to be ordered separately)			
	Ordering code	Size	Mounting key	Key adapter
C3-C4	5691 034-01	M8	5680 019-01	5680 021-02
C5-C6	5691 034-02	M10	5680 019-01	5680 021-03
C8	5691 034-03	M12	5680 019-01	5680 021-04



C36



C63



G6



J2

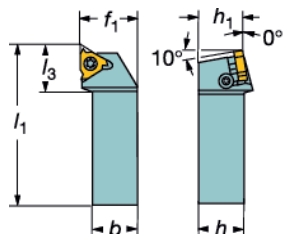
A General Turning
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CoroThread® 266 shank tools

Screw clamp design

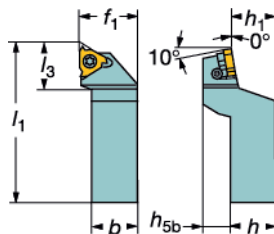


266R/LFG



266R/LFGZ

For upside down mounting



	iC	Angle of inclination with different shims, see page C45.
16	3/8	
22	1/2	
27	5/8	



x and z, see infeed tables on pages C70.

Right hand style shown

Metric version

Main application	Insert size		Dimensions								Nm ¹⁾
	iC	Ordering code	b	f_1	h	h_1	h_{5b}	h	l_3		
	16	3/8	266R/LFG-1616-16	16	20	16	16		100	21.4	3.0
			266R/LFG-2020-16	20	25	20	20		125	21.6	3.0
			266R/LFG-2525-16	25	32	25	25		150	22.2	3.0
	22	1/2	266R/LFG-3225-16	25	32	32	32		150	22.2	3.0
			266R/LFG-2525-22	25	32	25	25		150	33.3	5.0
			266R/LFG-3232-22	32	40	32	32		170	34.3	5.0
27	5/8	266R/LFG-4040-22	40	50	40	40		251	29.7	5.0	
		266R/LFG-3232-27	32	40	32	32		170	39.0	7.5	
		266R/LFG-4040-27	40	50	40	40		250	34.6	7.5	
	16	3/8	266R/LFGZ2525-16	25	32	25	25	19	150	22.2	3.0
			266RFGZ3225-16	25	32	32	32	16	170	22.2	3.0
	22	1/2	266R/LFGZ2525-22	25	32	25	25	19	150	33.3	5.0
			266R/LFGZ3232-22	32	40	32	32	21	170	34.3	5.0

Inch version

Main application	Insert size		Dimensions, inch								ft-lbs ²⁾
	iC	Ordering code	b	f_1	h	h_1	h_{5b}	h	l_3		
	16	3/8	266R/LFG-123B	.750	1.000	.750	.750		4.500	.870	2.2
			266R/LFG-163D	1.000	1.250	1.000	1.000		6.000	.870	2.2
			266R/LFG-203D	1.250	1.500	1.250	1.250		6.000	.870	2.2
	22	1/2	266R/LFG-164D	1.000	1.250	1.000	1.000		6.000	1.272	3.7
			266R/LFG-204D	1.250	1.500	1.250	1.250		6.000	1.272	3.7
			266R/LFG-244E	1.500	2.000	1.500	1.500		7.000	1.193	3.7
27	5/8	266R/LFG-205D	1.250	1.500	1.250	1.250		6.000	1.455	5.5	
		266R/LFG-245E	1.500	2.000	1.500	1.500		7.000	1.386	5.5	
		266R/LFGZ123B	.750	1.000	.750	.750		4.500	.870	2.2	
	16	3/8	266R/LFGZ163D	1.000	1.250	1.000	1.000		6.000	.870	2.2
			266RFGZ203D	1.250	1.500	1.250	1.250	.025	6.000	.870	2.2
	22	1/2	266R/LFGZ164D	1.000	1.250	1.000	1.000	.748	6.000	1.272	3.7
			266R/LFGZ204D	1.250	1.500	1.250	1.250	.827	6.000	1.272	3.7

¹⁾ Insert tightening torque, Nm.

²⁾ Insert tightening torque ft-lbs.

266R = Right hand, 266L = Left hand

Angle of inclination with different shims, see page C45.

Main spare parts

Insert size		Shim for right hand external toolholder		Shim for left hand external toolholder		
iC	Insert screw	Key (Torx Plus)	Inclination angle +1° ³⁾	Inclination angle +1° ³⁾	Shim screw	
16	3/8	5513 020-13	5680 049-05 (15IP/10IP)	5322 389-11	5322 390-11	5512 032-05
22	1/2	5513 020-26	5680 043-14 (20IP)	5322 379-11	5322 380-11	5512 032-04
27	5/8	5513 020-66	5680 043-15 (25IP)	5322 387-11	5322 388-11	5512 032-03

³⁾ For optional shims, see page C45.



CoroThread® 266 shank tools

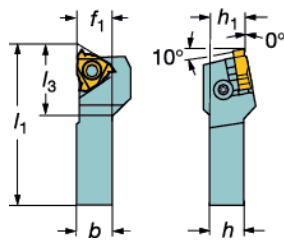
Tool holders for Swiss machines

Screw clamp design



266 R/LG

266R/LFA



Threading of slender components and against live center

	iC	Angle of inclination from -2° to $+4^\circ$ with different shims, see page C45.
16	3/8	



x and z, see infeed tables on pages C70.

Right hand style shown

Metric version

Main application	Insert size		Ordering code	Dimensions					Nm ¹⁾	
		iC		b	f_1	h	h_1	l_1		l_3
	16	3/8	266R/LFA-1010-16-S	10	10	10	10	125	19.8	3.0
			266R/LFA-1212-16-S	12	12	12	12	125	21.3	3.0
			266R/LFA-1616-16-S	16	16	16	16	125	23.3	3.0

Inch version

Main application	Insert size		Ordering code	Dimensions, inch					ft-lbs ²⁾	
		iC		b	f_1	h	h_1	l_1		l_3
	16	3/8	266R/LFA-063-S	.375	.375	.375	.375	5.000	.841	2.2
			266R/LFA-083-S	.500	.500	.500	.500	5.000	.841	2.2
			266R/LFA-103-S	.625	.625	.625	.625	5.000	.841	2.2
			266R/LFA-123-S	.750	.750	.750	.750	5.000	.841	2.2

¹⁾ Insert tightening torque, Nm.

²⁾ Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size		Insert screw		Key (Torx Plus)		Shim for right hand external toolholder Inclination angle $+1^\circ$ ³⁾		Shim for left hand external toolholder Inclination angle $+1^\circ$ ³⁾		Shim screw	
	iC	5513 020-13	5680 049-05 (15IP/10IP)	5322 389-11	5322 390-11	5322 389-11	5322 390-11	5512 032-05			

³⁾ For optional shims, see page C45.



C11



C35



C63



G6



J2

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THREADING CoroThread® 266 – External threading

CoroThread 266® short holder for QS™ holding system
Threading
Screw clamp design

QS-266RFA




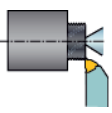
266 R/LG

	<i>iC</i>	Angle of inclination from -2° to $+4^\circ$ with different shims, see page C45.
16	3/8	 -2° to $+4^\circ$


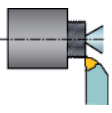
x and z, see infeed tables on pages C70.

Right hand style shown

Metric version

Main application	Insert size		Ordering code	Dimensions						Nm ¹⁾
		<i>iC</i>		<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	
	16	3/8	QS-266RFA-1010-16	10	10	10	10	70	19.8	3.0
			QS-266RFA-1212-16	12	12	12	12	70	21.3	3.0
			QS-266RFA-1616-16	16	16	16	16	70	23.3	3.0


Inch version

Main application	Insert size		Ordering code	Dimensions, inch						ft-lbs ²⁾
		<i>iC</i>		<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	
	16	3/8	QS-266RFA-063	.375	.375	.375	.375	2.756	.780	2.2
			QS-266RFA-083	.500	.500	.500	.500	2.756	.839	2.2
			QS-266RFA-103	.625	.625	.625	.625	2.756	.917	2.2

¹⁾ Insert tightening torque, Nm.
²⁾ Insert tightening torque ft-lbs.
For QS stops, see page A233.

R = Right hand

Main spare parts

Insert size		Insert screw		Key (Torx Plus)		Shim for right hand external toolholder Inclination angle $+1^\circ$ ²⁾		Shim for left hand external toolholder Inclination angle $+1^\circ$ ²⁾		Shim screw	
	<i>iC</i>										
16	3/8	5513 020-13	5680 049-05 (15IP/10IP)	5322 389-11	5322 390-11	5512 032-05					

²⁾ For optional shims, see page C45.

C 38

CoroThread® 266 Coromant Capto® cutting units

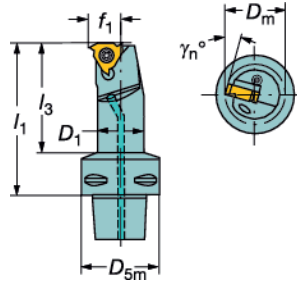
Screw clamp design

Steel bar with internal cutting fluid supply



266 R/LL

Cx-266R/LKF



	16 3/8	Angle of inclination with different shims, see page C45.



x and z, see infeed tables on pages C70.

Right hand style shown

Main application	Insert size		Ordering code	Dimensions, mm, inch							Nm ¹⁾	
		iC		D ₁	D _m min	D _{5m}	f ₁	l ₁	l ₃	γ _n		
	16	3/8	C3-266R/LKF-14060-16	18.5	25	32	14.0	60	44	-15°	3.0	
			C4-266R/LKF-14060-16	.728	.984	1.260	.551	2.362	1.732			
			C4-266R/LKF-17070-16	24.5	32	40	17.0	70	48	-15°	3.0	
			C4-266RKF-22090-16	.965	1.260	1.575	.669	2.756	1.890			
			C5-266R/LKF-14060-16	32.0	40	40	22.0	90	69	-15°	3.0	
			C5-266R/LKF-17070-16	1.260	1.575	1.575	.866	3.543	2.716			
			C5-266R/LKF-17070-16	18.5	25	50	14.0	60	36	-15°	3.0	
			C5-266R/LKF-17070-16	.728	.984	1.968	.551	2.362	1.417			
			C5-266R/LKF-17070-16	24.5	32	50	17.0	70	47	-15°	3.0	
			C5-266R/LKF-22090-16	.965	1.260	1.968	.669	2.756	1.850			
			C5-266R/LKF-22090-16	32.0	40	50	22.0	90	68	-15°	3.0	
			C5-266R/LKF-22090-16	1.260	1.575	1.968	.866	3.543	2.677			
			C5-266R/LKF-27105-16	40.0	50	50	27.0	105	84	-15°	3.0	
			C5-266R/LKF-27105-16	1.575	1.968	1.968	1.063	4.134	3.307			
			C6-266R/LKF-14070-16	18.5	25	63	14.0	70	42	-15°	3.0	
			C6-266R/LKF-17075-16	.728	.984	2.480	.551	2.756	1.654			
			C6-266R/LKF-17075-16	24.5	32	63	17.0	75	48	-15°	3.0	
			C6-266R/LKF-22090-16	.965	1.260	2.480	.669	2.953	1.890			
			C6-266R/LKF-22090-16	32.0	40	63	22.0	90	64	-15°	3.0	
			C6-266R/LKF-22090-16	1.260	1.575	2.480	.866	3.543	2.520			
C6-266R/LKF-27105-16	40.0	50	63	27.0	105	80	-15°	3.0				
C6-266R/LKF-27105-16	1.575	1.968	2.480	1.063	4.134	3.150						

¹⁾ Insert tightening torque, Nm.

266R = Right hand, 266L = Left hand

Angle of inclination with different shims, see page C45.

Main spare parts

Insert size		Insert screw		Key (Torx Plus)		Shim for right hand internal tool holder Inclination angle +1° ²⁾		Shim for left hand internal tool holder Inclination angle +1° ²⁾		Shim screw	
	iC										
16	3/8	5513 020-13	5680 049-05 (15IP/10IP)	5322 390-11		5322 389-11		5512 032-05			

²⁾ For optional shims, see page C45.



C11



C41



C64



G6



J2

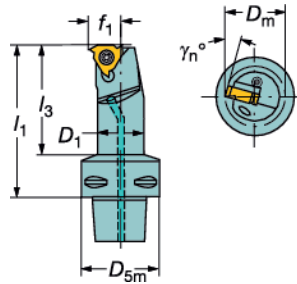
CoroThread® 266 Coromant Capto® cutting units

Screw clamp design
Steel bar with internal cutting fluid supply



266 R/LL

Cx-266R/LKF



\triangleleft	iC	Angle of inclination with different shims, see page C45.
22	1/2	-2° - $+4^{\circ}$



x and z, see infeed tables on pages C70.

Right hand style shown

Main application	Insert size		Ordering code	Dimensions, mm, inch							Nm ¹⁾
	\triangleleft	iC		D_1	D_m min	D_{5m}	f_1	l_1	l_2	γ_n	
	22	1/2	C4-266RKF-19070-22	25.0	32	40	19.0	70	48	-15°	5.0
			C4-266RKF-22090-22	.984	1.260	1.575	.748	2.756	1.890	-15°	5.0
			C4-266RKF-27080-22	1.240	1.575	1.575	.866	3.543	2.716	-15°	5.0
			C4-266RKF-27080-22	39.5	50	40	27.0	80	60	-15°	5.0
			C5-266RKF-19070-22	1.555	1.968	1.575	1.063	3.150	2.362	-15°	5.0
			C5-266RKF-19070-22	25.0	32	50	19.0	70	47	-15°	5.0
			C5-266RKF-22090-22	.984	1.260	1.968	.748	2.756	1.850	-15°	5.0
			C5-266RKF-22090-22	32.0	40	50	22.0	90	68	-15°	5.0
			C5-266R/LKF-27105-22	1.260	1.575	1.968	.866	3.543	2.677	-15°	5.0
			C5-266R/LKF-27105-22	40.0	50	50	26.9	105	84	-15°	5.0
			C6-266RKF-19075-22	1.575	1.968	1.968	1.059	4.134	3.307	-15°	5.0
			C6-266RKF-19075-22	25.0	32	63	19.0	75	48	-15°	5.0
C6-266RKF-22090-22	.984	1.260	2.480	.748	2.953	1.890	-15°	5.0			
C6-266RKF-22090-22	31.5	40	63	22.0	90	64	-15°	5.0			
C6-266R/LKF-27105-22	1.240	1.575	2.480	.866	3.543	2.520	-15°	5.0			
C6-266R/LKF-27105-22	40.0	50	63	26.9	105	80	-15°	5.0			
C6-266R/LKF-27105-22	1.575	1.968	2.480	1.059	4.134	3.150	-15°	5.0			

¹⁾ Insert tightening torque, Nm.

266R = Right hand, 266L = Left hand

Angle of inclination with different shims, see page C45.

Main spare parts

Insert size		Insert screw		Key (Torx Plus)		Shim for right hand internal tool holder		Shim for left hand internal tool holder		Shim screw	
\triangleleft	iC					Inclination angle $+1^{\circ}$ ²⁾		Inclination angle $+1^{\circ}$ ²⁾			
22	1/2	5513	020-26	5680	043-14 (20IP)	5322	380-11	5322	379-11	5512	032-04

²⁾ For optional shims, see page C45.



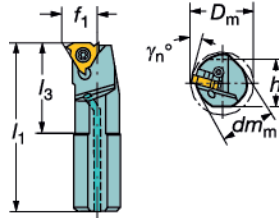
CoroThread® 266 boring bars

Screw clamp design
Internal cutting fluid supply
Cylindrical with flat



266 R/LL

266R/LKF
Cylindrical with flat



\triangle	iC	dm_m inch	Angle of inclination with different shims, see page C45.
16	3/8	20-50	-2° - $+4^\circ$
22	1/2	25-50	1°
27	5/8	40	0° - $+3^\circ$
			No shims used
16	3/8	16	2°
22	1/2	20	2°



x and z, see infeed tables on pages C70.

