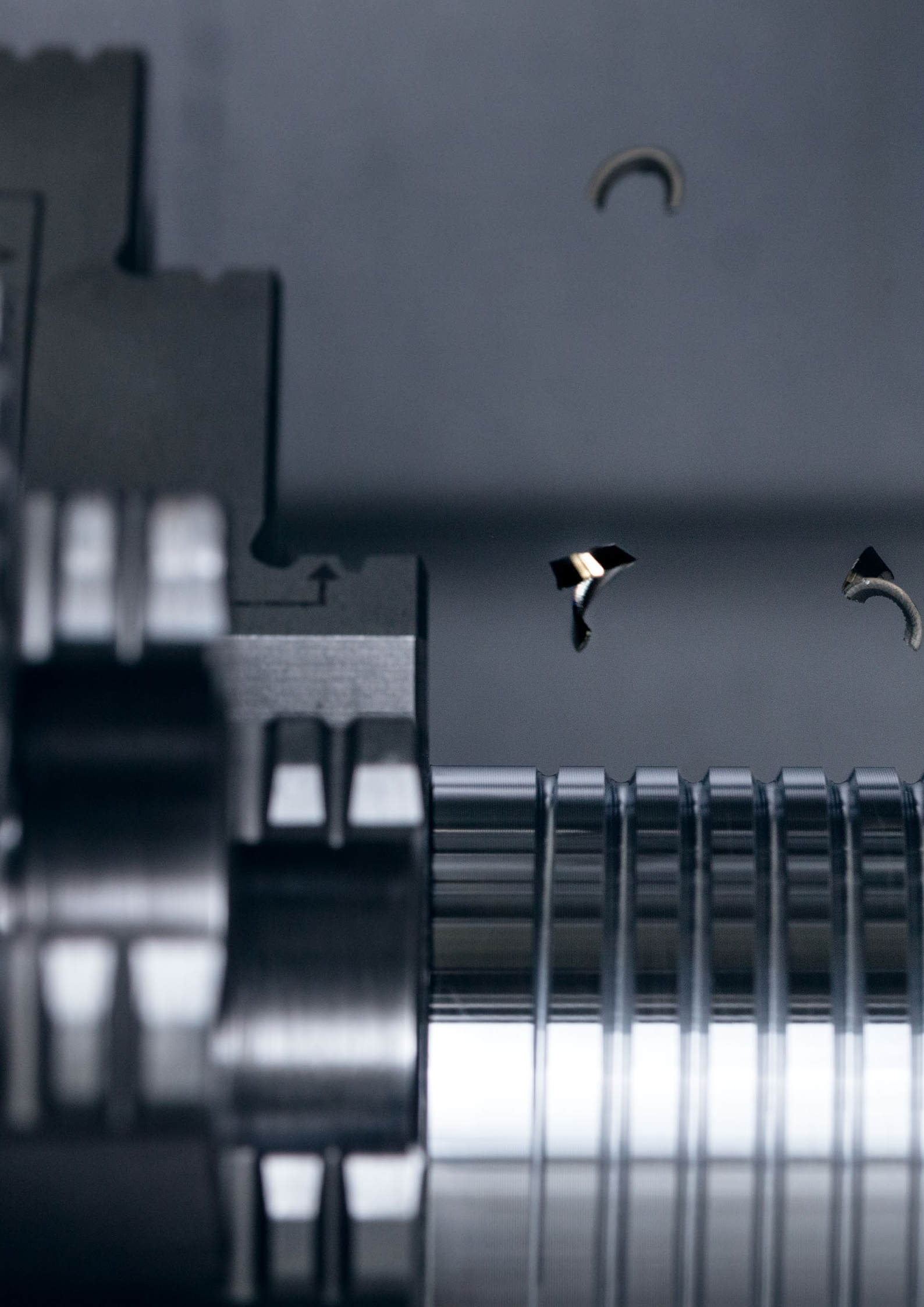
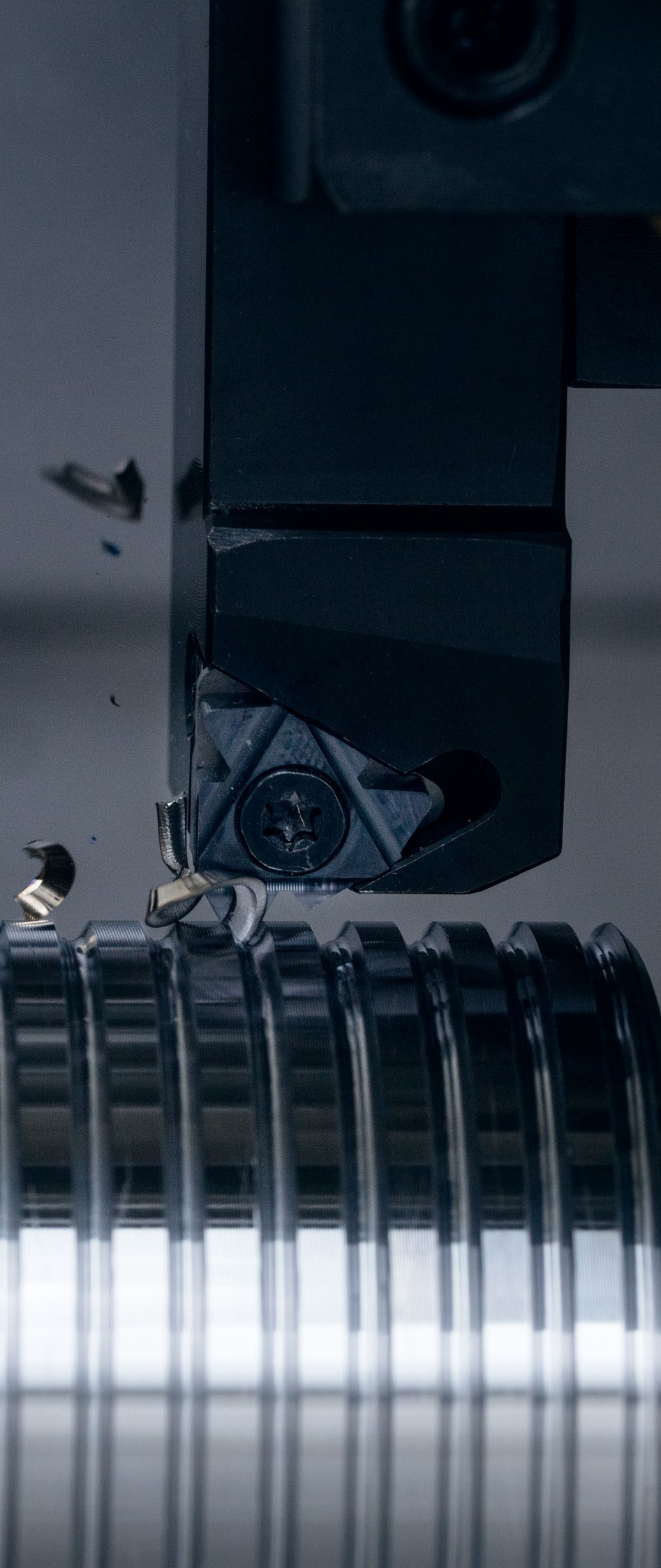






Solid drilling and bore machining

1 HSS drilling

2 Solid carbide drilling

3 Indexable insert drilling

4 Reaming and Countersinking

5 Spindle Tooling

Threading

6 Taps and thread formers

7 Circular and Thread Milling

8 Thread turning

8

Turning

9 Turning Tools

10 EcoCut

11 Grooving Tools

12 Miniature turning tools

Milling

13 HSS Milling Cutters

14 Solid Carbide milling cutters

15 Milling tools with
indexable inserts

Tool Clamping

16 Adapters

17 Accessories

18 Material examples and
article no. index

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Product programme	4-38
Shims	39
Technical Information	
Pitch angle	40
Cutting Data	41+42
Thread turning methods	43
Troubleshooting	44
WNT Designation Key	45
Grade description and profile explanation	46

WNT \ Performance

Premium quality tools for high performance.

The premium quality tools from the **WNT Performance** product line have been designed for specific applications and are distinguished by their outstanding performance. If you make high demands on the performance of your production and want to achieve the very best results, we recommend the Premium tools in this product line.