Right hand style shown

Metric version

Main application	Insert size		Ordering code	Dimensions							Nm ¹⁾
	\triangle	iC		dm_m	D_m min	f_1	h	h_1	b	γ_n	
	16	3/8	266RKF-16-16	16	20	12.0		125	27.0	-15°	3.0
			266R/LKF-20-16	20	25	14.0	18	250	29.0	-15°	3.0
			266R/LKF-25-16	25	32	17.0	23	300	29.0	-15°	3.0
			266R/LKF-32-16	32	40	22.0	30	250	30.9	-15°	3.0
			266R/LKF-40-16	40	50	27.0	37	300	31.5	-15°	3.0
	266R/LKF-50-16	50	63	35.0	49	350	40.2	-15°	3.0		
	22	1/2	266RKF-20-22	20	25	15.0	18	250	36.5	-15°	5.0
			266R/LKF-25-22	25	32	19.0	23	300	34.6	-15°	5.0
			266R/LKF-32-22	32	40	21.9	30	250	37.7	-15°	5.0
			266R/LKF-40-22	40	50	26.9	37	300	38.2	-15°	5.0
266R/LKF-50-22			50	63	34.9	47	350	45.7	-15°	5.0	
27	5/8	266R/LKF-40-27	40	50	26.9	37	300	47.2	-10°	7.5	

¹⁾ Insert tightening torque, Nm.

266R = Right hand, 266L = Left hand

Angle of inclination with different shims, see page C45.

Main spare parts

Insert size			Insert screw		Key (Torx Plus)		Shim for right hand internal tool holder Inclination angle $+1^\circ$ ²⁾	Shim for left hand internal tool holder Inclination angle $+1^\circ$ ²⁾	Shim screw
\triangle	iC	dm_m							
16	3/8	16	5513 020-02	5680 049-05 (15IP/10IP)	-	-	-	-	
16	3/8	20-50	5513 020-13	5680 049-05 (15IP/10IP)	5322 390-11	5322 389-11	5512 032-05		
22	1/2	20	5513 020-07	5680 043-14 (20IP)	-	-	-		
22	1/2	25-50	5513 020-26	5680 043-14 (20IP)	5322 380-11	5322 379-11	5512 032-04		
27	5/8	40	5513 020-66	5680 043-15 (25IP)	5322 388-11	5322 387-11	5512 032-03		

²⁾ For optional shims, see page C45.



J2



C35



C64



G6

A
General Turning
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THREADING CoroThread® 266 – Internal threading

CoroThread® 266 boring bars
Screw clamp design
Internal cutting fluid supply
Cylindrical with flats

266 R/LL

266R/LKF
Cylindrical with flat

	<i>iC</i>	<i>dm_m</i> inch	Angle of inclination with different shims, see page C45.
16	3/8	.750-2.000	-2°-+4°
22	1/2	1.250-2.000	No shims used
16	3/8	.625	2°

x and z, see infeed tables on pages C70.

Inch version

Main application	Insert size		Ordering code	Dimensions, inch							ft-lbs ¹⁾
		<i>iC</i>		<i>dm_m</i>	<i>D_m</i> min	<i>f₁</i>	<i>h</i>	<i>h₁</i>	<i>b</i>	γ_n	
	16	3/8	266RKF-D10-3	.625	.790	.472	.563	8	1.050	-15°	2.2
			266R/LKF-D12-3	.750	.980	.551	.709	10	1.140	-15°	2.2
			266R/LKF-D16-3	1.000	1.260	.669	.910	12	1.140	-15°	2.2
			266R/LKF-D20-3	1.250	1.580	.866	1.181	14	1.220	-15°	2.2
			266R/LKF-D24-3	1.500	1.970	1.063	1.378	15	1.260	-15°	2.2
			266R/LKF-D32-3	2.000	2.480	1.378	1.874	16	1.580	-15°	2.2
22	1/2	266R/LKF-D20-4	1.250	1.580	.866	1.181	14	1.742	-15°	3.7	
		266R/LKF-D24-4	1.500	1.970	1.063	1.378	15	2.012	-15°	3.7	
		266R/LKF-D32-4	2.000	2.480	1.378	1.874	16	2.059	-15°	3.7	

¹⁾ Insert tightening torque ft-lbs. 266R = Right hand, 266L = Left hand

Angle of inclination with different shims, see page C45.

Main spare parts

Insert size			Insert screw		Key (Torx Plus)		Shim for right hand internal tool holder Inclination angle +1° ²⁾		Shim for left hand internal tool holder Inclination angle +1° ²⁾		Shim screw
	<i>iC</i>	<i>dm_m</i>									
16	3/8	.625	5513 020-02	5680 049-05 (15IP/10IP)	-	-	-	-	-	-	
16	3/8	.750-2.000	5513 020-13	5680 049-05 (15IP/10IP)	5322 390-11	5322 389-11	5512 032-05				
22	1/2	1.250-2.000	5513 020-26	5680 043-14 (20IP)	5322 380-11	5322 379-11	5512 032-04				

²⁾ For optional shims, see page C45.

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C 42

CoroThread® 266 boring bars

Screw clamp design

Internal cutting fluid supply

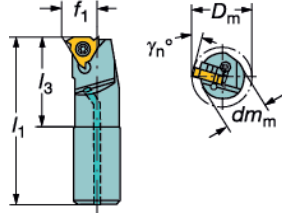
Cylindrical with groove for EasyFix sleeve

266R/LKF-R

Cylindrical with groove for EasyFix sleeve



266 R/LL



\triangleleft	iC	dm _m mm	dm _m in.	Angle of inclination with different shims, see page C45.
16	3/8	20-25	.750-1.000	-2°-+4°
22	1/2	25	1.000	
				No shims used
16	3/8	16	.625	2°
22	1/2	20	.750	



x and z, see infeed tables on pages C70.

Right hand style shown

Metric version

Main application	Insert size		Ordering code	Dimensions						Nm ¹⁾
	\triangleleft	iC		dm _m	D _m min	f ₁	h ₁	b ₃	γ _n	
	16	3/8	266RKF-16-16-R	16	20	12.0	125	27.0	-15°	3.0
			266R/LKF-20-16-R	20	25	14.0	140	28.7	-15°	3.0
			266R/LKF-25-16-R	25	32	17.0	180	28.8	-15°	3.0
	22	1/2	266RKF-20-22-R	20	25	15.0	140	34.2	-15°	5.0
			266R/LKF-25-22-R	25	32	19.0	180	34.6	-15°	5.0

Inch version

Main application	Insert size		Ordering code	Dimensions, inch						ft-lbs ²⁾
	\triangleleft	iC		dm _m	D _m min	f ₁	h ₁	b ₃	γ _n	
	16	3/8	266RKF-D10-3-R	.625	.790	.472	8	1.050	-15°	2.2
			266R/LKF-D12-3-R	.750	.980	.551	10	1.140	-15°	2.2
			266R/LKF-D16-3-R	1.000	1.260	.669	12	1.140	-15°	2.2
	22	1/2	266RKF-D12-4-R	.750	.984	.591	5.5	1.346	-15°	3.7
			266R/LKF-D16-4-R	1.000	1.260	.669	12	1.341	-15°	3.7
			Carbide							
16	3/8	266RKF-D12-3-RE	.750	.980	.551	10	1.140	-15°	2.2	

¹⁾ Insert tightening torque, Nm.

²⁾ Insert tightening torque ft-lbs.

266R = Right hand, 266L = Left hand

Angle of inclination with different shims, see page C45.

Main spare parts

Insert size				Insert screw		Key (Torx Plus)		Shim for right hand internal tool holder Inclination angle +1° ³⁾		Shim for left hand internal tool holder Inclination angle +1° ³⁾		Shim screw
\triangleleft	iC	dm _m mm	dm _m in.									
16	3/8	16	.625	5513 020-02	5680 049-05 (15IP/10IP)	-	-	-	-	-	-	
16	3/8	20-25	.750-1.000	5513 020-13	5680 049-05 (15IP/10IP)	5322 390-11	5322 390-11	5322 389-11	5322 389-11	5512 032-05		
22	1/2	20	.750	5513 020-07	5680 043-14 (20IP)	-	-	-	-	-		
22	1/2	25	1.000	5513 020-26	5680 043-14 (20IP)	5322 380-11	5322 380-11	5322 379-11	5322 379-11	5512 032-04		

³⁾ For optional shims, see page C45.



J2



C35



C64



G6

A General Turning
B Parting and Grooving
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A
General Turning
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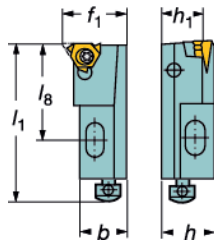
THREADING CoroThread® 266 – Internal threading



CoroThread® 266 cartridges

Screw clamp design



266 R/LL


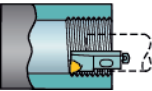


	<i>iC</i>	Angle of inclination with different shims, see page C45.
16	3/8	 -2°-+4°
22	1/2	



x and z, see infeed tables on pages C70.


Right hand style shown

Main application	Insert size		Ordering code	Dimensions, mm, inch							Nm ¹⁾
		<i>iC</i>		<i>D_m</i> min	<i>b</i>	<i>f₁</i>	<i>h₁</i>	<i>h</i>	<i>h₂</i>	<i>γ_n</i>	
	16	3/8	266R/LKF-16CA-16	55	19	25.0	63	21	38	-15°	3.0
				2.165	.748	.984	2.480	.827	1.496		
	22	1/2	266R/LKF-20CA-22	60	16	25.0	70	21	40	-15°	5.0
				2.362	.630	.984	2.756	.827	1.575		

1) Insert tightening torque, Nm.

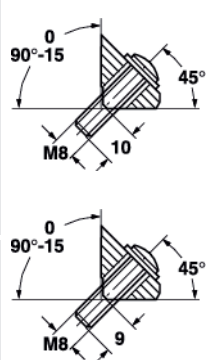
Angle of inclination with different shims, see page C45.

Main spare parts

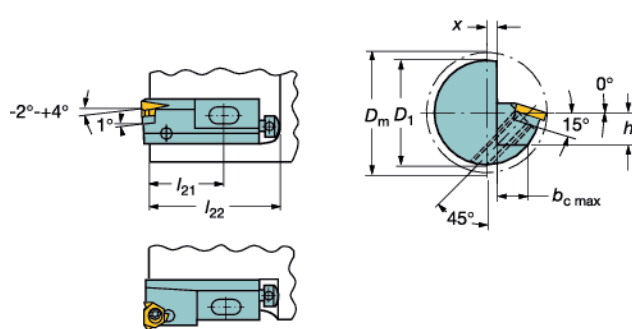
Insert size		Insert screw		Key (Torx Plus)		Shim for right hand internal tool holder		Shim for left hand internal tool holder		Shim screw	
	<i>iC</i>					Inclination angle +1° 2)		Inclination angle +1° 2)			
16	3/8	5513 020-13	5680 049-05 (15IP/10IP)	5322 390-11		5322 389-11		5512 032-05			
22	1/2	5513 020-26	5680 043-14 (20IP)	5322 380-11		5322 379-11		5512 032-04			

2) For optional shims, see page C45.

Mounting dimensions for cartridges



16CA
20CA



$$D_1 = 2 \sqrt{h_1^2 + (b_{C \max} + (-) x)^2}$$

$$x = \frac{D_m}{2} - f_1$$

Angle of inclination from -2° to +4° with different shims, see page C45.

Cartridge code	Dimensions, mm, inch						
	<i>D_m</i> min	<i>D₁</i> min	<i>x</i>	<i>l₁</i> min	<i>l₂</i>	<i>h₁</i>	<i>b_c</i> max
266R/LKF-16CA-16	55	50	4.47	35	60	16	15
	2.165	1.969	.176	1.378	2.362	.630	.591
266R/LKF-20CA-22	60	55	6.63	37	67	20	12.2
	2.362	2.165	.261	1.460	2.638	.787	.480



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Selecting shims

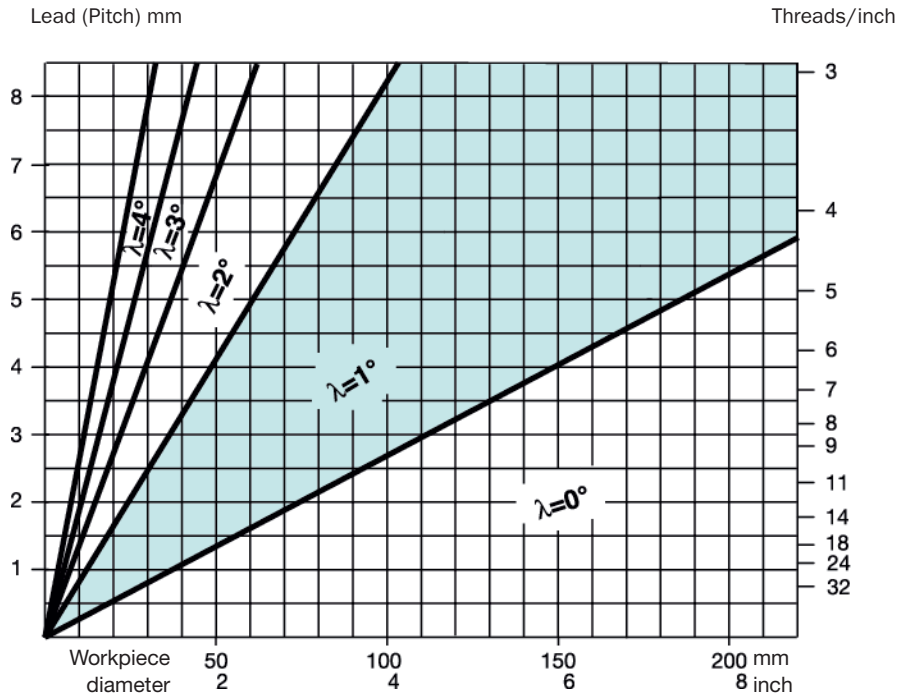
The angle of inclination is calculated by using the formula:




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

P = Pitch = 1/TPI

d₂ = Effective diameter of thread

λ = Angle of inclination



Pitch range mm (TPI)	Insert size		Inclination angle	Shims	
		<i>iC</i>			
0.5-3.0 (32-6)	16	3/8	-2° -1° 0° 1° 2° 3° 4°	For right hand external tool For left hand internal tool	For left hand external tool For right hand internal tool
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

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°.

Selecting shims

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:

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

P = Pitch = 1/TPI

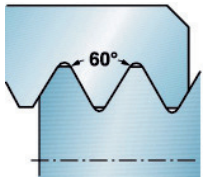
d₂ = Effective diameter of thread

λ = Angle of inclination

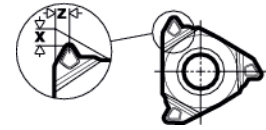
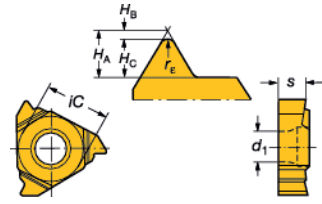
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V-profile 60° Non-topping

P M K N S H



$$H_C = H_A - H_B$$



Style shown: Right hand external, Left hand internal

x = 0.68 mm (.0268 inch)
z = 0.9 mm (.0354 inch)

Dimensions, mm (inch)

iC	Pitch, mm	Pitch, TPI	iC mm	d_1	s
11	1.0-2.0	24-12	6.35	2.8 (.110)	3.17 (.125)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

Internal

For ISO application areas, see bottom of the table.