Toolfinder

TC threading system (external thread)

M	BSW
Full profile Partial profile	Full profile Partial profile

→ Chapter 11 – Grooving tools

TC threading system (internal thread)

M	BSW
Full profile Partial profile	Full profile Partial profile

→ Chapter 11 – Grooving tools

MiniCut

M	G	Tr
Full profile Partial profile	Partial profile	Partial profile

→ Chapter 12 – Miniature turning tools

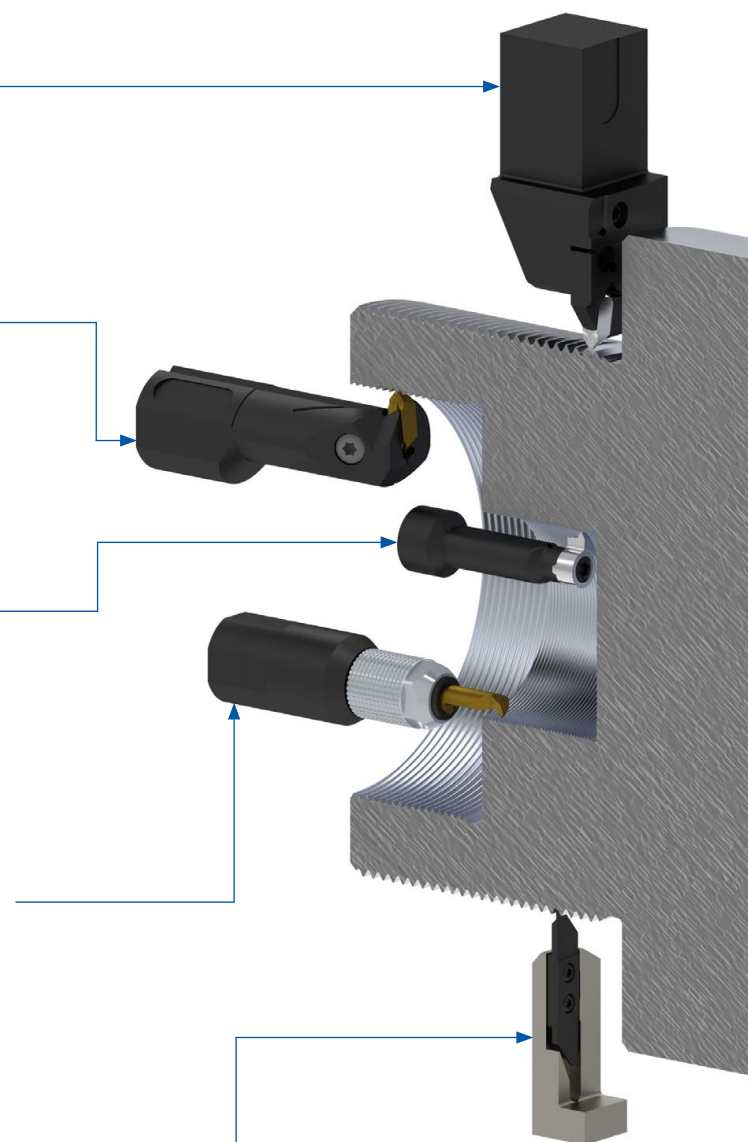
UltraMini

M	MF	G	Tr
Full profile Partial profile	Full profile Partial profile	Partial profile	Partial profile

→ Chapter 12 – Miniature turning tools

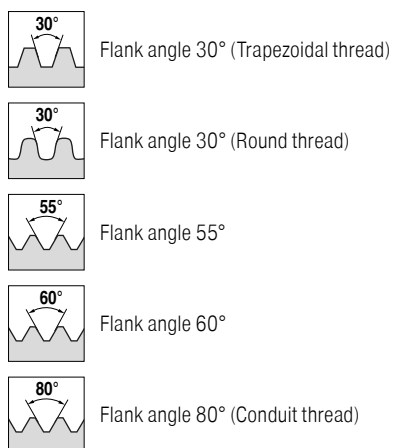
VertiClamp/System 25

→ Sliding head tooling catalogue, Chapter 3 – Turning



Symbol explanation

Flank angle

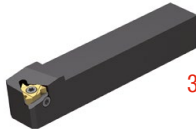


- = Main Application
- = Extended application

Threading

M	ISO metric coarse thread DIN 13	UNF	American unified thread (fine) BS 1580 (ASME B 1.1)
MF	ISO Metric fine thread DIN 13	UNEF	American unified thread (extra fine) BS 1580 (ASME B 1.1)
MJ	Metric thread for the aerospace industry DIN ISO 5855	NPT	American pipe thread ANSI/ASME B 1.20.3
BSW	British Whitworth thread BS 84	Tr	Trapezoidal thread DIN 103
UN	American unified thread BS 1580 (ASME B 1.1)	Rd	Round Thread DIN 405
UNC	American unified thread (coarse) BS 1580 (ASME B 1.1)	Pg	Conduit Threads DIN 40430

Standard external thread turning

Full profile										
M	MJ	BSW	UN	UNC	UNF	UNEF	NPT	Tr	Rd	Pg
4+5	9	11+12	15+16	15+16	15+16	15+16	19	21	23	25
Partial profile										
60°	55°									
27	29									
Multi-cutting edge										
M										
8										
Suitable holder										
 31										

Standard internal thread turning

Full profile										
M	MJ	BSW	UN	UNC	UNF	UNEF	NPT	Tr	Rd	Pg
6+7	10	13+14	17+18	17+18	17+18	17+18	20	22	24	26
Partial profile										
60°	55°									
28	30									
Suitable holder										
 32+33										

Mini 06

Full profile	
M	BSW
34	34
Partial profile	
60°	55°
35	35

Mini 08

Full profile	
M	
36	
Partial profile	
60°	55°
36	37

Suitable holder

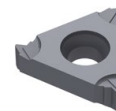
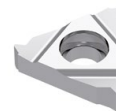
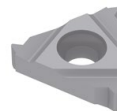
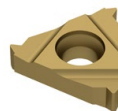
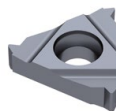
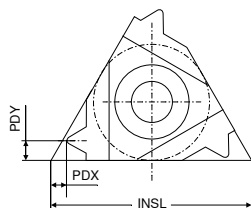