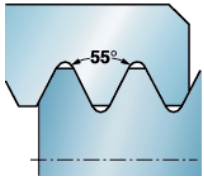
iC	Pitch, mm	Pitch, TPI	Ordering code	Dimensions, mm, inch		ISO Application Areas															
				H_A mm	H_A in.	H_B mm	H_B in.	r_e mm	r_e in.	P	M	K	N	S	H						
11	1-2.00	24-12	R166.0L-11VM01-001	1.45	.0571	0.06	.0024	0.06	.0024	GC	GC	GC	GC	GC	GC						
			★							★	★	★	★	★							
			★							★	★	★	★	★							
			R166.0L-11VM01C001							P20	P20	M20	M20	K15	K15	N25	N25	S20	S20	H20	H20

1) For maximum support use a reinforced shim. See page C57.

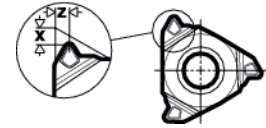
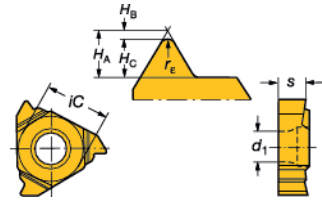
R = Right hand, L = Left hand
★ = First choice

V-profile 55° Non-topping

P M K N S H



$$H_C = H_A - H_B$$



Style shown: Right hand external, Left hand internal

x = 0.68 mm (.0268 inch)
z = 0.9 mm (.0354 inch)

Dimensions, mm (inch)

iC	Pitch, TPI	iC mm	d_1	s
11	28-14	6.35	2.8 (.110)	3.17 (.125)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

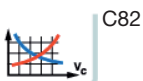
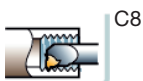
Internal

For ISO application areas, see bottom of the table.

iC	Pitch, TPI	Ordering code	Dimensions, mm, inch		ISO Application Areas																
			H_A mm	H_A in.	H_B mm	H_B in.	r_e mm	r_e in.	P	M	K	N	S	H							
11	28-14	R166.0L-11VW01-001	1.60	.0630	0.12	.0047	0.11	.0043	GC	GC	GC	GC	GC	GC							
		★							★	★	★	★	★								
		★							★	★	★	★	★								
		L166.0L-11VW01-001								P20	P20	M20	M20	K15	K15	N25	N25	S20	S20	H20	H20

1) For maximum support use a reinforced shim. See page C57.

R = Right hand, L = Left hand
★ = First choice



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THREADING T-Max U-Lock® inserts

Metric 60° Topping

Threads for general usage in all segments of engineering industry

P M K N S H

Single-point

ISO 965-1998 Tolerance class 6

Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

\triangle	iC	Pitch, mm	iC mm	d_1	s
11	1/4	0.5-2.0	6.35	2.8 (.110)	3.17 (.125)

Tailor Made

Even more possibilities thanks to tailored design! See page J3.

Internal

For ISO application areas, see bottom of the table.

\triangle	iC	Pitch, mm	Ordering code	Dimensions, millimeter, inch (mm, in.)								Material													
				H_A		H_B		x		z		P		M		K		N		S		H			
				mm	in.	mm	in.	mm	in.	mm	in.	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC		
11	1/4	0.50	R/L166.0L-11MM01-050	0.32	.0126	0.03	.0012	0.68	.0268	0.5	.0197	★	★	★	★	★	★	★	★	★	★	★	★		
		0.75	R/L166.0L-11MM01-075	0.47	.0185	0.04	.0016	0.68	.0268	0.6	.0236	★	★	★	★	★	★	★	★	★	★	★	★	★	
		1.00	R166.0L-11MM01-100 L166.0L-11MM01-100	0.64	.0252	0.06	.0024	0.68	.0268	0.8	0.315	★	☆	★	★	★	★	★	★	★	★	★	★	★	★
		1.25	R/L166.0L-11MM01-125	0.79	.0311	0.07	.0028	0.68	.0268	0.8	.0314	★	★	★	★	★	★	★	★	★	★	★	★	★	★
		1.50	R166.0L-11MM01-150 L166.0L-11MM01-150	0.96	.0378	0.09	.0035	0.68	.0268	1.1	.0433	★	★	★	★	★	★	★	★	★	★	★	★	★	★
		1.75	R/L166.0L-11MM01-175	1.11	.0437	0.11	.0043	0.68	.0268	1.05	.0413	★	★	★	★	★	★	★	★	★	★	★	★	★	★
		2.00	R166.0L-11MM01-200 L166.0L-11MM01-200	1.27	.0500	0.12	.0047	0.58	.0228	0.92	.0362	★	★	★	★	★	★	★	★	★	★	★	★	★	★
														P20	M20	K15	K15	N25	S20	S20	H20	H20			

R = Right hand, L = Left hand
★ = First choice

C8

C82

C86

C2

J3

I8

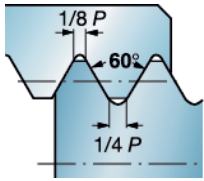
C 48

SANDVIK
Coromant

UN 60° Topping

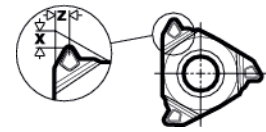
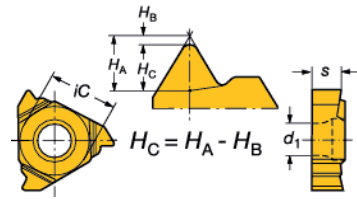
Threads for general usage in all segments of engineering industry

P M K N S H



ISO 5864-1978
Tolerance class 2B, int.
Tolerance class 2A, ext.

Single-point



Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

iC	Pitch, TPI	iC mm	d_1	s
11	1/4	32-14	6.35	2.8 (.110) 3.17 (.125)

Tailor Made

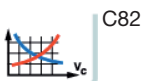
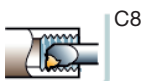
Even more possibilities thanks to tailored design! See page J3.

Internal

For ISO application areas, see bottom of the table.

iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)								Material						
			H_A mm	H_A in.	H_B mm	H_B in.	x mm	x in.	z mm	z in.	P	M	K	N	S	H	
			GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
11	1/4	32	R/L166.0L-11UN01-320	0.50	.0197	0.04	.0016	0.68	.0268	0.6	.0236	★	★	★	★	★	★
		28	R/L166.0L-11UN01-280	0.58	.0228	0.05	.0020			0.8	.0315	★	★	★	★	★	★
		24	R/L166.0L-11UN01-240	0.67	.0264	0.06	.0024			0.85	.0335	★	★	★	★	★	★
		20	R/L166.0L-11UN01-200	0.80	.0315	0.07	.0028			0.9	.0354	★	★	★	★	★	★
		18	R/L166.0L-11UN01-180	0.89	.0350	0.08	.0031			1.0	.0394	★	★	★	★	★	★
		16	R/L166.0L-11UN01-160	1.00	.0394	0.09	.0035			1.0	.0394	★	★	★	★	★	★
		14	R/L166.0L-11UN01-140	1.13	.0445	0.11	.0043			1.05	.0413	★	★	★	★	★	★
												P20	M20	K15	N25	S20	H20

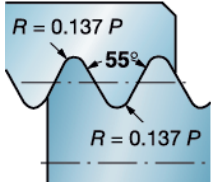
R = Right hand, L = Left hand
★ = First choice



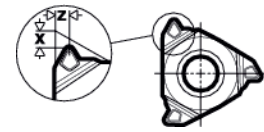
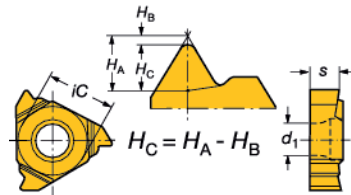
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Whitworth 55° (BSW, BSF, BSP) Topping

Threads for pipe fittings and couplings for gas, water and sewage



Single-point



ISO 228-1982
BS 2779-1973
BS 84-1956
Class A tolerance

Pipe threads 55°
External: G thread
Internal: G/R_p threads
Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

\triangle	iC	Pitch, TPI	iC mm	d_1	s
11	1/4	20-14	6.35	2.8 (.110)	3.17 (.125)



Even more possibilities thanks to tailored design! See page J3.

Internal

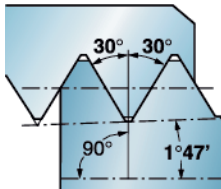
For ISO application areas, see bottom of the table.

\triangle	iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				Material														
				H_A mm	H_A in.	H_B mm	H_B in.	x mm	x in.	z mm	z in.	P	M	K	N	S	H					
				mm	in.	mm	in.	mm	in.	mm	in.	GC	GC	GC	GC	GC	GC	GC				
11	1/4	20	R/L166.0L-11WH01-200	0.99	.0390	0.17	.0067	0.68	.0268	0.9	.0354	★	★	★	★	★	★	★	★	★		
			19	R166.0L-11WH01-190	1.05	.0413	0.18	.0071					★	★	★	★	★	★	★	★	★	
		14	L166.0L-11WH01-190																			
			R166.0L-11WH01-140	1.43	.0563	0.25	.0098			1.05	.0413											
			L166.0L-11WH01-140																			
												P20	M20	M20	K15	K15	N25	S20	S20	H20	H20	

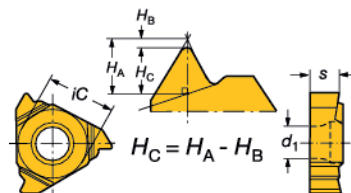
R = Right hand, L = Left hand
★ = First choice

NPT 60° NPSC, NPTR, LINE PIPE¹⁾ Topping

Threads for pipe fittings and couplings for gas, water and sewage



Single-point



ANSI B.1.20.1-1983

Style shown: Right hand external, Left hand internal

Dimensions, mm (inch)

\triangle	iC	Pitch, TPI	iC mm	d_1	s
11	1/4	18-14	6.35	2.8 (.110)	3.17 (.125)



Even more possibilities thanks to tailored design! See page J3.

For ISO application areas, see bottom of the table.

\triangle	iC	Pitch, TPI	Ordering code	Dimensions, millimeter, inch (mm, in.)				Material													
				H_A mm	H_A in.	H_B mm	H_B in.	P	M	K	N	S	H								
				mm	in.	mm	in.	GC	GC	GC	GC	GC	GC								
11	1/4	18	R166.0L-11NT01F180	1.14	.0449	0.08	.0031	★	★	★	★	★	★	★	★						
		14	R166.0L-11NT01F140	1.46	.0575	0.09	.0035	★	★	★	★	★	★	★	★						
												P20	M20	M20	K15	K15	N25	S20	S20	H20	H20

R = Right hand, L = Left hand
★ = First choice

¹⁾ The insert can give a slightly bigger truncation for LINE PIPE 14 TPI
²⁾ For maximum support use a reinforced shim. See page C57.



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T-Max U-Lock® Coromant Capto® cutting units

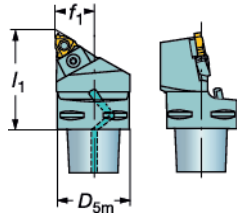
Wedge clamp design



266 R/LG

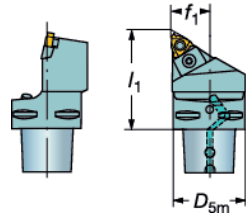
To be used with CoroThread 266 inserts

Cx-R/L166.5FA



Cx-R/L166.5FAZ

For upside down mounting



	iC	Angle of inclination with different shims, see page C45.
16	3/8	



x and z, see infeed tables on pages C70.

Threading of slender components and against live center

Right hand style shown

Main application	Insert size		Ordering code	Dimensions, millimeter, inch (mm, in.)						Nm ¹⁾
		iC		D_{5m} mm	D_{5m} in.	f_1 mm	f_1 in.	h mm	h in.	
	16	3/8	C3-R/L166.5FA-17039-16	32	1.260	17	.669	39	1.535	1.7
			C4-R/L166.5FA-21055-16	40	1.575	21	.827	55	2.165	1.7
			C5-R/L166.5FA-26065-16	50	1.968	26	1.024	65	2.559	1.7
			C6-R/L166.5FA-33075-16	63	2.480	33	1.299	75	2.953	1.7
	16	3/8	C3-R166.5FAZ17039-16	32	1.260	17	.669	39	1.535	1.7
			C4-R166.5FAZ21055-16	40	1.575	21	.827	55	2.165	1.7
			C5-R166.5FAZ26065-16	50	1.968	26	1.024	65	2.559	1.7
			C6-R166.5FAZ33075-16	63	2.480	33	1.299	75	2.953	1.7

¹⁾ Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size		Shims ¹⁾ Inclination angle +1°				
	iC	Wedge set	Center pin	Key (Torx Plus)	Right hand	Left hand
16	3/8	5431 126-011	5313 033-01	5680 051-03 (9IP)	5322 371-11	5322 372-11

¹⁾ For optional shims, see page C57.



C4



C52



C65



G6



C2



J2

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H Multi-task machining
I CoroTurn® SL
J General information

T-Max U-Lock® shank tools

Wedge clamp design

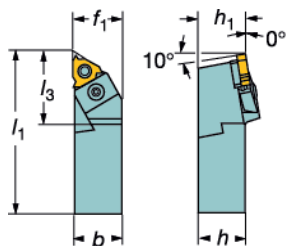
Threading of slender components and against live center



266 R/LG

To be used with CoroThread 266 inserts

R/L166.5FA



	iC	Angle of inclination with different shims, see page C45.
16	3/8	

Threading of slender components and against live center



x and z, see infeed tables on pages C70.

Right hand style shown

Metric version

Main application	Insert size		Pitch range		Ordering code	Dimensions						Nm ¹⁾
		iC	mm	TPI		b	f_1	h	h_1	l_1	l_2	
	16	3/8	0.5-3.0	32-6	R/L166.5FA-1212-16	12	12.5	12	12	80	30.4	1.7
					R/L166.5FA-1616-16	16	16.5	16	16	100	30.4	1.7
					R/L166.5FA-2020-16	20	20.5	20	20	125	30.4	1.7
					R/L166.5FA-2525-16	25	25.5	25	25	150	30.4	1.7

Inch version

Main application	Insert size		Pitch range		Ordering code	Dimensions, inch						ft-lbs ²⁾
		iC	mm	TPI		b	f_1	h	h_1	l_1	l_2	
	16	3/8	0.5-3.0	32-6	R166.5FA-083	.500	.520	.500	.500	3.500	1.200	0.9
					R/L166.5FA-103	.625	.645	.625	.625	4.000	1.200	0.9
					R/L166.5FA-123B	.750	.770	.750	.750	4.500	1.200	0.9
					R/L166.5FA-163D	1.000	1.020	1.000	1.000	6.000	1.200	0.9
					R166.5FA-203D	1.250	1.289	1.250	1.250	6.000	1.200	0.9

- 1) Insert tightening torque, Nm.
- 2) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size					Shim ³⁾ Inclination angle +1°	
	iC	Wedge set	Center pin	Key (Torx Plus)	Right hand	Left hand
16	3/8	5431 126-011	5313 033-01	5680 051-03 (9IP)	5322 371-11	5322 372-11

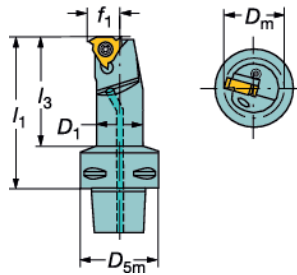
3) For optional shims, see page C57.



T-Max U-Lock® Coromant Capto® cutting units

Screw clamp design

Steel bar with internal cutting fluid supply



	<i>iC</i>		No shims used.
11	1/4		



x and z values, see T-Max U-Lock insert pages, C70.

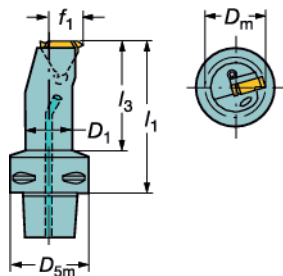
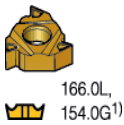
Right hand style shown

Main application	Insert size		Pitch range		Ordering code	Dimensions, mm, inch						Nm ¹⁾
		<i>iC</i>	mm	TPI		<i>D₁</i>	<i>D_m</i> min	<i>D_{5m}</i>	<i>f₁</i>	<i>l₁</i>	<i>l₃</i>	
	11	1/4	0.5-2.0	32-12	C3-R/L166.0KF-12050-11	16.0	20	32	12	50	33	0.9
						.630	.787	1.260	.472	1.969	1.299	0.9
					C4-R/L166.0KF-12060-11	16.0	20	40	12	60	37	0.9
						.630	.787	1.575	.472	2.362	1.457	0.9

¹⁾ Insert tightening torque, Nm.

R = Right hand, L = Left hand

For upside down mounting



	<i>iC</i>		No shims used.
11	1/4		



x and z values, see T-Max U-Lock insert pages, C70.

Right hand style shown

Main application	Insert size		Pitch range		Ordering code	Dimensions, mm, inch						Nm ¹⁾
		<i>iC</i>	mm	TPI		<i>D₁</i>	<i>D_m</i> min	<i>D_{5m}</i>	<i>f₁</i>	<i>l₁</i>	<i>l₃</i>	
	11	1/4	0.5-2.0	32-12	C3-R166.0KFZ12050-11	16.0	20	32	12	50	33	0.9
						.630	.787	1.260	.472	1.969	1.299	0.9
					C4-R166.0KFZ12060-11	16.0	20	40	12	60	37	0.9
						.630	.787	1.575	.472	2.362	1.457	0.9

¹⁾ Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size			Insert screw	Key (Torx Plus)
	<i>iC</i>	<i>D₁</i>		
11	1/4	.630	5513 020-03	5680 051-02 (7IP)

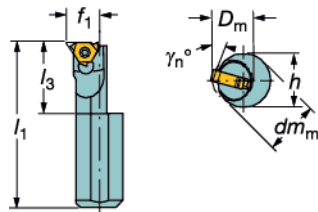


T-Max U-Lock® boring bars

Screw clamp design
Cylindrical with flat



R166.0KF



	<i>iC</i>		No shims used.
11	1/4	1°	



x and z values, see T-Max U-Lock insert pages, C70.

Metric version

Right hand style shown

Main application	Insert size		Pitch range		Ordering code	Dimensions							Nm ¹⁾
		<i>iC</i>	mm	TPI		<i>dm_m</i>	<i>D_m min</i>	<i>f₁</i>	<i>h</i>	<i>h₁</i>	<i>h₂</i>	<i>γ_n</i>	
	11	1/4	0.5-2.0	32-12	R/L166.0KF-16-1220-11B	16	12	10	15	125	20.9	-15	0.9
					R/L166.0KF-16-1625-11B	16	16	10.5	15	150	25.9	-15	0.9

Inch version

Main application	Insert size		Pitch range		Ordering code	Dimensions, inch							ft-lbs ²⁾
		<i>iC</i>	mm	TPI		<i>dm_m</i>	<i>D_m min</i>	<i>f₁</i>	<i>h</i>	<i>h₁</i>	<i>h₂</i>	<i>γ_n</i>	
	11	1/4	0.5-2.0	32-12	R/L166.0KF-D10-D0812-2B	0.625	0.5	.394	.570	5.000	.820	-15	0.7
					R166.0KF-D10-D1016-2B	0.625	0.63	.413	.563	6.000	1.030	-15	0.7

1) Insert tightening torque, Nm.
2) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size	Insert screw	Key (Torx Plus)
11 <i>iC</i> 1/4	5513 020-03	5680 051-02 (7IP)



T-Max U-lock® carbide and steel boring bars

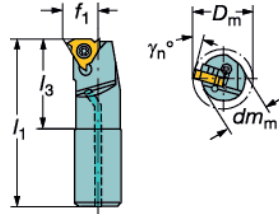
Cylindrical shank

With groove for EasyFix sleeve

Screw clamp design



R/L166.4KF
R166.0KF



	<i>iC</i>		No shims used.
11	1/4		



x and z values, see T-Max U-Lock insert pages, C70.

Right hand style shown

Metric version

Main application	Insert size		Pitch range		Ordering code	Dimensions						
		<i>iC</i>	mm	TPI		<i>dm_m</i>	<i>D_m min</i>	<i>f₁</i>	<i>h</i>	<i>h₁</i>	<i>b_s</i>	<i>γ_n</i>
	11	1/4	0.5-2.0	32-12	R166.0KF-10E-11 R166.0KF-12E-11	10 12	12 16	7.2 9	150 180	21.0 25.0	-15 -15	0.9 0.9

Inch version

Main application	Insert size		Pitch range		Ordering code	Dimensions, inch							
		<i>iC</i>	mm	TPI		<i>dm_m</i>	<i>D_m min</i>	<i>f₁</i>	<i>h</i>	<i>h₁</i>	<i>b_s</i>	<i>γ_n</i>	ft-lbs ²⁾
	11	1/4	0.5-2.0	32-12	R/L166.0KF-D06C-2C R/L166.0KF-D08C-2C	0.375 0.5	0.5 0.63	.295 .354	.359 .484	6.000 8.000	.880 .930	-15 -15	0.7 0.7

1) Insert tightening torque, Nm.

2) Insert tightening torque ft-lbs.

For coolant connector, see page A308.

R = Right hand, L = Left hand

Main spare parts

Insert size			Insert screw	Key (Torx Plus)
<i>iC</i>		\varnothing <i>dm_m</i>		
1/4	11	.625-.630	5513 020-03	5680 051-02 (7IP)



T-Max U-Lock® boring bars

Cylindrical

Screw clamp design dedicated for circlip grooves

R154.0KF

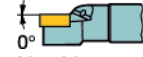
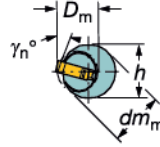
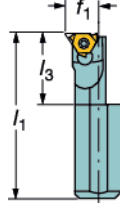
Cylindrical with flats



166.0L,
154.0G¹⁾



x and z, see infeed tables on pages C70.



No shims used.

Cylindrical with flats

Right hand style shown

Main application	Insert size		Pitch range		Ordering code	Dimensions, mm, inch						
		iC	mm	TPI		dm	Dm min	f1	h	h1	h2	Nm ¹⁾
	11	1/4	0.5-2.0	32-12	R154.0KF-16-1220-11B	16	12	10	15	125	20.9	0.9
						.630	.472	.394	.591	4.921	.823	0.9

1) Insert tightening torque, Nm.

R = Right hand

For coolant connector, see page A308.







Main spare parts

Insert size	Insert screw	Key (Torx Plus)
11	5513 020-03	5680 051-02 (7IP)



Selecting shims

T-Max U-Lock®

Pitch range	Insert size	Inclination angle	Shims for QC-screw holders 166.4, 466.4 and 566.4	Shims for wedge clamping holders 166.5
mm (TPI)	 <i>iC</i>		  Reinforced	 Right hand  Left hand
0.5–3.0 (32-6)	16 3/8	-2° -1° 0° 1° 2° 3° 4°	5322 361-22 – 5322 361-21 – 5322 361-10 ¹⁾ – 5322 361-11 ²⁾ 5322 363-11 5322 361-12 5322 363-12 5322 361-13 5322 363-13 5322 361-14 5322 363-14	– – 5322 371-10 ¹⁾ 5322 372-10 ¹⁾ 5322 371-11 ²⁾ 5322 372-11 ²⁾ 5322 371-12 5322 372-12 5322 371-13 5322 372-13 5322 371-14 5322 372-14
2.5-7.0 (11.5-4)	22 1/2	-2° -1° 0° 1° 2° 3° 4°	5322 365-22 – 5322 365-21 – 5322 365-10 ¹⁾ – 5322 365-11 ²⁾ 5322 367-11 5322 365-12 5322 367-12 5322 365-13 5322 367-13 5322 365-14 5322 367-14	
Pitch range	Insert size	Inclination angle	Shims for U-screw holders 166.0 and 566.0	
mm (TPI)	 <i>iC</i>		External Right hand	Internal Right hand
8.0 (5-3)	27 5/8	0° 1° 2° 3°	5322 385-10 5322 383-11 ²⁾ 5322 385-12 5322 385-13	5322 386-10 5322 383-11 ²⁾ 5322 386-12 5322 386-13

1) Must be used when using U-Lock circlip grooving inserts, type R/L 154.0G.

2) 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 361-11 = angle + 1° and 5322 361-21 = angle - 1°.

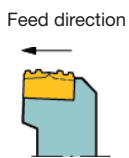
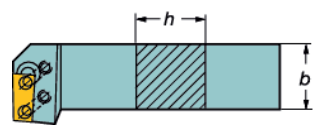
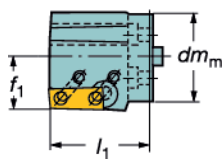
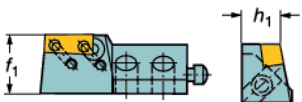
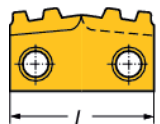
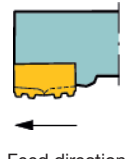
Note: Shims for quick change screw holders, 166.4, are symmetrical, i.e. there are no left and right hand versions. Shims for wedge clamp holders, 166.5, are not symmetrical and are available in left and right hand versions.

Code key for T-Max Twin-Lock® for oil pipe threading

T-Max Twin-Lock® holders

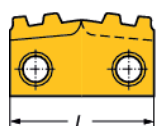
R	166.39	FG	-	3232	-	24
1	2	3		4		5

1 Hand of tool	2 Main code
R = Right hand style	166.39 = Twin-Lock® shank holder 466.39 = Twin-Lock® cartridge 566.39 = Twin-Lock® SL cutting head

3 Type of tool and holder style	4 Toolholder dimensions, mm	5 Insert dimension, mm
<p>External</p>  <p>FG</p>	<p>Shank tool $h \times b$</p>  <p>T-Max Twin-Lock® SL cutting head $dm_m \times l_1 \times f_1$</p>  <p>Cartridge $h_1 \times f_1$</p> 	<p>Insert size l, in mm $l = 24.0 \text{ mm } (.945 \text{ inch})$</p> 
<p>Internal</p>  <p>KF</p>		

T-Max Twin-Lock® inserts

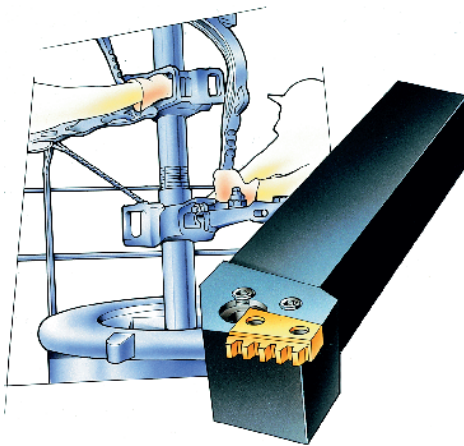
R	166.39	G	-	24	RD1	3	-	080
1	2	3		4	5	6		7

1 Hand of insert	2 Main code	3 Type of machining	4 Insert dimension
R = Right hand style insert	166.39 = T-Max Twin-Lock®	G = Inserts for external threading L = Inserts for internal threading	Length l , in mm $l = 24.0 \text{ mm } (.945 \text{ inch})$
			

5 Thread profile	6 Number of points per cutting edge	7 Pitch
RD0 = API Round Vee tubing and casing RD1 = API Round Vee tubing and casing BU1 = API Buttress $\leq 13 \frac{3}{8}$ " (3/4" i.p.f) BU2 = API Buttress ≥ 16 " (1" i.p.f)	Varies from 2 to 4 points.	Number of threads per inch x 10

A General Turning
B Parting and Grooving
C Threading
G Tooling systems
H Multi-task machining
I CoroTurn® SL
J General information

The T-Max Twin-Lock system

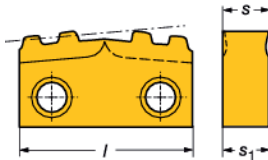


T-Max Twin-Lock® is a system that well suits the wide and varying aspects and requirements of the oil related industry, primarily for use in the high volume area of tubing, casing and coupling production.

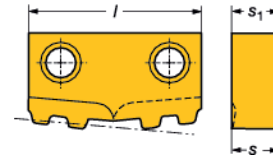
Tool joint and rotary shouldered connection threads are also covered by the system where the excellent indexing accuracy, edge security and repeatability are ideally suited to modern production units.

External and internal threading inserts for casing and tubing

External (pin)



Internal (box)



Dimensions: $l = 24.0$ (.945 inch) $s_1 = 6.4$ (.252 inch) $s = 6.35$ (.250 inch)

Component range, mm (inch)	Thread form	Pitch	Taper on dia.	Ordering code	No. of points		
						GC	GC
	Double sided	TPI	i.p.f.			1125	4125
API NU Tubing 1.050" – 3 1/2"	API Round Vee			External			
API EU Tubing 1.050" – 1.900"		10	3/4	R166.39G-24RD03-100	3+3	☆	
API IJ Tubing 1.315" – 2 1/16"		10	3/4	R166.39L-24RD04-100¹⁾	4+4	☆	
API NU Tubing 4" – 4 1/2"	API Round Vee			External			
API EU Tubing 2 3/8" – 4 1/2"		8	3/4	R166.39G-24RD13-080	3+3	☆	
API SR Casing 4 1/2" – 20"				Internal			
API LR Casing 4 1/2" – 20"		8	3/4	R166.39L-24RD04-080¹⁾	4+4	☆	
API Buttress Casing 4 1/2" – 13 3/8"	API Buttress			External			
		5	3/4	R166.39G-24BU12-050	2+2	☆	
	API Buttress			Internal			
		5	3/4	R166.39L-24BU12-050¹⁾	2+2	☆	
API Buttress Casing ≥ 16"	API Buttress			External			
		5	1	R166.39G-24BU22-050	2+2	☆	
	Rougher			Internal			
		5	1	R166.39L-24BU22-050¹⁾	2+2	☆	

¹⁾ To be used in holders giving 10° inclination angle.

R = Right hand



A
B
C
G
H
I
J

THREADING T-Max Twin-Lock® for oil pipe threading

T-Max Twin-Lock®

Lever design

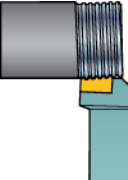
**Shank tool
R166.39FG**

**SL cutting head
R 566.39KF**

R166.39G/L


Right hand style shown

Shank tool

Main application	Pitch range	Ordering code	Dimensions, mm, inch				
	TPI		<i>b</i>	<i>f₁</i>	<i>h</i>	<i>h₁</i>	<i>l₁</i>
	10-5	R166.39FG-3232-24	32	38.6	32	32	148.4
			1.260	1.520	1.260	1.260	5.842

R = Right hand

T-Max Twin-Lock® SL cutting head

Main application	Pitch range	Ordering code	Coupling size	Dimensions, mm, inch			
	TPI			<i>dm_m</i>	<i>D_m min</i>	<i>f₁</i>	<i>l₁</i>
	10-5	R566.39KF-404527-24 ¹⁾	40	40.00	60.30	25.80	44.20
				1.575	2.374	1.016	1.740

¹⁾ Only for API Round Vee inserts, 8 and 10 TPI.