i Information on the different thread profiles can be found on → **Page 46.**

Right hand external thread turning insert

▲ Full profile

▲ CCN7525 grade with sintered chip breaker for universal application



Designation	TP	INSL	PDX	PDY	ER X3		ER X3		ER X3		ER Y1		ER X3	
					Article no.		Article no.		Article no.		Article no.		Article no.	
					71 220 ...		71 220 ...		71 220 ...		71 220 ...		71 220 ...	
	mm	mm	mm	mm	EUR		EUR		EUR		EUR		EUR	
11 ER 0,35	0,35	11	0,8	0,4	18,05	204					11,78	604		
11 ER 0,4	0,40	11	0,7	0,4	18,05	206					11,78	606		
11 ER 0,45	0,45	11	0,7	0,4	18,05	208					11,78	608		
11 ER 0,5	0,50	11	0,6	0,6	18,05	209					11,78	609		
11 ER 0,6	0,60	11	0,6	0,6	18,05	210					11,78	610		
11 ER 0,7	0,70	11	0,6	0,6	18,05	211					11,78	611		
11 ER 0,75	0,75	11	0,6	0,6	18,05	212					11,78	612		
11 ER 0,8	0,80	11	0,6	0,6	18,05	213					11,78	613		
11 ER 1,0	1,00	11	0,7	0,7	16,87	214					10,63	614		
11 ER 1,25	1,25	11	0,8	0,9	16,87	216					10,63	616		
11 ER 1,5	1,50	11	0,8	1,0	16,87	218					10,63	618		
11 ER 1,75	1,75	11	0,8	1,1	16,87	220					10,63	620		
16 ER 0,35	0,35	16	0,8	0,4	18,05	234			21,94	734	11,78	634		
16 ER 0,4	0,40	16	0,7	0,4	18,05	236			21,94	736	11,78	636		
16 ER 0,45	0,45	16	0,7	0,4	18,05	238					11,78	638		
16 ER 0,5	0,50	16	0,6	0,6	18,05	240	15,14	140	16,64	740	11,78	640	16,64	940
16 ER 0,7	0,70	16	0,6	0,6	18,05	241	16,22	141	17,62	741	11,78	641		
16 ER 0,75	0,75	16	0,6	0,6	18,05	242	15,14	142	16,64	742	11,78	642	16,64	942
16 ER 0,8	0,80	16	0,6	0,6	18,05	243	15,14	143	16,64	743	11,78	643	16,64	943
16 ER 1,0	1,00	16	0,7	0,7	16,87	244	14,60	144	16,22	744	10,63	644	16,22	944
16 ER 1,25	1,25	16	0,8	0,9	16,87	246	14,60	146	16,22	746	10,63	646	16,22	946
16 ER 1,5	1,50	16	0,8	1,0	16,87	248	14,60	148	16,22	748	10,63	648	16,22	948
16 ER 1,75	1,75	16	0,9	1,2	16,87	250	14,60	150	16,22	750	10,63	650		
16 ER 2,0	2,00	16	1,0	1,3	16,87	252	14,60	152	16,22	752	10,63	652	16,22	952
16 ER 2,5	2,50	16	1,1	1,5	16,87	254	14,60	154	16,22	754	10,63	654	16,22	954
16 ER 3,0	3,00	16	1,2	1,6	16,87	256	14,60	156	16,22	756	10,63	656	16,22	956
22 ER 3,5	3,50	22	1,6	2,3	25,29	270	22,70	170	24,97	770	16,43	670		
22 ER 4,0	4,00	22	1,6	2,3	25,29	272	23,89	172	25,83	772	16,43	672		
22 ER 4,5	4,50	22	1,7	2,4	25,29	274	25,62	174	27,89	774	16,43	674		
22 ER 5,0	5,00	22	1,7	2,5	25,29	276	25,62	176	27,89	776	16,43	676		
22 ER 5,5	5,50	22	1,7	2,6			25,62	178						
22 ER 5,5	5,50	22	1,9	2,7	25,29	278					16,43	678		
22 EN 5,5	5,50	22	2,3	11,0	31,89	282 ¹⁾					21,62	682 ¹⁾		
22 ER 6,0	6,00	22	1,9	2,7			25,62	180	27,89	780				
22 ER 6,0	6,00	22	2,0	2,9	25,29	280					16,43	680		
22 EN 6,0	6,00	22	2,6	11,0	31,89	284 ¹⁾					21,62	684 ¹⁾		

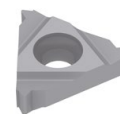
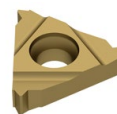
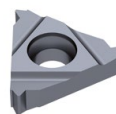
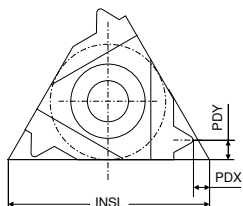
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Stainless steel	●	○	●	●
Cast iron		●	○	●
Non ferrous metals	○	●	○	○
Heat resistant alloys			○	●

1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

→ v_c Page 42

Left hand external thread turning insert

▲ Full profile



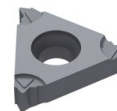
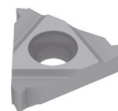
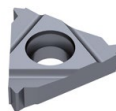
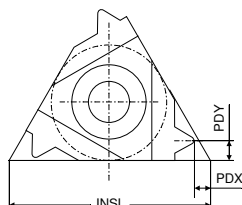
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					Article no.		Article no.		Article no.		Article no.	
					71 222 ...	EUR	71 222 ...	EUR	71 222 ...	EUR	71 222 ...	EUR
11 EL 0,35	0,35	11	0,8	0,4	18,05	204					11,78	604
11 EL 0,4	0,40	11	0,7	0,4	18,05	206					11,78	606
11 EL 0,45	0,45	11	0,7	0,4	18,05	208					11,78	608
11 EL 0,5	0,50	11	0,6	0,6	18,05	209					11,78	609
11 EL 0,6	0,60	11	0,6	0,6	18,05	210					11,78	610
11 EL 0,7	0,70	11	0,6	0,6	18,05	211					11,78	611
11 EL 0,75	0,75	11	0,6	0,6	18,05	212					11,78	612
11 EL 0,8	0,80	11	0,6	0,6	18,05	213					11,78	613
11 EL 1,0	1,00	11	0,7	0,7	16,87	214					10,63	614
11 EL 1,25	1,25	11	0,8	0,9	16,87	216					10,63	616
11 EL 1,5	1,50	11	0,8	1,0	16,87	218					10,63	618
11 EL 1,75	1,75	11	0,8	1,1	16,87	220					10,63	620
16 EL 0,35	0,35	16	0,8	0,4	18,05	234					11,78	634
16 EL 0,4	0,40	16	0,7	0,4	18,05	236					11,78	636
16 EL 0,45	0,45	16	0,7	0,4	18,05	238					11,78	638
16 EL 0,5	0,50	16	0,6	0,6	18,05	240					11,78	640
16 EL 0,7	0,70	16	0,6	0,6	18,05	241					11,78	641
16 EL 0,75	0,75	16	0,6	0,6	18,05	242					11,78	642
16 EL 0,8	0,80	16	0,6	0,6	18,05	243					11,78	643
16 EL 1,0	1,00	16	0,7	0,7	16,87	244	15,56	144	16,97	744	10,63	644
16 EL 1,25	1,25	16	0,8	0,9	16,87	246	16,54	146			10,63	646
16 EL 1,5	1,50	16	0,8	1,0	16,87	248	15,56	148	16,97	748	10,63	648
16 EL 1,75	1,75	16	0,9	1,2	16,87	250			19,90	750	10,63	650
16 EL 2,0	2,00	16	1,0	1,3	16,87	252	16,54	152			10,63	652
16 EL 2,5	2,50	16	1,1	1,5	16,87	254					10,63	654
16 EL 3,0	3,00	16	1,2	1,6	16,87	256	19,24	156			10,63	656
22 EL 3,5	3,50	22	1,6	2,3	25,29	270					21,62	670
22 EL 4,0	4,00	22	1,6	2,3	25,29	272					21,62	672
22 EL 4,5	4,50	22	1,7	2,4	25,29	274					21,62	674
22 EL 5,0	5,00	22	1,7	2,5	25,29	276					21,62	676
22 EL 5,5	5,50	22	1,9	2,7	25,29	278					21,62	678
22 EL 6,0	6,00	22	2,0	2,9	25,29	280					21,62	680
Steel					●		●		○			
Stainless steel					●		○		●			
Cast iron							●		○		●	
Non ferrous metals					○		●		○		●	
Heat resistant alloys									○		○	