R = Right hand

Main spare parts

	Lever	Screw	Key (mm)	Shim
R166.39FG	5432 005-01	174.3-820M	170.3-860 (2.5)	5321 110-02
R566.39KF	5432 005-01	174.3-820M	170.3-860 (2.5)	5321 111-01



C 60



General information

T-Max Twin-Lock®

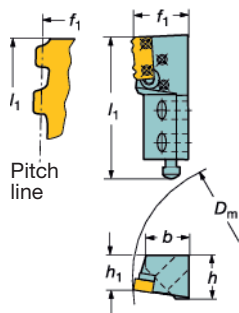
Cartridge

Lever design



R166.39G/L

R 466.39KF



Right hand style shown

Main application	Pitch range	Ordering code	Dimensions, mm, inch					
	TPI		D_m min	b	f_1	h	h_1	l_1
	10-5	R466.39KF-1832-24	114.00	25	30.0	24	18	80.0
			4.488	.984	1.181	.945	.709	3.150

R = Right hand

Main spare parts

Insert size	Lever	Screw	Key (mm)	Shim
24	5432 005-01	174.3-820M	170.3-860 (2.5)	5321 110-01



C59



C69



C2

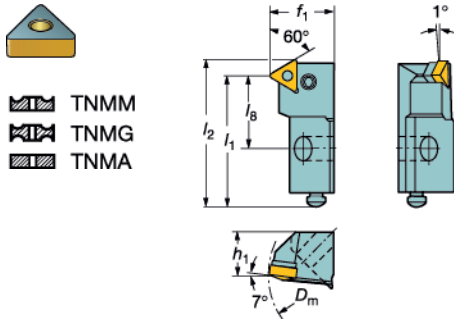


J2

T-Max P cartridge for rough threading

Lever design

R 466.3KW



- TNMM
- TNMG
- TNMA

Right hand style shown

Main application	Insert size		Pitch range		Ordering code	Dimensions, mm, inch						
		iC	mm	TPI		D _m min	f ₁	h	h ₁	h ₂	l ₁	l ₂
	16	3/8	0.5-3.0	32-6	R466.3KW-2030-16	79.00	29.7	26	20	59.3	67	29.36
						3.110	1.170	1.024	.787	2.335	2.638	1.156

R = Right hand

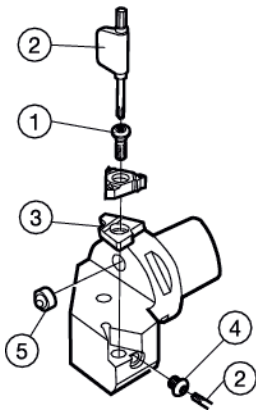
Main spare parts

Insert size	Lever	Screw	Key (mm)	Shim
 16	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M



CoroThread® 266 external

Shank tools/ Coromant Capto®



Nozzle for Coromant Capto® cutting units

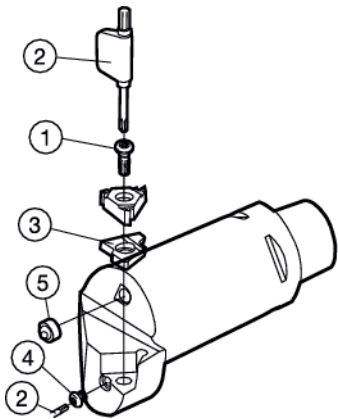
Cutting unit size	5
C3-C4	5691 034-01
C5-C6	5691 034-02
C8	5691 034-03

		1	2	3	4	
				Shims ¹⁾ Inclination angle +1°		
Shank tools	Coromant Capto®	Insert screw	Key (Torx Plus)	Right hand external	Left hand external	Shim screw
266R/LFG-1616-16	C3-266R/LFG-22040-16	5513 020-13	5680 049-05 (15IP/10IP)	5322 389-11	5322 390-11	5512 032-05
266R/LFG-2020-16	C4-266R/LFG-27050-16					
266R/LFG-2525-16	C5-266R/LFG-35060-16					
266R/LFG-3225-16	C6-266R/LFG-45065-16					
266R/LFGZ2525-16	C8-266R/LFG-55080-16					
266RFGZ3225-16	C4-266RFGZ27050-16					
266R/LFG-123B	C5-266RFGZ35060-16					
266R/LFG-163D	C6-266RFGZ45065-16					
266R/LFG-203D						
266R/LFGZ123B						
266R/LFGZ163D						
266RFGZ203D						
266R/LFA-1010-16-S						
266R/LFA-1212-16-S						
266R/LFA-1616-16-S						
266R/LFA-063-S						
266R/LFA-083-S						
266R/LFA-103-S						
266R/LFA-123-S						
QS-266RFA-1010-16						
QS-266RFA-1212-16						
QS-266RFA-1616-16						
QS-266RFA-063						
QS-266RFA-083						
QS-266RFA-103						
266R/LFG-164D	C3-266R/LFG-22040-22	5513 020-26	5680 043-14 (20IP)	5322 379-11	5322 380-11	5512 032-04
266R/LFG-204D	C4-266R/LFG-27050-22					
266R/LFG-244E	C5-266R/LFG-35060-22					
266R/LFGZ164D	C6-266R/LFG-45065-22					
266R/LFGZ204D	C8-266R/LFG-55080-22					
266R/LFG-2525-22	C4-266R/LFGZ27050-22					
266R/LFG-3232-22	C5-266R/LFGZ35060-22					
266R/LFG-4040-22	C6-266R/LFGZ45065-22					
266R/LFGZ2525-22						
266R/LFGZ3232-22						
266R/LFG-205D	C6-266R/LFG-45065-27	5513 020-66	5680 043-15 (25IP)	5322 387-11	5322 388-11	5512 032-03
266R/LFG-245E	C6-266R/LFGZ45065-27					
266R/LFG-3232-27						
266R/LFG-4040-27						

1) For optional shims, see page C45.

CoroThread® 266 internal

Boring bars/Coromant Capto



Nozzle for Coromant Capto® cutting units

Cutting unit size	5
C3-C4	5691 029-08
C5-C6	5691 029-09
C8	5691 029-10

Boring bar	Coromant Capto®	1		2		3		4	
		Insert screw	Key (Torx Plus)	Right hand internal	Left hand internal	Shim screw	Shims ¹⁾ Inclination angle +1°		
266R/LKF-20-16	C3-266R/LKF-14060-16	5512 020-13	5680 049-05 (15IP/10IP)	5322 390-11	5322 389-11	5512 032-05			
266R/LKF-25-16	C4-266R/LKF-14060-16								
266R/LKF-32-16	C4-266R/LKF-17070-16								
266R/LKF-40-16	C4-266RKF-22090-16								
266R/LKF-50-16	C5-266R/LKF-14060-16								
266R/LKF-D12-3	C5-266R/LKF-17070-16								
266R/LKF-D16-3	C5-266R/LKF-22090-16								
266R/LKF-D20-3	C5-266R/LKF-27105-16								
266R/LKF-D24-3	C6-266R/LKF-14070-16								
266R/LKF-D32-3	C6-266R/LKF-17075-16								
266R/LKF-20-16-R	C6-266R/LKF-22090-16								
266R/LKF-25-16-R	C6-266R/LKF-27105-16								
266LKF-D12-3-R									
266LKF-D16-3-R									
266RKF-D12-3-R									
266RKF-D12-3-RE									
266RKF-D16-3-R									
266R/LKF-D20-4	C5-266R/LKF-27105-22	5513 020-26	5680 043-14 (20IP)	5322 380-11	5322 379-11	5512 032-04			
266R/LKF-D24-4	C6-266R/LKF-27105-22								
266R/LKF-D32-4	C4-266RKF-19070-22								
266R/LKF-25-22	C4-266RKF-22090-22								
266R/LKF-25-22-R	C4-266RKF-27080-22								
266R/LKF-D16-4-R	C5-266RKF-19070-22								
266R/LKF-32-22	C5-266RKF-22090-22								
266R/LKF-40-22	C6-266RKF-19075-22								
266R/LKF-50-22	C6-266RKF-22090-22								
266R/LKF-40-27		5513 020-66	5680 043-15 (25IP)	5322 388-11	5322 387-11	5512 032-03			
Cartridges									
266R/LKF-16CA-16	C6-266RKF-22090-22								
266R/LKF-20CA-22		5513 020-26	5680 043-14 (20IP)	5322 388-11	5322 387-11	5512 032-04			

1) For optional shims, see page C45.

A General Turning
 B Parting and Grooving
 C Threading
 G Tooling systems
 H Multi-task machining
 I
 J CoroTurn® SL
 General information

T-Max U-Lock® external

OBSOLETE TOOLS

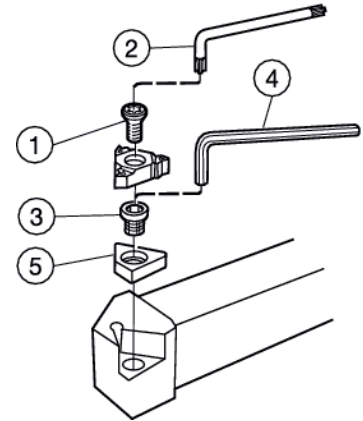
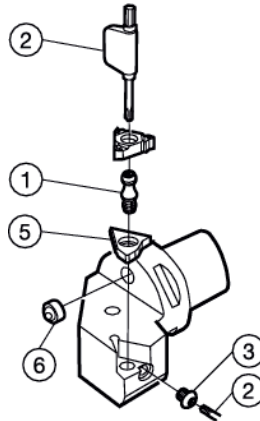
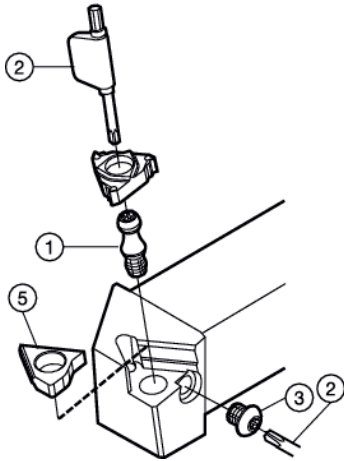
Shank tools/ Coromant Capto®

Screw clamping

Quick Change screw for insert sizes 16 (iC3/8) and 22 (iC1/2)

Quick Change screw for insert sizes 16 (iC3/8) and 22 (iC1/2)

T-Max U screw for insert size 27 (iC5/8)



		1	2	3	2										
Shank tools	Coromant Capto®	Insert screw (thread)	Key (Torx Plus)	Shim screw	Key (Torx Plus)										
R/L166.4FG/FGZ-123B	C3- R/L 166.4FG/FGZ22040-16	5513 026-01 (M4)	5680 051-03 (9IP)	5512 032-01	5680 051-03 (9IP)										
R/L166.4FG-163C	C4- R/L 166.4FG/FGZ27050-16	5513 020-13 ³⁾	5680 043-13 (15IP) ³⁾												
R/L166.4FG/FGZ-163D	C5- R/L 166.4FG/FGZ35060-16														
R/L166.4FG/FGZ-203D	C6- R/L 166.4FG/FGZ45065-16														
R/L166.4FG-1616-16	C8- R/L 166.4FG-55080-16														
R/L166.4FG-2020-16															
R/L166.4FG/FGZ-2525-16															
R/L166.4FG/FGZ-3225-16															
R/L166.4FA-1010-16-S															
R/L166.4FA-1212-16-S															
R/L166.4FA-1616-16-S															
R/L166.4FG-164D	C3- R/L 166.4FG/FGZ22040-22	5513 026-02 (M5)	5680 049-02 (15IP)	5512 032-02	5680 049-02 (15IP)										
R/L166.4FG-204D	C4- R/L 166.4FG/FGZ27050-22	5513 020-26 ²⁾	5680 043-14 (20IP) ³⁾												
R/L166.4FG-244E	C5- R/L 166.4FG/FGZ35060-22														
R/L166.4FGZ-2525-22	C6- R/L 166.4FG/FGZ45065-22														
R/L166.4FGZ-3232-22	C8- R/L 166.4FG-55080-22														
R/L166.4FG-4040-22															
R/L166.0FG-205D	—	5513 020-14 (M6)	5680 043-15 (25IP) ³⁾	5512 090-08	—										
R/L166.0FG-245E	—														
R/L166.0FG-4040-27	—	5513 020-14 (M6)	5680 043-15 (25IP)	5512 090-08	—										
Shank tools	Coromant Capto®	4	5												
R/L166.4FG/FGZ-123B	C3- R/L 166.4FG/FGZ22040-16	Key (size, mm)	Shims ¹⁾	<table border="1"> <thead> <tr> <th colspan="2">Nozzle for Coromant Capto® cutting units</th> </tr> <tr> <th>Cutting unit size</th> <th>6</th> </tr> </thead> <tbody> <tr> <td>C3-C4</td> <td>5691 029-08</td> </tr> <tr> <td>C5-C6</td> <td>5691 029-09</td> </tr> <tr> <td>C8</td> <td>5691 029-10</td> </tr> </tbody> </table>		Nozzle for Coromant Capto® cutting units		Cutting unit size	6	C3-C4	5691 029-08	C5-C6	5691 029-09	C8	5691 029-10
Nozzle for Coromant Capto® cutting units															
Cutting unit size	6														
C3-C4	5691 029-08														
C5-C6	5691 029-09														
C8	5691 029-10														
R/L166.4FG-123B	C4- R/L 166.4FG/FGZ27050-16	—	Inclination angle +1°												
R/L166.4FG/FGZ-163D	C5- R/L 166.4FG/FGZ35060-16		5322 361-11												
R/L166.4FG/FGZ-203D	C6- R/L 166.4FG/FGZ45065-16														
R/L166.4FG-1616-16	C8- R/L 166.4FG-55080-16														
R/L166.4FG-2020-16															
R/L166.4FG/FGZ-2525-16															
R/L166.4FG/FGZ-3225-16															
R/L166.4FA-1010-16-S															
R/L166.4FA-1212-16-S															
R/L166.4FA-1616-16-S															
R/L166.4FG-164D	C3- R/L 166.4FG/FGZ22040-22	—	5322 365-11												
R/L166.4FG-204D	C4- R/L 166.4FG/FGZ27050-22														
R/L166.4FG-244E	C5- R/L 166.4FG/FGZ35060-22														
R/L166.4FGZ-2525-22	C6- R/L 166.4FG/FGZ45065-22														
R/L166.4FGZ-3232-22	C8- R/L 166.4FG-55080-22														
R/L166.4FG-4040-22															
R/L166.0FG-205D	—	3021010-060 (6.0)	5322 383-11												
R/L166.0FG-245E	—														
R/L166.0FG-4040-27	—														

1) For optional shims, see page C57.