→ v_c Page 42

Right hand internal thread turning insert

▲ Full profile

▲ CCN7525 grade with sintered chip breaker for universal application



Designation	TP	INS	PDX	PDY	IR X3		IR X3		IR X3		IR Y1		IR X3	
					Article no.		Article no.		Article no.		Article no.		Article no.	
					71 224 ...	EUR	71 224 ...	EUR	71 224 ...	EUR	71 224 ...	EUR	71 224 ...	EUR
11 IR 0,35	0,35	11	0,8	0,3	18,05	204					11,78	604		
11 IR 0,4	0,40	11	0,8	0,4	18,05	206					11,78	606		
11 IR 0,45	0,45	11	0,8	0,4	18,05	208					11,78	608		
11 IR 0,5	0,50	11	0,6	0,6	18,05	210					11,78	610		
11 IR 0,7	0,70	11	0,6	0,6	18,05	211					11,78	611		
11 IR 0,75	0,75	11	0,6	0,6	18,05	212					11,78	612	19,90	912
11 IR 0,8	0,80	11	0,6	0,6	18,05	213			22,48	713	11,78	613		
11 IR 1,0	1,00	11	0,6	0,6									16,22	914
11 IR 1,0	1,00	11	0,6	0,7	16,87	214	14,60	114	16,22	714	10,63	614		
11 IR 1,25	1,25	11	0,8	0,9	16,87	216					10,63	616		
11 IR 1,5	1,50	11	0,8	0,9									16,22	918
11 IR 1,5	1,50	11	0,8	1,0	16,87	218	14,60	118	16,22	718	10,63	618		
11 IR 1,75	1,75	11	0,9	1,1	16,87	220					10,63	620		
11 IR 2,0	2,00	11	0,8	0,9			14,60	122	16,22	722				
11 IR 2,0	2,00	11	0,9	1,1	16,87	222					10,63	622		
11 IR 2,5	2,50	11	0,8	1,2			16,54	124	18,05	724				
11 IR 2,5	2,50	11	0,9	1,1	16,87	224					10,63	624		
16 IR 0,35	0,35	16	0,8	0,4	18,05	234					11,78	634		
16 IR 0,4	0,40	16	0,7	0,4	18,05	236					11,78	636		
16 IR 0,45	0,45	16	0,7	0,4	18,05	238					11,78	638		
16 IR 0,5	0,50	16	0,6	0,6	18,05	240					11,78	640		
16 IR 0,7	0,70	16	0,6	0,6	18,05	241					11,78	641		
16 IR 0,75	0,75	16	0,6	0,6	18,05	242	18,26	142	19,90	742	11,78	642		
16 IR 0,8	0,80	16	0,6	0,6	18,05	243					11,78	643		
16 IR 1,0	1,00	16	0,6	0,7			14,60	144	16,22	744			16,22	944
16 IR 1,0	1,00	16	0,7	0,7	16,87	244					10,63	644		
16 IR 1,25	1,25	16	0,8	0,9	16,87	246			16,97	746	10,63	646	16,97	946
16 IR 1,5	1,50	16	0,8	1,0	16,87	248	14,60	148	16,22	748	10,63	648	16,22	948
16 IR 1,75	1,75	16	0,9	1,2	16,87	250			19,90	750	10,63	650		
16 IR 2,0	2,00	16	1,0	1,3	16,87	252	14,60	152	16,22	752	10,63	652	16,22	952
16 IR 2,5	2,50	16	1,1	1,5	16,87	254	14,60	154	16,22	754	10,63	654	16,22	954
16 IR 3,0	3,00	16	1,1	1,5	16,87	256	14,60	156	16,22	756	10,63	656	16,22	956
22 IR 3,5	3,50	22	1,6	2,3	25,29	270	23,89	170	25,83	770	16,43	670		
22 IR 4,0	4,00	22	1,6	2,3	25,29	272	23,89	172	25,83	772	16,43	672		
22 IR 4,5	4,50	22	1,6	2,4			25,62	174	27,89	774				
22 IR 4,5	4,50	22	1,7	2,4	25,29	274					16,43	674		
22 IR 5,0	5,00	22	1,6	2,3			25,62	176						
22 IR 5,0	5,00	22	1,7	2,5	25,29	276					16,43	676		
22 IR 5,5	5,50	22	1,6	2,3			25,95	178						
22 IR 5,5	5,50	22	1,9	2,7	25,29	278					16,43	678		
22 IN 5,5	5,50	22	2,3	11,0	31,89	282 ¹⁾					21,62	682 ¹⁾		
22 IR 6,0	6,00	22	1,6	2,4			25,62	180						
22 IR 6,0	6,00	22	2,0	2,9	25,29	280					16,43	680		
22 IN 6,0	6,00	22	2,6	11,0	31,89	284 ¹⁾					21,62	684 ¹⁾		

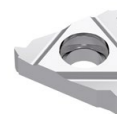
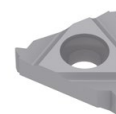
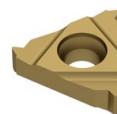
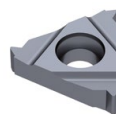
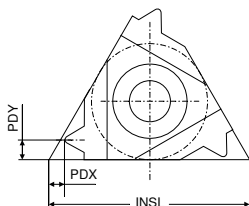
Steel	●	●	○	●
Stainless steel	●	○	●	●
Cast iron		●	○	●
Non ferrous metals	○	●	○	○
Heat resistant alloys			○	○

1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

→ v_c Page 42

Left hand internal thread turning insert

▲ Full profile



Designation	TP	INSL	PDX	PDY	IL X3		IL X3		IL X3		IL Y1	
					Article no.		Article no.		Article no.		Article no.	
					71 226 ...	EUR	71 226 ...	EUR	71 226 ...	EUR	71 226 ...	EUR
11 IL 0,35	0,35	11	0,8	0,3	18,05	204					11,78	604
11 IL 0,4	0,40	11	0,8	0,4	18,05	206					11,78	606
11 IL 0,45	0,45	11	0,8	0,4	18,05	208					11,78	608
11 IL 0,5	0,50	11	0,6	0,6	18,05	210					11,78	610
11 IL 0,7	0,70	11	0,6	0,6	18,05	211					11,78	611
11 IL 0,75	0,75	11	0,6	0,6	18,05	212					11,78	612
11 IL 0,8	0,80	11	0,6	0,6	18,05	213					11,78	613
11 IL 1,0	1,00	11	0,6	0,7	16,87	214					10,63	614
11 IL 1,25	1,25	11	0,8	0,9	16,87	216					10,63	616
11 IL 1,5	1,50	11	0,8	1,0	16,87	218					10,63	618
11 IL 1,75	1,75	11	0,9	1,1	16,87	220					10,63	620
11 IL 2,0	2,00	11	0,9	1,1	16,87	222					10,63	622
11 IL 2,5	2,50	11	0,9	1,1	16,87	224					10,63	624
16 IL 0,35	0,35	16	0,8	0,4	18,05	234					11,78	634
16 IL 0,4	0,40	16	0,7	0,4	18,05	236					11,78	636
16 IL 0,45	0,45	16	0,7	0,4	18,05	238					11,78	638
16 IL 0,5	0,50	16	0,6	0,6	18,05	240					11,78	640
16 IL 0,7	0,70	16	0,6	0,6	18,05	241					11,78	641
16 IL 0,75	0,75	16	0,6	0,6	18,05	242					11,78	642
16 IL 0,8	0,80	16	0,6	0,6	18,05	243					11,78	643
16 IL 1,0	1,00	16	0,6	0,7			19,24	144				
16 IL 1,0	1,00	16	0,7	0,7	16,87	244					10,63	644
16 IL 1,25	1,25	16	0,8	0,9	16,87	246					10,63	646
16 IL 1,5	1,50	16	0,8	1,0	16,87	248	18,38	148	19,90	748	10,63	648
16 IL 1,75	1,75	16	0,9	1,2	16,87	250					10,63	650
16 IL 2,0	2,00	16	1,0	1,3	16,87	252	16,54	152			10,63	652
16 IL 2,5	2,50	16	1,1	1,5	16,87	254					10,63	654
16 IL 3,0	3,00	16	1,2	1,6	16,87	256					10,63	656
22 IL 3,5	3,50	22	1,6	2,3	31,68	270					21,62	670
22 IL 4,0	4,00	22	1,6	2,3	31,68	272					21,62	672
22 IL 4,5	4,50	22	1,7	2,4	31,68	274					21,62	674
22 IL 5,0	5,00	22	1,7	2,5	31,68	276					21,62	676
22 IL 5,5	5,50	22	1,9	2,7	31,68	278					21,62	678
22 IL 6,0	6,00	22	2,0	2,9	31,68	280					21,62	680

Steel	●	●	○	
Stainless steel	●	○	●	
Cast iron		●	○	●
Non ferrous metals	○	●	○	●
Heat resistant alloys			○	○

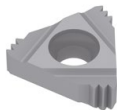
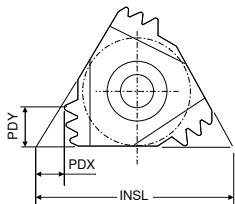
→ v_c Page 42

Right hand external thread turning insert

▲ Multi edge insert



HCN2525



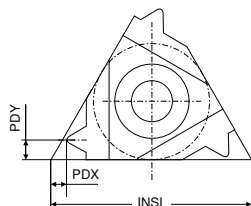
Designation	TP	INSL	PDX	PDY	NT	ER X3	
	mm	mm	mm	mm		Article no.	
16 ER 1,0 3M	1,0	16	1,7	2,5	3	71 221 ...	
16 ER 1,5 2M	1,5	16	1,5	2,3	2		

Steel	○
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	○

→ v_c Page 42

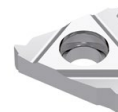
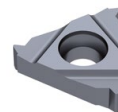
Right hand external thread turning insert

▲ Full profile



CCN20

CWK20



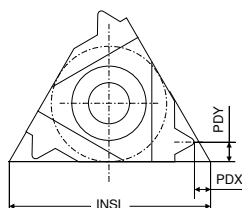
Designation	TP	INSL	PDX	PDY	ER X3		ER Y1	
					Article no. 71 286 ...		Article no. 71 286 ...	
	mm	mm	mm	mm	EUR		EUR	
11 ER 1,0	1,00	11	0,7	0,8	30,60	214	22,91	614
11 ER 1,25	1,25	11	0,8	0,9	30,60	216	22,91	616
11 ER 1,5	1,50	11	0,8	1,0	30,60	218	22,91	618
11 ER 2,0	2,00	11	0,9	1,0	30,60	222	22,91	622
16 ER 1,0	1,00	16	0,7	0,8	30,60	244	22,91	644
16 ER 1,25	1,25	16	0,8	0,9	30,60	246	22,91	646
16 ER 1,5	1,50	16	0,8	1,0	30,60	248	22,91	648
16 ER 2,0	2,00	16	1,0	1,3	30,60	252	22,91	652

Steel	•
Stainless steel	•
Cast iron	•
Non ferrous metals	○
Heat resistant alloys	○

→ v_c Page 42

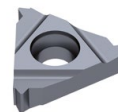
Left hand external thread turning insert

▲ Full profile



CCN20

CWK20



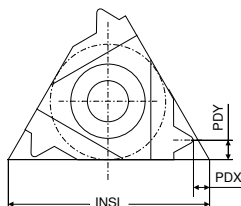
Designation	TP	INSL	PDX	PDY	EL X3		EL Y1	
					Article no. 71 287 ...		Article no. 71 287 ...	
	mm	mm	mm	mm	EUR		EUR	
11 EL 1,0	1,00	11	0,7	0,8	30,60	214	22,91	614
11 EL 1,25	1,25	11	0,8	0,9	30,60	216	22,91	616
11 EL 1,5	1,50	11	0,8	1,0	30,60	218	22,91	618
11 EL 2,0	2,00	11	0,9	1,0	30,60	222	22,91	622
16 EL 1,0	1,00	16	0,7	0,8	30,60	244	22,91	644
16 EL 1,25	1,25	16	0,8	0,9	30,60	246	22,91	646
16 EL 1,5	1,50	16	0,8	1,0	30,60	248	22,91	648
16 EL 2,0	2,00	16	1,0	1,3	30,60	252	22,91	652

Steel	•
Stainless steel	•
Cast iron	•
Non ferrous metals	○
Heat resistant alloys	○

→ v_c Page 42

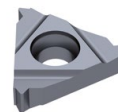
Right hand internal thread turning insert

▲ Full profile



CCN20

CWK20



Designation	TP	INS	PDX	PDY
	mm	mm	mm	mm
11 IR 1,0	1,00	11	0,7	0,8
11 IR 1,25	1,25	11	0,8	0,9
11 IR 1,5	1,50	11	0,8	1,0
11 IR 2,0	2,00	11	0,9	1,0
16 IR 1,0	1,00	16	0,7	0,8
16 IR 1,25	1,25	16	0,8	0,9
16 IR 1,5	1,50	16	0,8	1,0
16 IR 2,0	2,00	16	1,0	1,3

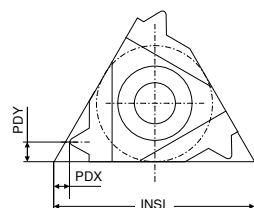
IR	IR
X3	Y1
Article no.	Article no.
71 284 ...	71 284 ...
EUR	EUR
30,60 214	22,91 614
30,60 216	22,91 616
30,60 218	22,91 618
30,60 222	22,91 622
30,60 244	22,91 644
30,60 246	22,91 646
30,60 248	22,91 648
30,60 252	22,91 652

Steel	•
Stainless steel	•
Cast iron	•
Non ferrous metals	○
Heat resistant alloys	○

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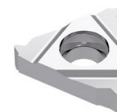
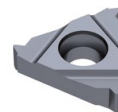
Left hand internal thread turning insert

▲ Full profile



CCN20

CWK20



Designation	TP	INS	PDX	PDY
	mm	mm	mm	mm
11 IL 1,0	1,00	11	0,7	0,8
11 IL 1,25	1,25	11	0,8	0,9
11 IL 1,5	1,50	11	0,8	1,0
11 IL 2,0	2,00	11	0,9	1,0
16 IL 1,0	1,00	16	0,7	0,8
16 IL 1,25	1,25	16	0,8	0,9
16 IL 1,5	1,50	16	0,8	1,0
16 IL 2,0	2,00	16	1,0	1,3

IL	IL
X3	Y1
Article no.	Article no.
71 285 ...	71 285 ...
EUR	EUR
30,60 214	22,91 614
30,60 216	22,91 616
30,60 218	22,91 618
30,60 222	22,91 622
30,60 244	22,91 644
30,60 246	22,91 646
30,60 248	22,91 648
30,60 252	22,91 652

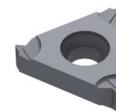
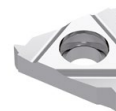
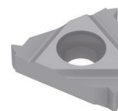
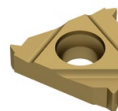
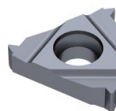
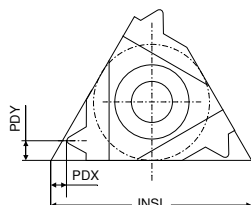
Steel	•
Stainless steel	•
Cast iron	•
Non ferrous metals	○
Heat resistant alloys	○

→ v_c Page 42

Right hand external thread turning insert

▲ Full profile

▲ CCN7525 grade with sintered chip breaker for universal application



Designation	TPI	INSL	PDX	PDY	ER X3		ER X3		ER X3		ER Y1		ER X3	
					Article no.		Article no.		Article no.		Article no.		Article no.	
					71 228 ...	EUR	71 228 ...	EUR	71 228 ...	EUR	71 228 ...	EUR	71 228 ...	EUR
11 ER 72	72,0	11	0,7	4,0	21,29	202					13,83	602		
11 ER 60	60,0	11	0,7	4,0	21,29	204					13,83	604		
11 ER 56	56,0	11	0,7	4,0	21,29	206					13,83	606		
11 ER 48	48,0	11	0,6	0,6	21,29	208					13,83	608		
11 ER 40	40,0	11	0,6	0,6	21,29	210					13,83	610		
11 ER 36	36,0	11	0,6	0,6	21,29	212					13,83	612		
11 ER 32	32,0	11	0,6	0,6	21,29	214					13,83	614		
11 ER 28	28,0	11	0,6	0,7	19,56	216					12,75	616		
11 ER 26	26,0	11	0,7	0,8	19,56	218					12,75	618		
11 ER 24	24,0	11	0,7	0,8	19,56	220					12,75	620		
11 ER 22	22,0	11	0,8	0,9	19,56	222					12,75	622		
11 ER 20	20,0	11	0,8	0,9	19,56	224					12,75	624		
11 ER 19	19,0	11	0,8	1,0	19,56	226					12,75	626		
11 ER 18	18,0	11	0,8	1,0	19,56	228					12,75	628		
11 ER 16	16,0	11	0,9	1,1	19,56	230					12,75	630		
11 ER 14	14,0	11	0,9	1,1	19,56	232					12,75	632		
16 ER 40	40,0	16	0,6	0,6	21,29	240					13,83	640		
16 ER 36	36,0	16	0,6	0,6	21,29	242					13,83	642		
16 ER 32	32,0	16	0,6	0,6	21,29	244					13,83	644		
16 ER 28	28,0	16	0,6	0,7	19,56	246	18,80	146	20,54	746	12,75	646		
16 ER 26	26,0	16	0,7	0,7					22,91	748				
16 ER 26	26,0	16	0,7	0,8	19,56	248					12,75	648		
16 ER 24	24,0	16	0,7	0,8	19,56	250					12,75	650		
16 ER 22	22,0	16	0,8	0,9	19,56	252					12,75	652		
16 ER 20	20,0	16	0,8	0,9	19,56	254			22,91	754	12,75	654		
16 ER 19	19,0	16	0,8	1,0	19,56	256	16,87	156	18,60	756	12,75	656	18,60	956
16 ER 18	18,0	16	0,8	1,0	19,56	258					12,75	658		
16 ER 16	16,0	16	0,9	1,1	19,56	260	20,86	160	22,37	760	12,75	660		
16 ER 14	14,0	16	1,0	1,2	19,56	262	16,87	162	18,60	762	12,75	662	18,60	962
16 ER 12	12,0	16	1,1	1,4	19,56	264	20,86	164	22,37	764	12,75	664		
16 ER 11	11,0	16	1,1	1,5	19,56	266	16,87	166	18,60	766	12,75	666	18,60	966
16 ER 10	10,0	16	1,1	1,5	19,56	268					12,75	668		
16 ER 9	9,0	16	1,2	1,7	19,56	270					12,75	670		
16 ER 8	8,0	16	1,2	1,5	19,56	272					12,75	672		
22 ER 7	7,0	22	1,6	2,3	30,26	280					20,44	680		
22 ER 6	6,0	22	1,6	2,3	30,26	282					20,44	682		
22 ER 5	5,0	22	1,7	2,4	30,26	284					20,44	684		
22 EN 4,5	4,5	22	2,3	11,0	32,53	290 ¹⁾					22,16	690 ¹⁾		
22 EN 4	4,0	22	1,8	11,0	32,53	292 ¹⁾					22,16	692 ¹⁾		