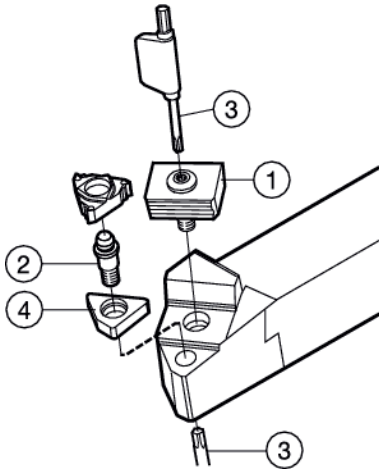
2) U-screw for insert clamping, optional part delivered to separate order

3) Key for U-screw

T-Max U-Lock® external

Shank tools/ Coromant Capto®

Wedge clamp design



To be used with CoroThread 266 inserts

		1	2	3	4	
					Shims ¹⁾ Inclination angle +1°	
Shank holder	Coromant Capto®	Wedge set	Center pin	Key (Torx Plus)	Right hand	Left hand
R/L166.5FA-083	C3-R/L166.5FA/FAZ17039-16	5431 126-011	5313 033-01	5680 051-03 (9IP)	5322 371-11	5322 372-11
R/L166.5FA-103	C3-R/L166.5FA/FAZ21055-16					
R/L166.5FA-123B	C3-R/L166.5FA/FAZ26065-16					
R/L166.5FA-163D	C3-R/L166.5FA/FAZ33075-16					
R/L166.5FA-203D						
R/L166.5FA-1212-16						
R/L166.5FA-1616-16						
R/L166.5FA-2020-16						
R/L166.5FA-2525-16						

T-Max U-Lock® internal

Shank tools

Bars/Coromant Capto®

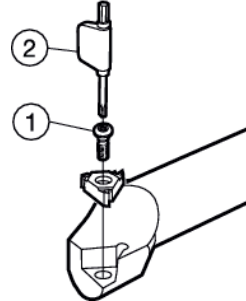
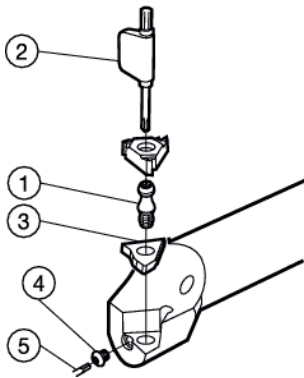
Screw clamping

QC-screw to be used for insert sizes 16 (*iC* 3/8) and 22 (*iC* 1/2)

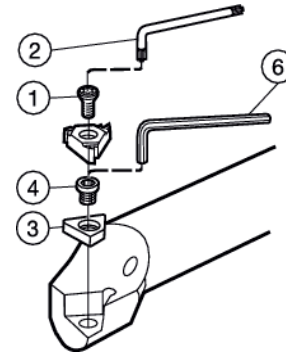
T-Max U screw to be used for insert size 11 (*iC* 1/4)

T-Max U screw to be used for insert size 27 (*iC* 5/8)

OBSOLETE TOOLS



OBSOLETE TOOLS



Shank tools	Coromant Capto®	1 Insert screw (thread)	2 ²⁾ Key (Torx Plus)	3 Key (Torx Plus)	4 Shims ¹⁾ Inclination angle +1° ²	5 Shim screw	6 Key (Torx Plus)	6 Key (size, mm)
R154.0KF-16-1220-11B		5513 020-03	(M2.5)	5680 051-02 (7IP)	-	-	-	-
R/L154.4KF-16-16		5513 026-05	(M4)	5680 051-03 (9IP)	-	-	-	-
R/L154.4KF-16F16		5513 020-02 ²⁾						
R/L154.4KF-20-22		5513 026-06	(M5)	5680 049-02 (15IP)	-	-	-	-
R/L154.4KF-20F22								
R/L166.0KF-D06C-2C	Cx-R/L166.0 KF/KFZ-12050-11	5513 020-03	(M2.5)	5680 051-02 (7IP)	-	-	-	-
R/L166.0KF-10E-11	Cx-R/L166.0 KF/KFZ-12060-11							
R/L166.0KF-D08C-2C								
R/L166.0KF-12E-11								
R/L166.0KF-D10-D0812-2B								
R/L166.0KF-D10-D1016-2B								
R/L166.0KF-16-1220-11B								
R/L166.0KF-16-1625-11B								
R/L166.4KF-D10-3	Cx-R/L166.4 KF/KFZ-12050-16	5513 026-05	(M4)	5680 051-03 (9IP)	-	-	-	-
R/L166.4KF-D10C-3C	Cx-R/L166.4 KF/KFZ-12060-16	5513 020-02 ²⁾						
R/L166.4KF-16-16								
R/L166.4KF-16E-16								
R/L166.4KF-16F16								
R/L166.4KF-D12-3	Cx-R/L166.4 KF/KFZ-14060-16	5513 026-03	(M4)	5680 051-03 (9IP)	5322 361-11	5512 032-01	5680 051-03 (9IP)	-
R/L166.4KF-D12C-3C	Cx-R/L166.4 KF/KFZ-14070-16	5513 020-25 ²⁾						
R/L166.4KF-20-16								
R/L166.4KF-20F16								
R/L166.4KF-D16-3	Cx-R/L166.4 KF/KFZ-17065-16	5513 026-01	(M4)	5680 051-03 (9IP)	5322 361-11	5512 032-01	5680 051-03 (9IP)	-
R/L166.4KF-25-16	Cx-R/L166.4 KF/KFZ-17070-16							
R/L166.4KF-D20-3	Cx-R/L166.4 KF/KFZ-17075-16							
R/L166.4KF-25F22	Cx-R/L166.4 KF/KFZ-22085-16	5513 020-13 ²⁾						
R/L166.4KF-D24-3	Cx-R/L166.4 KF/KFZ-22090-16							
R/L166.4KF-32-16								
R/L166.4KF-D32-3								
R/L166.4KF-40-16								
R/L166.4KF-50-16								
R/L166.4KF-20-22	Cx-R/L166.4 KF/KFZ-15060-22	5513 026-06	(M5)	5680 049-02 (15IP)	5322 351-11	5512 032-01	5680 051-03 (9IP)	-
R/L166.4KF-20F22	Cx-R/L166.4 KF/KFZ-15065-22	5513 020-07 ²⁾						
R/L166.4KF-25-22	Cx-R/L166.4 KF/KFZ-19065-22	5513 026-04	(M5)	5680 049-02 (15IP)	5322 365-11	5512 032-01	5680 049-02 (15IP)	-
R/L166.4KF-25F22	Cx-R/L166.4 KF/KFZ-19070-22	5513 020-26 ²⁾						
R/L166.4KF-25F22	Cx-R/L166.4 KF/KFZ-19075-22							
R/L166.4KF-D20-4	Cx-R/L166.4 KF/KFZ-22085-22	5513 026-02	(M5)	5680 049-02 (15IP)	5322 365-11	5512 032-01	5680 049-02 (15IP)	-
R/L166.4KF-32-22	Cx-R/L166.4 KF/KFZ-22090-22	5513 020-26 ²⁾						
R/L166.4KF-40-22	Cx-R/L166.4 KF/KFZ-27080-22							
R/L166.4KF-D24-4	Cx-R/L166.4 KF/KFZ-27105-22							
R/L166.4KF-50-22								
R/L166.4KF-D32-4								
R166.0KF-40-27		5513 020-14	(M5)	5680 043-15 (25IP)	5322 383-11	5512 090-08	-	3021 010-060

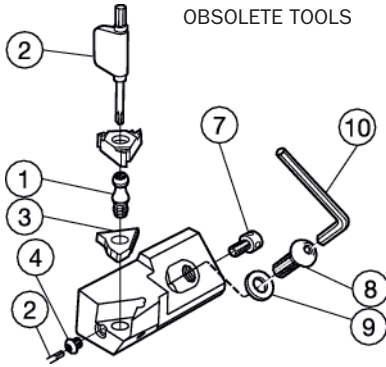
1) For optional shims, see page C57.

2) Optional part delivered to separate order.

Ordering example: 10 pieces 5513 020-03

T-Max U-Lock®**Cartridges****Screw clamping**

OBSOLETE TOOLS



	1	2	3	4	2
Cartridges	Insert screw (thread)	Key (size, Torx)	Shims ¹⁾ Inclination angle +1°	Shim screw	Key (Torx Plus)
R/L466.4KF-16CA-16	5513 026-01 (M4) 5513 020-13 ²⁾	5680 051-03 (9IP)	5322 361-11	5512 032-01	5680 049-03 (9IP)
R/L466.4KF-20CA-22	5513 026-02 (M5) 5513 020-26 ²⁾	5680 049-02 (15IP)	5322 365-11	5512 032-02	5680 049-02 (15IP)
	7	8	9	10	
Cartridges	Adjusting screw, axial	Mounting screw	Washer	Key (size, mm)	
R/L466.4KF-16CA-16	438.3-828	434.9-830	3411 011-084	174.1-863 (2.5)	
R/L466.4KF-20CA-22	438.3-839	434.9-827	3411 011-084	174.1-863 (2.5)	

1) For optional shims, see page C57.

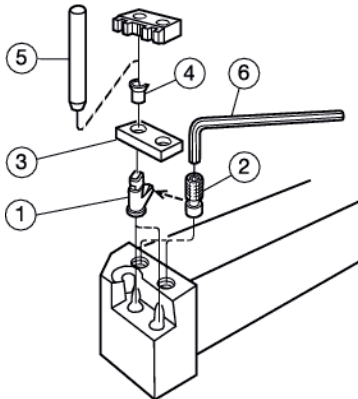
2) Optional part delivered to separate order.

Ordering example: 10 pieces 438.3-828

T-Max Twin-Lock®

Holders for oil pipe threading

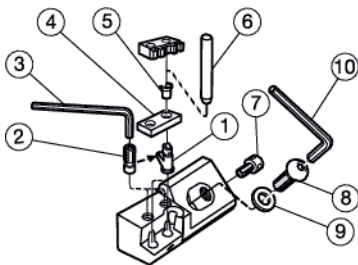
Shank tools



	1	2	3	4	5	6
Shank tool	Lever	Screw	Shim	Shim pin	Shim pin punch	Key (mm)
R166.39FG-3232-24	5432 005-01	174.3-820M	5321 110-02	174.3-860	174.3-870	170.3-860 (2.5)

Ordering example: 10 pieces 5432 005-01

Cartridges

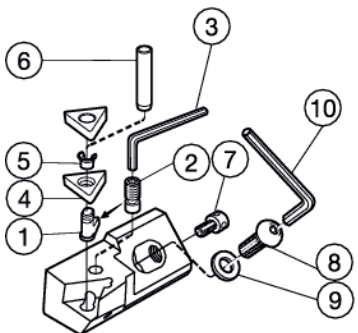


	1	2	3	4	5
Cartridge	Lever	Lever screw	Key (mm)	Shim	Shim pin
R466.39.KF-1832-24	5432 005-01	174.3-820M	170.3-860 (2.5)	5321 111-01	174.3-860

	6	7	8	9	10
	Shim pin punch	Adjusting screw, axial	Mounting screw	Washer	Key (size, mm)
	174.3-870	438.3-839	434.9-827	3411 011-084	174.1-863 (2.5)

Ordering example: 10 pieces 438.3-828

T-MAX P Cartridges



	1	2	3	4	5
T-MAX P Cartridges	Lever	Lever screw	Key (mm)	Shim (For insert thickness)	radius Inch (mm)
R466.3KW-2030-16	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M (1.87) 179.3-858M (1.87) ¹⁾	.016-.032 (0.4-0.8) .047-.063 (1.2 - 1.6) ¹⁾

	6	7	8	9	10
	Shim pin punch	Adjusting screw, axial	Mounting screw	Washer	Key (size, mm)
R466.3KW-2030-16	174.3-870	434.9-839	434.9-830	3411 011-084	174.1-863 (2.5)

¹⁾ For optional shims, see page C57.

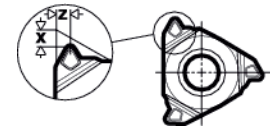
Ordering example: 10 pieces 438.3-828

A
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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	
x	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	
z	.052	.052	.052	.052	.052	.052	.052	.052	.052	.066	.066	.066	.054	.043	.035	
	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	
	.020	.020	.031	.031	.039	.047	.055	.055	.071	.098	.098	.098	.098	.098	.110	
No. of infeeds	Radial infeed per pass															
1	0.10	0.16	0.16	0.17	0.20	0.17	0.20	0.20	0.20	0.24	0.24	0.27	0.29	0.27	0.30	
	.004	.006	.006	.007	.008	.007	.008	.008	.008	.009	.009	.011	.011	.011	.012	
2	0.09	0.15	0.15	0.15	0.19	0.17	0.19	0.19	0.19	0.23	0.22	0.25	0.28	0.26	0.29	
	.004	.006	.006	.006	.007	.007	.007	.007	.007	.009	.009	.010	.011	.010	.011	
3	0.08	0.12	0.14	0.14	0.18	0.16	0.18	0.18	0.19	0.22	0.22	0.24	0.27	0.26	0.29	
	.003	.005	.006	.006	.007	.006	.007	.007	.007	.009	.009	.009	.011	.010	.011	
4	0.07	0.07	0.12	0.13	0.16	0.15	0.17	0.17	0.18	0.21	0.21	0.23	0.26	0.25	0.28	
	.003	.003	.005	.005	.006	.006	.007	.007	.007	.008	.008	.009	.010	.010	.011	
5			0.08	0.12	0.14	0.14	0.16	0.17	0.17	0.21	0.21	0.23	0.25	0.25	0.27	
			.003	.005	.006	.006	.006	.007	.007	.008	.008	.009	.010	.010	.011	
6				0.08	0.08	0.13	0.15	0.16	0.17	0.20	0.20	0.22	0.25	0.24	0.26	
				.003	.003	.005	.006	.006	.006	.008	.008	.009	.010	.009	.010	
7					0.11	0.13	0.15	0.16	0.18	0.19	0.21	0.24	0.23	0.26	0.26	
					.004	.005	.006	.006	.007	.007	.008	.009	.009	.009	.010	
8						0.08	0.08	0.14	0.15	0.17	0.18	0.20	0.23	0.23	0.25	
						.003	.003	.006	.006	.007	.007	.008	.009	.009	.010	
9								0.12	0.14	0.16	0.17	0.19	0.22	0.22	0.24	
								.005	.006	.006	.007	.007	.009	.009	.009	
10									0.08	0.13	0.15	0.16	0.18	0.20	0.21	0.23
									.003	.005	.006	.006	.007	.008	.008	.009
11										0.12	0.13	0.15	0.17	0.19	0.20	0.22
										.005	.005	.006	.007	.007	.008	.009
12										0.08	0.08	0.14	0.16	0.17	0.19	0.20
										.003	.003	.006	.006	.007	.007	.008
13												0.12	0.14	0.15	0.18	0.19
												.005	.006	.006	.007	.007
14												0.08	0.10	0.10	0.16	0.17
												.003	.004	.004	.006	.007
15															0.14	0.15
															.006	.006
16															0.10	0.10
															.004	.004
Total infeed	0.34	0.50	0.65	0.79	0.95	1.11	1.26	1.56	1.88	2.18	2.49	2.79	3.10	3.39	3.70	
	.013	.020	.026	.031	.037	.044	.050	.061	.077	.086	.098	.110	.122	.133	.145	

Dimensions x and z



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		
x	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		
z	.051	.051	.051	.051	.051	.051	.051	.051	.051	.065	.065	.065	.053	.042	.034		
	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		
	.020	.020	.031	.031	.039	.047	.055	.055	.071	.098	.098	.098	.098	.098	.094		
No. of infeeds	Radial infeed per pass																
1	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		
	.004	.006	.006	.006	.008	.006	.007	.007	.007	.009	.008	.009	.010	.010	.011		
2	0.09	0.14	0.14	0.15	0.18	0.15	0.18	0.18	0.18	0.21	0.21	0.23	0.26	0.25	0.27		
	.004	.005	.006	.006	.007	.006	.007	.007	.007	.008	.008	.009	.010	.010	.011		
3	0.08	0.12	0.13	0.14	0.17	0.15	0.17	0.17	0.18	0.20	0.20	0.22	0.25	0.24	0.26		
	.003	.005	.005	.006	.007	.006	.007	.007	.007	.008	.008	.009	.010	.010	.010		
4	0.07	0.07	0.12	0.13	0.15	0.14	0.16	0.17	0.17	0.20	0.19	0.22	0.24	0.24	0.26		
	.003	.003	.005	.005	.006	.006	.006	.007	.007	.008	.008	.009	.010	.009	.010		
5			0.08	0.11	0.13	0.13	0.15	0.16	0.16	0.19	0.19	0.21	0.24	0.23	0.25		
			.003	.005	.005	.005	.006	.006	.006	.007	.007	.008	.009	.009	.010		
6				0.08	0.08	0.12	0.14	0.15	0.16	0.18	0.18	0.20	0.23	0.22	0.24		
				.003	.003	.005	.005	.006	.006	.007	.007	.008	.009	.009	.010		
7					0.11	0.12	0.14	0.15	0.17	0.18	0.20	0.22	0.22	0.24	0.24		
					.004	.005	.006	.006	.007	.007	.008	.009	.009	.009	.009		
8						0.08	0.08	0.13	0.14	0.16	0.17	0.19	0.21	0.21	0.23		
						.003	.003	.005	.006	.006	.007	.007	.008	.008	.009		
9								0.12	0.14	0.15	0.16	0.18	0.20	0.20	0.22		
								.005	.005	.006	.006	.007	.008	.008	.009		
10									0.08	0.12	0.14	0.15	0.17	0.19	0.20	0.21	
									.003	.005	.005	.006	.007	.007	.008	.008	
11										0.11	0.12	0.14	0.16	0.18	0.19	0.20	
										.004	.005	.006	.006	.007	.007	.008	
12											0.08	0.08	0.13	0.15	0.16	0.18	0.19
										.003	.003	.005	.006	.006	.007	.007	.008
13												0.12	0.14	0.15	0.17	0.18	
												.005	.005	.006	.007	.007	
14												0.08	0.10	0.10	0.16	0.16	
												.003	.004	.004	.006	.006	
15															0.14	0.15	
															.005	.006	
16															0.10	0.10	
															.004	.004	
Total infeed	0.34	0.48	0.63	0.77	0.92	1.05	1.20	1.48	1.78	2.03	2.31	2.61	2.88	3.19	3.44		
	.013	.019	.025	.030	.036	.041	.047	.058	.070	.080	.091	.103	.113	.126	.135		