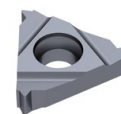
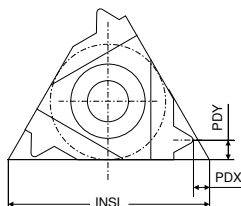
Steel	●	●	○	●
Stainless steel	●	○	●	●
Cast iron		●	○	●
Non ferrous metals	○	●	○	○
Heat resistant alloys			○	○

1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

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Left hand external thread turning insert

▲ Full profile



Designation	TPI	INSL	PDX	PDY	EL X3		EL Y1	
					Article no.		Article no.	
					71 229 ...		71 229 ...	
	1/"	mm	mm	mm	EUR		EUR	
11 EL 72	72	11	0,7	4,0	24,43	202	16,75	602
11 EL 60	60	11	0,7	4,0	24,43	204	16,75	604
11 EL 56	56	11	0,7	4,0	24,43	206	16,75	606
11 EL 48	48	11	0,6	0,6	24,43	208	16,75	608
11 EL 40	40	11	0,6	0,6	24,43	210	16,75	610
11 EL 36	36	11	0,6	0,6	24,43	212	15,56	612
11 EL 32	32	11	0,6	0,6	24,43	214	15,56	614
11 EL 28	28	11	0,6	0,7	22,91	216	15,56	616
11 EL 26	26	11	0,7	0,8	22,91	218	15,56	618
11 EL 24	24	11	0,7	0,8	22,91	220	15,56	620
11 EL 22	22	11	0,8	0,9	22,91	222	15,56	622
11 EL 20	20	11	0,8	0,9	22,91	224	15,56	624
11 EL 19	19	11	0,8	1,0	22,91	226	15,56	626
11 EL 18	18	11	0,8	1,0	22,91	228	15,56	628
11 EL 16	16	11	0,9	1,1	22,91	230	15,56	630
11 EL 14	14	11	0,9	1,1	19,56	232	12,75	632
16 EL 40	40	16	0,6	0,6	24,43	240	16,75	640
16 EL 36	36	16	0,6	0,6	24,43	242	16,75	642
16 EL 32	32	16	0,6	0,6	24,43	244	16,75	644
16 EL 28	28	16	0,6	0,7	22,91	246	15,56	646
16 EL 26	26	16	0,7	0,8	22,91	248	15,56	648
16 EL 24	24	16	0,7	0,8	22,91	250	15,56	650
16 EL 22	22	16	0,8	0,9	22,91	252	15,56	652
16 EL 20	20	16	0,8	0,9	22,91	254	15,56	654
16 EL 19	19	16	0,8	1,0	22,91	256	15,56	656
16 EL 18	18	16	0,8	1,0	22,91	258	15,56	658
16 EL 16	16	16	0,9	1,1	22,91	260	15,56	660
16 EL 14	14	16	1,0	1,2	19,56	262	12,75	662
16 EL 12	12	16	1,1	1,4	22,91	264	15,56	664
16 EL 11	11	16	1,1	1,5	19,56	266	12,75	666
16 EL 10	10	16	1,1	1,5	26,16	268	17,95	668
16 EL 9	9	16	1,2	1,7	26,16	270	17,95	670
16 EL 8	8	16	1,2	1,5	26,16	272	17,95	672
22 EL 7	7	22	1,6	2,3	35,45	280	24,64	680
22 EL 6	6	22	1,6	2,3	35,45	282	24,64	682
22 EL 5	5	22	1,7	2,4	36,21	284	24,64	684

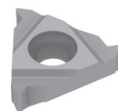
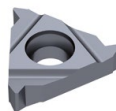
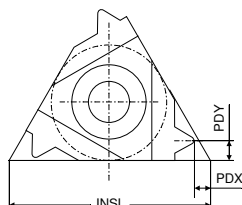
Steel	●	
Stainless steel	●	
Cast iron		●
Non ferrous metals	○	●
Heat resistant alloys		○

→ v_c Page 42

Right hand internal thread turning insert

▲ Full profile

▲ CCN7525 grade with sintered chip breaker for universal application

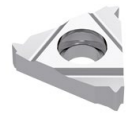
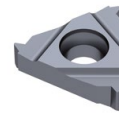
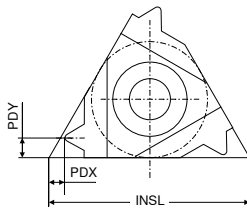


Designation	TPI	INSL	PDX	PDY	IR X3		IR X3		IR X3		IR Y1		IR X3	
					Article no.		Article no.		Article no.		Article no.		Article no.	
					71 230 ...	EUR	71 230 ...	EUR	71 230 ...	EUR	71 230 ...	EUR	71 230 ...	EUR
11 IR 48	48	11	0,6	0,6	21,29	206					13,83	606		
11 IR 40	40	11	0,6	0,6	21,29	208					13,83	608		
11 IR 36	36	11	0,6	0,6	21,29	210					13,83	610		
11 IR 32	32	11	0,6	0,6	21,29	212					13,83	612		
11 IR 28	28	11	0,6	0,7	19,56	214					12,75	614		
11 IR 26	26	11	0,7	0,8	19,56	216					12,75	616		
11 IR 24	24	11	0,7	0,8	19,56	218					12,75	618		
11 IR 22	22	11	0,8	0,9	19,56	220					12,75	620		
11 IR 20	20	11	0,8	0,9	19,56	222					12,75	622		
11 IR 19	19	11	0,8	0,9									19,68	924
11 IR 19	19	11	0,8	1,0	19,56	224	17,95	124	19,68	724	12,75	624		
11 IR 18	18	11	0,8	1,0	19,56	226					12,75	626		
11 IR 16	16	11	0,9	1,1	19,56	228					12,75	628		
11 IR 14	14	11	0,8	0,9									19,68	930
11 IR 14	14	11	0,9	1,1	19,56	230	17,95	130	19,68	730	12,75	630		
16 IR 40	40	16	0,6	0,6	21,29	240					13,83	640		
16 IR 36	36	16	0,6	0,6	21,29	242					13,83	642		
16 IR 32	32	16	0,6	0,6	21,29	244					13,83	644		
16 IR 28	28	16	0,6	0,7	19,56	246					12,75	646		
16 IR 26	26	16	0,7	0,8	19,56	248					12,75	648		
16 IR 24	24	16	0,7	0,8	19,56	250					12,75	650		
16 IR 22	22	16	0,8	0,9	19,56	252					12,75	652		
16 IR 20	20	16	0,8	0,9	19,56	254					12,75	654		
16 IR 19	19	16	0,8	1,0	19,56	256					12,75	656		
16 IR 18	18	16	0,8	1,0	19,56	258					12,75	658		
16 IR 16	16	16	0,9	1,1	19,56	260			22,91	760	12,75	660		
16 IR 14	14	16	1,0	1,2	19,56	262	16,87	162	18,60	762	12,75	662	18,60	962
16 IR 12	12	16	1,1	1,4	19,56	264					12,75	664		
16 IR 11	11	16	1,1	1,5	19,56	266	16,87	166	18,60	766	12,75	666	18,60	966
16 IR 10	10	16	1,1	1,5	19,56	268					12,75	668		
16 IR 9	9	16	1,2	1,7	19,56	270					12,75	670		
16 IR 8	8	16	1,2	1,5	19,56	272					12,75	672		
22 IR 7	7	22	1,6	2,3	30,60	280					20,44	680		
22 IR 6	6	22	1,6	2,3	30,60	282					20,44	682		
22 IR 5	5	22	1,7	2,4	30,60	284					20,44	684		
Steel					●		●		○				●	
Stainless steel					●		○		●				●	
Cast iron							●		○		●		●	
Non ferrous metals					○		●		○		●		○	
Heat resistant alloys									○		○		●	