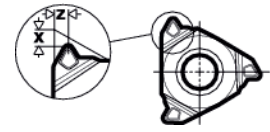
Total infeed = $a_p + 0.05$ mm (.002 inch)

A General Turning
 B Parting and Grooving
 C Threading
 G Tooling systems
 H Multi-task machining
 I CoroTurn® SL
 J General information

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
x	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
z	0.50	0.80	0.80	0.80	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	.104	.114
No. of infeeds	Radial infeed per pass																	
1	0.17	0.15	0.18	0.18	0.20	0.19	0.18	0.20	0.22	0.21	0.21	0.21	0.22	0.25	0.24	0.29	0.28	0.32
	.007	.006	.007	.007	.008	.007	.007	.008	.009	.008	.008	.008	.009	.010	.009	.012	.011	.013
2	0.16	0.14	0.16	0.17	0.18	0.18	0.18	0.19	0.21	0.20	0.20	0.20	0.21	0.24	0.23	0.29	0.28	0.32
	.006	.005	.006	.007	.007	.007	.007	.007	.008	.008	.008	.008	.008	.009	.009	.011	.011	.012
3	0.13	0.13	0.15	0.15	0.17	0.17	0.17	0.18	0.20	0.19	0.19	0.19	0.20	0.23	0.23	0.28	0.27	0.31
	.005	.005	.006	.006	.007	.007	.007	.007	.008	.008	.008	.008	.008	.009	.009	.011	.011	.012
4	0.08	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.19	0.18	0.18	0.19	0.20	0.22	0.22	0.27	0.26	0.30
	.003	.004	.005	.006	.006	.006	.006	.007	.007	.007	.007	.007	.008	.009	.009	.011	.010	.012
5	0.08	0.08	0.12	0.13	0.14	0.15	0.16	0.17	0.17	0.17	0.18	0.19	0.21	0.21	0.26	0.26	0.29	0.32
	.003	.003	.005	.005	.006	.006	.006	.007	.007	.007	.007	.007	.008	.008	.010	.010	.011	.012
6			0.08	0.08	0.12	0.14	0.14	0.15	0.16	0.16	0.17	0.18	0.20	0.21	0.25	0.25	0.28	0.32
			.003	.003	.005	.005	.006	.006	.006	.006	.007	.007	.008	.008	.010	.010	.011	.012
7			0.08	0.12	0.13	0.15	0.15	0.16	0.17	0.19	0.20	0.24	0.24	0.27	0.27	0.32	0.32	0.32
			.003	.005	.005	.005	.006	.006	.006	.007	.008	.008	.010	.010	.011	.011	.012	.012
8			0.08	0.08	0.13	0.14	0.15	0.16	0.18	0.19	0.23	0.23	0.26	0.26	0.32	0.32	0.32	0.32
			.003	.003	.003	.005	.006	.006	.006	.007	.008	.009	.009	.010	.010	.011	.011	.012
9				0.08	0.12	0.14	0.15	0.17	0.18	0.22	0.22	0.25	0.25	0.32	0.32	0.32	0.32	0.32
				.003	.005	.005	.006	.007	.007	.007	.009	.009	.010	.010	.011	.011	.012	.012
10					0.08	0.12	0.14	0.15	0.18	0.21	0.22	0.24	0.24	0.32	0.32	0.32	0.32	0.32
					.003	.005	.005	.006	.007	.008	.008	.010	.010	.011	.011	.012	.012	.012
11						0.08	0.12	0.13	0.17	0.19	0.21	0.23	0.23	0.32	0.32	0.32	0.32	0.32
						.003	.005	.005	.007	.008	.008	.010	.010	.011	.011	.012	.012	.012
12							0.08	0.08	0.15	0.18	0.19	0.22	0.22	0.32	0.32	0.32	0.32	0.32
							.003	.003	.006	.007	.008	.008	.010	.010	.011	.011	.012	.012
13									0.14	0.15	0.18	0.20	0.20	0.32	0.32	0.32	0.32	0.32
									.005	.006	.007	.008	.008	.010	.010	.011	.011	.012
14										0.10	0.10	0.17	0.18	0.18	0.20	0.20	0.20	0.20
										.004	.004	.007	.007	.008	.008	.008	.008	.008
15											0.15	0.16	0.16	0.16	0.16	0.16	0.16	0.16
											.006	.006	.006	.006	.006	.006	.006	.006
16												0.10	0.10	0.10	0.10	0.10	0.10	0.10
												.004	.004	.004	.004	.004	.004	.004
Total infeed	0.54	0.60	0.70	0.84	0.92	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

Dimensions x and z



mm
inch

ISO inch (UN), internal

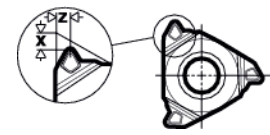
	Pitch, TPI																	
	32	28	24	20	18	16	14	13	12	11	10	9	8	7	6	5	4.5	4
x	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.64	1.64	1.35	1.06	0.87
z	0.50	0.80	0.80	0.80	1.00	1.00	1.20	1.40	1.40	1.40	1.40	1.80	1.80	2.50	2.50	2.50	2.50	2.60
	.020	.031	.031	.031	.039	.039	.047	.055	.055	.055	.055	.071	.071	.098	.098	.098	.098	.102
No. of infeeds	Radial infeed per pass																	
1	0.16	0.14	0.16	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
	.006	.005	.006	.004	.006	.006	.006	.008	.006	.007	.007	.007	.009	.008	.009	.010	.010	.011
2	0.14	0.13	0.15	0.09	0.14	0.14	0.15	0.18	0.15	0.18	0.18	0.18	0.21	0.21	0.23	0.26	0.25	0.27
	.006	.005	.006	.004	.005	.006	.006	.007	.006	.007	.007	.007	.008	.008	.009	.010	.010	.011
3	0.13	0.12	0.14	0.08	0.12	0.13	0.14	0.17	0.15	0.17	0.17	0.18	0.20	0.20	0.22	0.25	0.24	0.26
	.005	.005	.006	.003	.005	.005	.006	.007	.006	.007	.007	.007	.008	.008	.009	.010	.010	.010
4	0.08	0.11	0.12	0.07	0.07	0.12	0.13	0.15	0.14	0.16	0.17	0.17	0.20	0.19	0.22	0.24	0.24	0.26
	.003	.004	.005	.003	.003	.005	.005	.006	.006	.006	.007	.007	.008	.008	.009	.010	.009	.010
5		0.08	0.08			0.08	0.11	0.13	0.13	0.15	0.16	0.16	0.19	0.19	0.21	0.24	0.23	0.25
		.003	.003			.003	.005	.005	.005	.006	.006	.006	.007	.007	.008	.009	.009	.010
6							0.08	0.08	0.12	0.14	0.15	0.16	0.18	0.18	0.20	0.23	0.22	0.24
							.003	.003	.005	.005	.006	.006	.007	.007	.008	.009	.009	.010
7									0.11	0.12	0.14	0.15	0.17	0.18	0.20	0.22	0.22	0.24
									.004	.005	.006	.006	.007	.007	.008	.009	.009	.009
8									0.08	0.08	0.13	0.14	0.16	0.17	0.19	0.21	0.21	0.23
									.003	.003	.005	.006	.006	.007	.008	.008	.008	.009
9										0.12	0.14	0.15	0.16	0.18	0.20	0.20	0.22	0.22
										.005	.005	.006	.006	.007	.008	.008	.009	.009
10											0.08	0.12	0.14	0.15	0.17	0.19	0.20	0.21
											.003	.005	.005	.006	.007	.007	.008	.008
11												0.11	0.12	0.14	0.16	0.18	0.19	0.20
												.004	.005	.006	.006	.007	.007	.008
12													0.08	0.08	0.13	0.15	0.16	0.18
													.003	.003	.005	.006	.006	.007
13															0.12	0.14	0.15	0.17
															.005	.005	.006	.007
14																0.08	0.10	0.16
																.003	.004	.006
15																	0.14	0.15
																	.005	.006
16																		0.10
																	.004	.004
Total infeed	0.51	0.58	0.66	0.34	0.48	0.63	0.77	0.92	1.05	1.20	1.48	1.78	2.03	2.31	2.61	2.88	3.19	3.44
	.020	.023	.026	.013	.019	.025	.030	.036	.041	.047	.058	.070	.080	.091	.103	.113	.126	.135

Total infeed = $a_p + 0.05$ 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	X	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	
	Z	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.066	.066	.054	.039	.023	
Internal	X	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	2.65	2.75	
	Z	.031	.031	.031	.031	.039	.039	.055	.055	.055	.055	.071	.071	.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
2		.006	.007	.007	.008	.007	.007	.008	.009	.009	.009	.009	.010	.010	.012	.012	.013	
3		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
4		.006	.006	.007	.007	.006	.006	.007	.009	.008	.008	.008	.008	.009	.010	.012	.012	.013
5		0.14	0.14	0.16	0.17	0.16	0.16	0.18	0.21	0.20	0.20	0.20	0.21	0.25	0.24	0.29	0.29	0.32
6		.005	.006	.006	.007	.006	.006	.007	.008	.008	.008	.008	.008	.010	.009	.012	.011	.013
7		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
8		.005	.005	.006	.006	.006	.006	.007	.008	.008	.008	.008	.008	.009	.009	.011	.011	.012
9		0.08	0.08	0.13	0.13	0.13	0.14	0.16	0.18	0.18	0.18	0.18	0.19	0.20	0.23	0.23	0.28	0.30
10		.003	.003	.005	.005	.005	.006	.007	.007	.007	.007	.007	.008	.009	.009	.011	.011	.012
11				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
12				.003	.003	.005	.005	.006	.006	.007	.007	.007	.008	.008	.010	.010	.011	
13						0.08	0.08	0.08	0.13	0.15	0.16	0.17	0.18	0.19	0.20	0.24	0.25	0.27
14						.003	.003	.003	.005	.006	.006	.007	.007	.008	.008	.010	.010	.011
15									0.08	0.13	0.14	0.16	0.18	0.19	0.23	0.24	0.26	
16									.003	.005	.006	.006	.007	.008	.009	.009	.010	
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

Dimensions x and z



mm
inch

BSPT (PT), external and internal

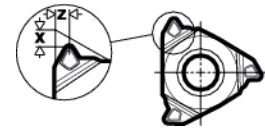
		Pitch, TPI				
		28	19	14	11	8
External	X	1.32	1.32	1.32	1.32	1.32
	Z	.052	.052	.052	.052	.052
Internal	X	0.80	0.80	1.20	1.40	1.80
	Z	.031	.031	.047	.055	.071
No. of infeeds		Radial infeed per pass				
1		0.15	0.19	0.19	0.22	0.22
2		.006	.008	.007	.009	.009
3		0.14	0.18	0.18	0.21	0.21
4		.006	.007	.007	.008	.008
5		0.13	0.17	0.17	0.20	0.21
6		.005	.007	.007	.008	.008
7		0.12	0.15	0.16	0.19	0.20
8		.005	.006	.006	.007	.008
9		0.08	0.13	0.15	0.18	0.19
10		.003	.005	.006	.007	.008
11			0.08	0.14	0.16	0.18
12			.003	.005	.006	.007
13				0.12	0.15	0.17
14				.005	.006	.007
15				0.08	0.13	0.16
16				.003	.005	.006
17					0.14	0.14
18					.006	.006
19					0.12	0.12
20					.005	.005
21					0.08	0.08
22					.003	.003
Total infeed		0.62	0.90	1.20	1.51	2.05
		.024	.035	.047	.059	.081

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

Round 30° Din405 (RN) external

	Pitch, TPI			
	10	8	6	4
	x	1.33 .052	1.33 .052	1.43 .056
z	0.83 .034	1.05 .041	1.50 .059	2.60 .102
No. of infeeds	Radial infeed per pass			
1	0.21 .008	0.21 .008	0.24 .009	0.30 .012
2	0.20 .008	0.20 .008	0.23 .009	0.29 .011
3	0.19 .007	0.19 .008	0.22 .009	0.28 .011
4	0.18 .007	0.19 .007	0.21 .008	0.27 .011
5	0.16 .006	0.18 .007	0.20 .008	0.26 .010
6	0.15 .006	0.17 .007	0.19 .008	0.25 .010
7	0.13 .005	0.15 .006	0.18 .007	0.24 .010
8	0.08 .003	0.14 .006	0.17 .007	0.23 .009
9		0.12 .005	0.16 .006	0.22 .009
10		0.08 .003	0.15 .006	0.21 .008
11			0.13 .005	0.19 .008
12			0.08 .003	0.18 .007
13				0.15 .006
14				0.10 .004
Total infeed	1.30 .051	1.63 .064	2.17 .085	2.95 .116

Dimensions x and z



□ mm
□ inch

Round 30° Din405 (RN) internal

	Pitch, TPI			
	10	8	6	4
	x	1.30 .051	1.30 .051	1.45 .053
z	1.85 .073	1.05 .041	1.35 .053	2.60 .102
No. of infeeds	Radial infeed per pass			
1	0.22 .009	0.21 .008	0.24 .009	0.30 .012
2	0.21 .008	0.20 .008	0.23 .009	0.29 .011
3	0.20 .008	0.20 .008	0.22 .009	0.29 .011
4	0.18 .007	0.19 .007	0.21 .008	0.28 .011
5	0.17 .007	0.18 .007	0.21 .008	0.27 .011
6	0.15 .006	0.17 .007	0.20 .008	0.26 .010
7	0.13 .005	0.16 .006	0.19 .007	0.25 .010
8	0.08 .003	0.14 .006	0.17 .007	0.24 .009
9		0.12 .005	0.16 .006	0.23 .009
10		0.08 .003	0.15 .006	0.21 .008
11			0.13 .005	0.20 .008
12			0.08 .003	0.18 .007
13				0.16 .006
14				0.10 .004
Total infeed	1.34 .053	1.64 .065	2.18 .086	2.98 .117

NPT (NT), external and internal

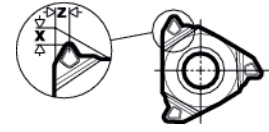
	Pitch, TPI				
	27	18	14	11½	8
	External	1.03 .041	1.03 .041	1.03 .041	1.03 .041
Internal	0.80 .031	1.00 .039	1.20 .047	1.40 .055	1.60 .063
	0.72 .028	1.01 .040	1.01 .040	1.01 .040	1.01 .040
z	0.85 .033	1.20 .047	1.20 .047	1.40 .055	1.60 .063
No. of infeeds	Radial infeed per pass				
1	0.15 .006	0.17 .007	0.18 .007	0.18 .007	0.21 .008
2	0.15 .006	0.17 .007	0.17 .007	0.17 .007	0.21 .008
3	0.14 .005	0.16 .006	0.16 .006	0.17 .007	0.20 .008
4	0.13 .005	0.15 .006	0.16 .006	0.16 .006	0.20 .008
5	0.11 .004	0.14 .006	0.15 .006	0.16 .006	0.19 .008
6	0.08 .003	0.13 .005	0.14 .006	0.15 .006	0.18 .007
7		0.11 .005	0.14 .006	0.15 .006	0.18 .007
8		0.08 .003	0.13 .005	0.14 .006	0.17 .007
9			0.11 .004	0.13 .005	0.17 .007
10			0.08 .003	0.12 .005	0.16 .006
11				0.11 .004	0.15 .006
12				0.08 .003	0.14 .006
13					0.13 .005
14					0.11 .005
15					0.08 .003
Total infeed	0.76 .030	1.11 .044	1.42 .056	1.73 .068	2.48 .098