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Left hand internal thread turning insert

▲ Full profile



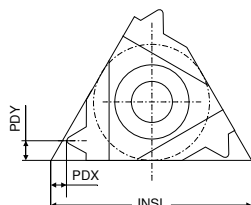
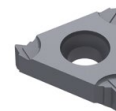
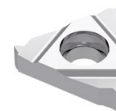
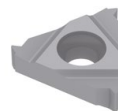
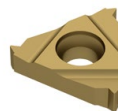
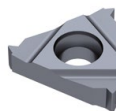
Designation	TPI	INSL	PDX	PDY	IL X3		IL Y1	
					Article no.	71 231 ...	Article no.	71 231 ...
	1/"	mm	mm	mm	EUR		EUR	
11 IL 48	48	11	0,6	0,6	24,43	206	16,75	606
11 IL 40	40	11	0,6	0,6	24,43	208	16,75	608
11 IL 36	36	11	0,6	0,6	22,91	210	15,56	610
11 IL 32	32	11	0,6	0,6	22,91	212	15,56	612
11 IL 28	28	11	0,6	0,7	22,91	214	15,56	614
11 IL 26	26	11	0,7	0,8	22,91	216	15,56	616
11 IL 24	24	11	0,7	0,8	22,91	218	15,56	618
11 IL 22	22	11	0,8	0,9	22,91	220	15,56	620
11 IL 20	20	11	0,8	0,9	22,91	222	15,56	622
11 IL 19	19	11	0,8	1,0	22,91	224	15,56	624
11 IL 18	18	11	0,8	1,0	22,91	226	15,56	626
11 IL 16	16	11	0,9	1,1	22,91	228	15,56	628
11 IL 14	14	11	0,9	1,1	19,56	230	12,75	630
16 IL 40	40	16	0,6	0,6	24,43	240	16,75	640
16 IL 36	36	16	0,6	0,6	24,43	242	16,75	642
16 IL 32	32	16	0,6	0,6	24,43	244	16,75	644
16 IL 28	28	16	0,6	0,7	22,91	246	15,56	646
16 IL 26	26	16	0,7	0,8	22,91	248	15,56	648
16 IL 24	24	16	0,7	0,8	22,91	250	15,56	650
16 IL 22	22	16	0,8	0,9	22,91	252	15,56	652
16 IL 20	20	16	0,8	0,9	22,91	254	15,56	654
16 IL 19	19	16	0,8	1,0	22,91	256	15,56	656
16 IL 18	18	16	0,8	1,0	22,91	258	15,56	658
16 IL 16	16	16	0,9	1,1	22,91	260	15,56	660
16 IL 14	14	16	1,0	1,2	19,56	262	12,75	662
16 IL 12	12	16	1,1	1,4	22,91	264	15,56	664
16 IL 11	11	16	1,1	1,5	19,56	266	12,75	666
16 IL 10	10	16	1,1	1,5	26,16	268	17,95	668
16 IL 9	9	16	1,2	1,7	26,16	270	17,95	670
16 IL 8	8	16	1,2	1,5	26,16	272	17,95	672
22 IL 7	7	22	1,6	2,3	35,45	280	24,64	680
22 IL 6	6	22	1,6	2,3	35,45	282	24,64	682
22 IL 5	5	22	1,7	2,4	35,45	284	24,64	684
Steel						●		
Stainless steel						●		
Cast iron								●
Non ferrous metals					○		○	
Heat resistant alloys								○

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Right hand external thread turning insert

▲ Full profile

▲ CCN7525 grade with sintered chip breaker for universal application



Designation	TPI	INSL	PDX	PDY	ER X3		ER X3		ER X3		ER Y1		ER X3	
					Article no.		Article no.		Article no.		Article no.		Article no.	
					71 264 ...	EUR	71 264 ...	EUR	71 264 ...	EUR	71 264 ...	EUR	71 264 ...	EUR
11 ER 72	72,0	11	0,8	0,4	21,40	202					13,83	602		
11 ER 64	64,0	11	0,8	0,4	21,40	204					13,83	604		
11 ER 56	56,0	11	0,7	0,4	21,40	206					13,83	606		
11 ER 48	48,0	11	0,6	0,6	21,40	208					13,83	608		
11 ER 44	44,0	11	0,6	0,6	21,40	210					13,83	610		
11 ER 40	40,0	11	0,6	0,6	21,40	212					13,83	612		
11 ER 36	36,0	11	0,6	0,6	21,40	214					13,83	614		
11 ER 32	32,0	11	0,6	0,6	21,40	216					13,83	616		
11 ER 28	28,0	11	0,6	0,7	19,56	218					12,86	618		
11 ER 27	27,0	11	0,7	0,8	19,56	220					12,86	620		
11 ER 24	24,0	11	0,7	0,8	19,56	222					12,86	622		
11 ER 20	20,0	11	0,8	0,9	19,56	224					12,86	624		
11 ER 18	18,0	11	0,8	1,0	19,56	226					12,86	626		
11 ER 16	16,0	11	0,9	1,1	19,56	228					12,86	628		
11 ER 14	14,0	11	0,9	1,1	19,56	230					12,86	630		
16 ER 72	72,0	16	0,8	0,4	21,29	232					13,83	632		
16 ER 64	64,0	16	0,8	0,4	21,29	234					13,83	634		
16 ER 56	56,0	16	0,7	0,4	21,29	236					13,83	636		
16 ER 48	48,0	16	0,6	0,6	21,29	238					13,83	638		
16 ER 44	44,0	16	0,6	0,6	21,29	240					13,83	640		
16 ER 40	40,0	16	0,6	0,6	21,29	242					13,83	642		
16 ER 36	36,0	16	0,6	0,6	21,29	244					13,83	644		
16 ER 32	32,0	16	0,6	0,6	21,29	246			24,10	746	13,83	646		
16 ER 28	28,0	16	0,6	0,7	19,56	248			22,37	748	12,75	648		
16 ER 27	27,0	16	0,7	0,8	19,56	250					12,75	650		
16 ER 24	24,0	16	0,7	0,8	19,56	252	18,80	152	20,54	752	12,75	652		
16 ER 20	20,0	16	0,8	0,9	19,56	254	17,95	154	19,68	754	12,75	654	19,68	954
16 ER 18	18,0	16	0,8	1,0	19,56	256	18,80	156	20,54	756	12,75	656		
16 ER 16	16,0	16	0,9	1,1	19,56	258	17,95	158	19,68	758	12,75	658	19,68	958
16 ER 14	14,0	16	1,0	1,2	19,56	260	18,80	160	20,54	760	12,75	660		
16 ER 13	13,0	16	1,0	1,3	19,56	262					12,75	662		
16 ER 12	12,0	16	1,1	1,4	19,56	264	18,80	164	20,54	764	12,75	664		
16 ER 11,5	11,5	16	1,1	1,5	19,56	266					12,75	666		
16 ER 11	11,0	16	1,1	1,5	19,56	268	21,40	168			12,75	668		
16 ER 10	10,0	16	1,1	1,5	19,56	270					12,75	670		
16 ER 9	9,0	16	1,2	1,7	19,56	272					12,75	672		
16 ER 8	8,0	16	1,1	1,1			21,40	174					22,91	974
16 ER 8	8,0	16	1,1	1,5										
16 ER 8	8,0	16	1,2	1,6	19,56	274					12,75	674		
22 ER 7	7,0	22	1,6	2,3	30,60	276					20,44	676		
22 ER 6	6,0	22	1,6	2,3	30,60	278					20,44	678		
22 ER 5	5,0	22	1,7	2,5	30,60	280					20,44	680		
22 EN 4,5	4,5	22	2,0	11,0	32,53	282 ¹⁾					22,27	682 ¹⁾		
22 EN 4	4,0	22	2,0	11,0	32,53	284 ¹⁾					22,27	684 ¹⁾		