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

ACME (AC), external

	Pitch, TPI									
	16	14	12	10	8	6	5	4	3	
	x	1.33	1.33	1.33	1.33	1.50	1.37	1.37	0.76	0.54
	.052	.052	.052	.052	.059	.054	.054	.030	.021	
z	1.00	1.10	1.20	1.30	1.50	1.90	2.10	2.40	3.30	
	.039	.043	.047	.051	.059	.075	.083	.094	.130	
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	

Dimensions x and z



mm
inch

ACME (AC), internal

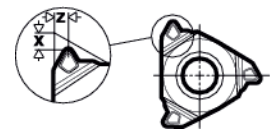
	Pitch, TPI									
	16	14	12	10	8	6	5	4	3	
	x	1.30	1.30	1.33	1.33	1.14	1.33	0.92	0.81	0.54
	.051	.051	.054	.054	.050	.052	.036	.032	.021	
z	0.80	1.00	1.10	1.20	1.50	2.00	2.20	2.40	3.30	
	.031	.039	.039	.043	.063	.079	.087	.094	.130	
No. of infeeds	Radial infeed per pass									
1	0.22	0.21	0.21	0.21	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 = $a_p + 0.05$ mm (.002 inch)

Stub-ACME (SA), external and internal

		Pitch, TPI								
		16	14	12	10	8	6	5	4	3
External	X	1.32	1.32	1.32	1.32	1.23	1.67	1.67	1.67	1.76
	Z	.052	.052	.052	.052	.048	.066	.066	.066	.069
Internal	X	0.90	1.00	1.10	1.20	1.50	1.80	2.00	2.40	3.10
	Z	.035	.029	.043	.047	.059	.071	.079	.094	.122
		1.64	1.33	1.30	1.20	1.64	1.64	1.64	1.64	1.76
		.065	.052	.051	.047	.065	.065	.065	.065	.069
		2.40	1.10	1.20	1.50	1.80	2.00	2.40	2.40	3.10
		.095	.043	.047	.059	.071	.079	.094	.094	.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	0.21
				.003	.005	.006	.007	.007	.008	.008
8					0.08	0.14	0.16	0.18	0.20	0.20
					.003	.005	.006	.007	.008	
9						0.08	0.14	0.17	0.19	0.19
						.003	.006	.007	.008	
10							0.09	0.16	0.18	0.18
							.004	.006	.007	
11								0.14	0.17	0.17
								.005	.007	
12								0.09	0.16	0.16
								.004	.006	
13									0.15	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

Dimensions x and z



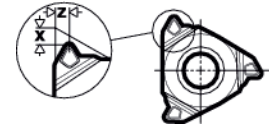
mm
inch

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

Trapezoidal (TR), external and internal

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

Dimensions x and z



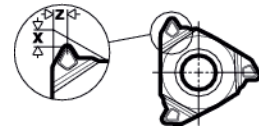
□ mm
□ inch

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

UNJ, external

		Pitch, TPI									
		32	28	24	20	18	16	14	12	10	8
X		1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32
		.052	.052	.052	.052	.052	.052	.052	.052	.052	.052
Z		0.50	0.80	0.80	0.80	1.00	1.00	1.20	1.40	1.40	1.80
		.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

Dimensions x and z



mm
inch

NPTF (NT), external and internal

		Pitch, TPI				
		27	18	14	11½	8
External	X	1.03	1.03	1.03	1.03	1.03
		.041	.041	.041	.041	.041
Internal	Z	0.80	1.00	1.20	1.40	1.60
		.031	.039	.047	.055	.063
Internal	X			1.01	1.01	1.01
				.040	.040	.040
Internal	Z			1.20	1.40	1.60
				.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	0.17
			.004	.005	.006	.007
8			0.08	0.12	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

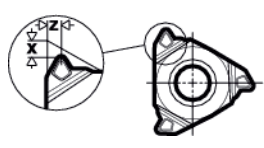
		Pitch, mm	
		1.5	2
X		1.32	1.32
		.052	.052
Z		1.00	1.40
		.039	.055
No. of infeeds		Radial infeed per pass	
1		0.20	0.19
		.008	.008
2		0.18	0.18
		.007	.007
3		0.17	0.17
		.007	.007
4		0.15	0.16
		.006	.006
5		0.13	0.15
		.005	.006
6		0.08	0.14
		.003	.006
7			0.12
			.005
8			0.08
			.003
Total infeed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

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

API thread forms

Insert	Pitch, TPI	x	z	No. of infeeds															Total infeed
				Radial infeed per pass															
				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	
API 60° V-0.038R																			
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 .012	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 .012	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	2.5 .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 .009	0.20 .008	0.18 .007	0.15 .006	0.08 .003	3.74 .147
266RL-22V501A0402E	4	0.87 .031	2.5 .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 .009	0.20 .008	0.18 .007	0.15 .006	0.08 .003	3.74 .147
266RG-22V501A0403E	4	0.88 .035	2.5 .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 .009	0.20 .008	0.18 .007	0.15 .006	0.08 .003	3.73 .147
266RL-22V501A0403E	4	0.87 .031	2.5 .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 .009	0.20 .008	0.18 .007	0.15 .006	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 .006	0.13 .005	0.11 .005	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 .006	0.13 .005	0.11 .005	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

Dimensions x and z



mm
inch

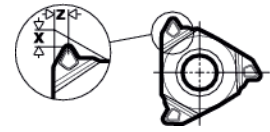
Total infeed = $a_p + 0.05$ mm (.002 inch)



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
x	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
	.064	.056	.075	.078	.110	.084	.060	.071	.076	.080	.068	.074	.066
z	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
External													
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			Pitch, TPI
	1.00	1.50	2.00	2.50	3.00	18	16	14	12	19	14	11	11 ½
	x	1.63	1.41	1.82	1.98	2.79				1.92		1.72	1.85
	.064	.056	.072	.078	.110				.076		.068	.073	.065
z	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

Dimensions x and z



mm
inch

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

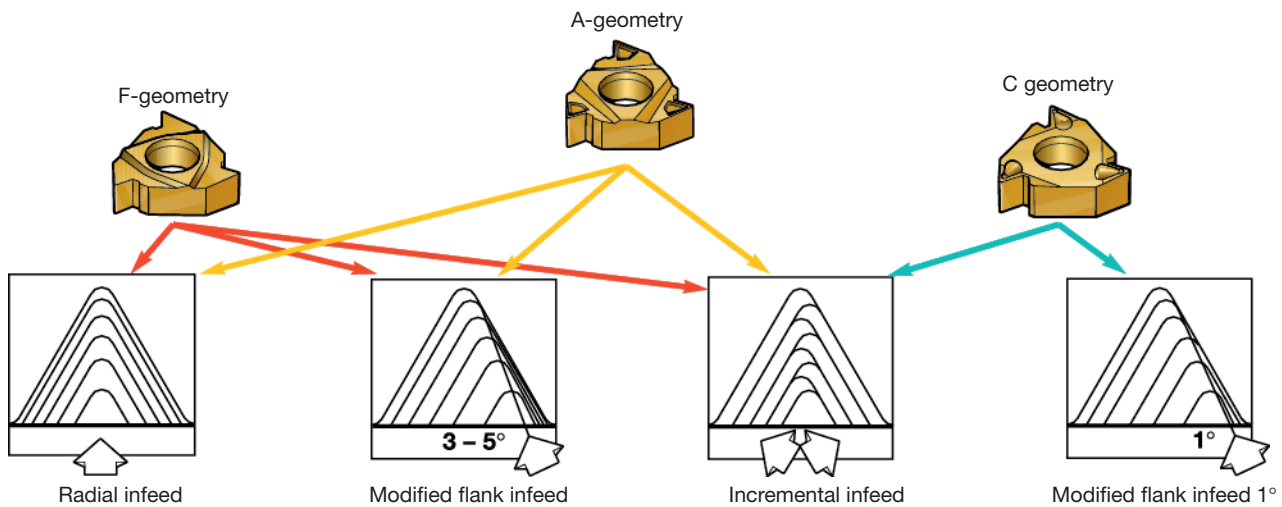
A
General Turning
B
Parting and Grooving
C
Threading
G
Tooling systems
H
Multi-task machining
I
CoroTurn® SL
J
General information

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 passes will be required.

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

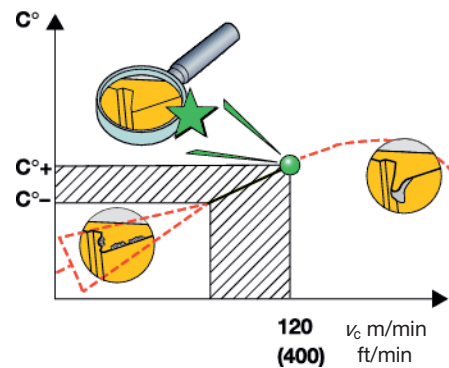
- When using grade CB20 the max infeed value should be .003 inch (0.07 mm).
- For C-geometry inserts, spring pass (a pass without infeed) should not be used.
- For Multi-point inserts it is essential that the recommendations on page C79 are used.
- The recommended number of passes for full form inserts can also be used for V-profile inserts.



Cutting speed

Starting cutting speed recommendations are given on page C82. Careful observation on the cutting edge can help you to achieve the best possible threading results.

- Cutting speed too low - Built-up edge
- Cutting speed too high - Plastic deformation of the edge



Formula

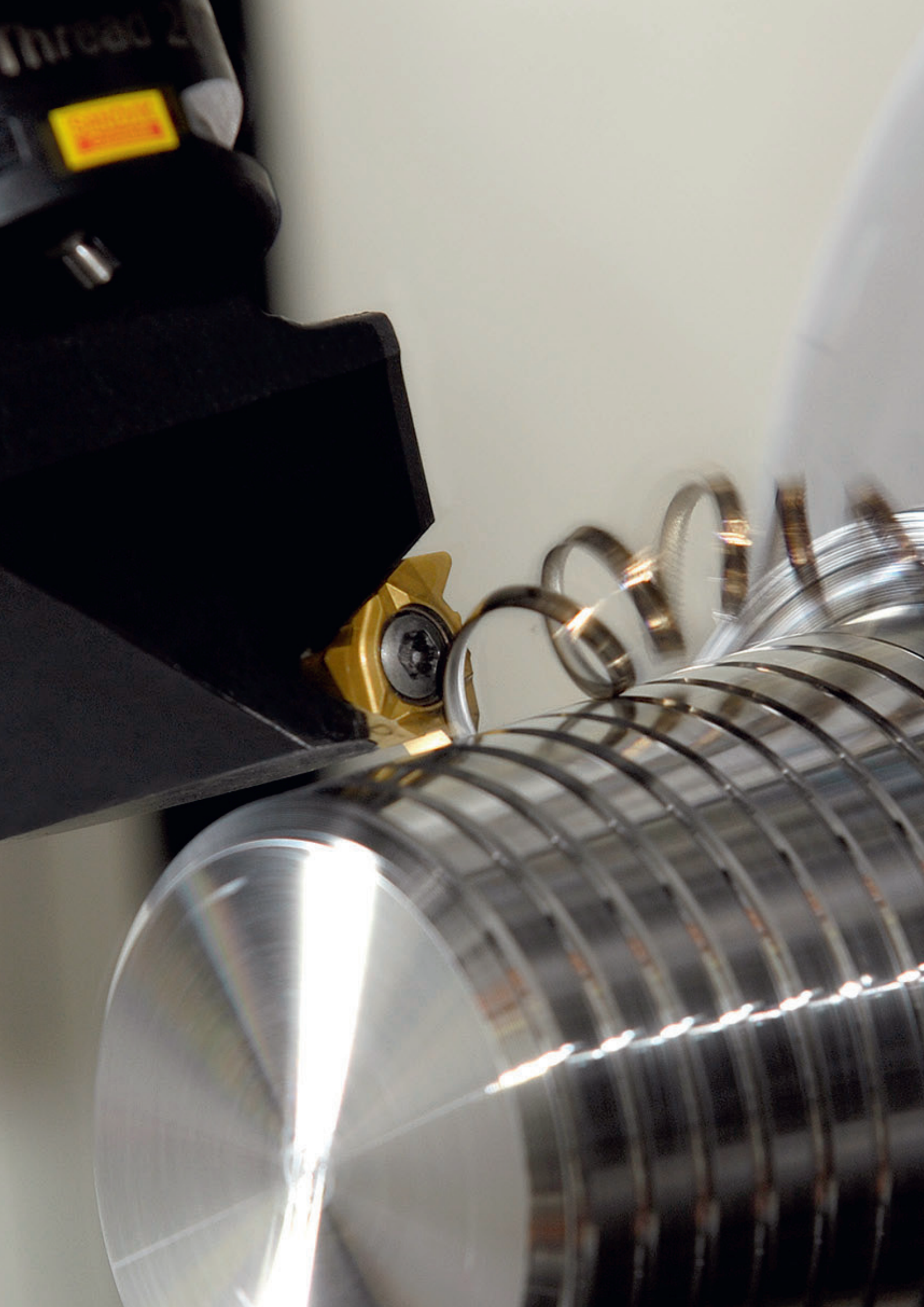
Formula to calculate infeed for each pass in a reduced series.

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

- Δ_{ap} Radial infeed
- x Actual pass (in a series from 1 to nap)
- a_p Total depth of thread. See page C70.
- nap Number of infeeds. See page C70.
- ϕ 1st pass = 0.3
2nd pass = 1
3rd and higher passes = $x - 1$



For technical information, see our Metal Cutting Technical Guide.



Cutting speed recommendations, metric values

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

Cutting speed recommendations, metric values

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

Cutting speed recommendations, inch values

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

Cutting speed recommendations, inch values

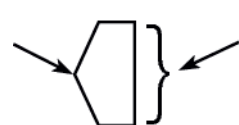
ISO N									
MC No.	CMC No.	Material	Hardness Brinell HB	Grades					
				GC1125	GC1135	GC1020	H13A	CB7015	
				Cutting speed (V _c) ft/min					
N1.2.Z.UT	30.11	Aluminum alloys Wrought/wrought and + cold-worked, non-aging	60	1650	1650	1650	1650		
N1.2.Z.AG	30.12		Aged	100	1650	1650	1650	1450	
N1.3.C.UT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

Grades for threading

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

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

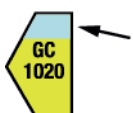
Center of the field of application.



Recommended field of application.

▲ Wear resistance

▼ Toughness



Additional coverage due to the F-geometry

Grades for threading

P Steel, cast steel, long chipping malleable iron

GC1020 (HC) – P20 (P10-P40)

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

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

GC1020 (HC) – M20 (M10-M30)

Good all-purpose 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 all-purpose 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 ISO-M materials and toughness-demanding threading operations.

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

GC1020 (HC) – K15 (K01-K20)

Good PVD coated 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 all-purpose PVD-coated grade with good wear resistance and very good edge line toughness for toughness-demanding threading operations in ISO-K materials.

N Non-ferrous metals

GC1020 (HC) – N25 (N10-N30)

Good all-purpose 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.

S Heat resistant 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 all-purpose PVD-coated carbide grade for toughness-demanding super alloy threading. To be used at low cutting speeds. First choice in ISO-S materials.

H Hardened materials

GC1020 (HC) – H20 (H05-H30)

Good all-purpose 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 aluminum oxide (Al₂O₃).

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

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄).

CC Ceramics as above, but coated.

Cubic boron nitride:

BN Cubic boron nitride

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