Steel	●	●	○	●
Stainless steel	●	○	●	●
Cast iron		●	○	●
Non ferrous metals	○	●	○	○
Heat resistant alloys			○	○

1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

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Left hand external thread turning insert

▲ Full profile



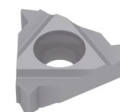
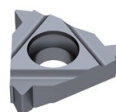
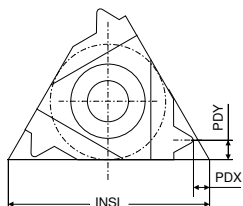
Designation	TPI	INSL	PDX	PDY	EL X3		EL Y1	
					Article no.		Article no.	
					71 266 ...		71 266 ...	
	1/"	mm	mm	mm	EUR		EUR	
11 EL 72	72,0	11	0,8	0,4	25,07	202	16,75	602
11 EL 64	64,0	11	0,8	0,4	25,07	204	16,75	604
11 EL 56	56,0	11	0,7	0,4	25,07	206	16,75	606
11 EL 48	48,0	11	0,6	0,6	25,07	208	16,75	608
11 EL 44	44,0	11	0,6	0,6	25,07	210	16,75	610
11 EL 40	40,0	11	0,6	0,6	25,07	212	16,75	612
11 EL 36	36,0	11	0,6	0,6	25,07	214	16,75	614
11 EL 32	32,0	11	0,6	0,6	25,07	216	16,75	616
11 EL 28	28,0	11	0,6	0,7	25,07	218	15,56	618
11 EL 27	27,0	11	0,7	0,8	25,07	220	15,56	620
11 EL 24	24,0	11	0,7	0,8	25,07	222	15,56	622
11 EL 20	20,0	11	0,8	0,9	25,07	224	15,56	624
11 EL 18	18,0	11	0,8	1,0	25,07	226	15,56	626
11 EL 16	16,0	11	0,9	1,1	25,07	228	15,56	628
11 EL 14	14,0	11	0,9	1,1	25,07	230	15,56	630
16 EL 72	72,0	16	0,8	0,4	24,43	232	16,75	632
16 EL 64	64,0	16	0,8	0,4	24,43	234	16,75	634
16 EL 56	56,0	16	0,7	0,4	24,43	236	16,75	636
16 EL 48	48,0	16	0,6	0,6	24,43	238	16,75	638
16 EL 44	44,0	16	0,6	0,6	24,43	240	16,75	640
16 EL 40	40,0	16	0,6	0,6	24,43	242	16,75	642
16 EL 36	36,0	16	0,6	0,6	24,43	244	16,75	644
16 EL 32	32,0	16	0,6	0,6	24,43	246	16,75	646
16 EL 28	28,0	16	0,6	0,7	22,91	248	15,56	648
16 EL 27	27,0	16	0,7	0,8	22,91	250	15,56	650
16 EL 24	24,0	16	0,7	0,8	22,91	252	15,56	652
16 EL 20	20,0	16	0,8	0,9	22,91	254	15,56	654
16 EL 18	18,0	16	0,8	1,0	22,91	256	15,56	656
16 EL 16	16,0	16	0,9	1,1	22,91	258	15,56	658
16 EL 14	14,0	16	1,0	1,2	22,91	260	15,56	660
16 EL 13	13,0	16	1,0	1,3	22,91	262	15,56	662
16 EL 12	12,0	16	1,1	1,4	19,56	264	12,75	664
16 EL 11,5	11,5	16	1,1	1,5	26,16	266	15,56	666
16 EL 11	11,0	16	1,1	1,5	26,16	268	15,56	668
16 EL 10	10,0	16	1,1	1,5	26,16	270	15,56	670
16 EL 9	9,0	16	1,2	1,7	26,16	272	15,56	672
16 EL 8	8,0	16	1,2	1,6	26,16	274	15,56	674
22 EL 7	7,0	22	1,6	2,3	35,45	276	24,64	676
22 EL 6	6,0	22	1,6	2,3	35,45	278	24,64	678
22 EL 5	5,0	22	1,7	2,5	35,45	280	24,64	680

Steel	●	
Stainless steel	●	
Cast iron		●
Non ferrous metals	○	●
Heat resistant alloys		○

→ v_c Page 42

Right hand internal thread turning insert

▲ Full profile



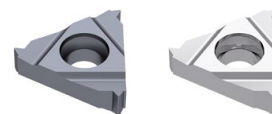
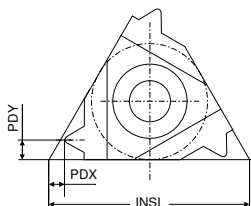
Designation	TPI	INSL	PDX	PDY	IR X3		IR X3		IR X3		IR Y1	
					Article no.		Article no.		Article no.		Article no.	
					71 268 ...	EUR	71 268 ...	EUR	71 268 ...	EUR	71 268 ...	EUR
11 IR 72	72,0	11	0,8	0,3	21,40	202					13,83	602
11 IR 64	64,0	11	0,8	0,4	21,40	204					13,83	604
11 IR 56	56,0	11	0,7	0,4	21,40	206					13,83	606
11 IR 48	48,0	11	0,6	0,6	21,40	208					13,83	608
11 IR 44	44,0	11	0,6	0,6	21,40	210					13,83	610
11 IR 40	40,0	11	0,6	0,6	21,40	212					13,83	612
11 IR 36	36,0	11	0,6	0,6	21,40	214					13,83	614
11 IR 32	32,0	11	0,6	0,6	21,40	216					13,83	616
11 IR 28	28,0	11	0,6	0,7	19,56	218					12,86	618
11 IR 27	27,0	11	0,7	0,8	19,56	220					12,86	620
11 IR 24	24,0	11	0,7	0,8	19,56	222					12,86	622
11 IR 20	20,0	11	0,8	0,9	19,56	224					12,86	624
11 IR 18	18,0	11	0,8	1,0	19,56	226					12,86	626
11 IR 16	16,0	11	0,9	1,1	19,56	228					12,86	628
11 IR 14	14,0	11	1,0	1,1	19,56	230					12,86	630
16 IR 72	72,0	16	0,8	0,3	21,29	232					13,83	632
16 IR 64	64,0	16	0,8	0,4	21,29	234					13,83	634
16 IR 56	56,0	16	0,7	0,4	21,29	236					13,83	636
16 IR 48	48,0	16	0,6	0,6	21,29	238					13,83	638
16 IR 44	44,0	16	0,6	0,6	21,29	240					13,83	640
16 IR 40	40,0	16	0,6	0,6	21,29	242					13,83	642
16 IR 36	36,0	16	0,6	0,6	21,29	244					13,83	644
16 IR 32	32,0	16	0,6	0,6	21,29	246					13,83	646
16 IR 28	28,0	16	0,6	0,7	19,56	248					12,75	648
16 IR 27	27,0	16	0,7	0,8	19,56	250					12,75	650
16 IR 24	24,0	16	0,7	0,8	19,56	252					12,75	652
16 IR 20	20,0	16	0,8	0,9	19,56	254					12,75	654
16 IR 18	18,0	16	0,8	1,0	19,56	256					12,75	656
16 IR 16	16,0	16	0,9	1,1	19,56	258					12,75	658
16 IR 14	14,0	16	1,0	1,2	19,56	260			22,91	760	12,75	660
16 IR 13	13,0	16	1,0	1,3	19,56	262					12,75	662
16 IR 12	12,0	16	1,1	1,4	19,56	264	18,80	164	20,54	764	12,75	664
16 IR 11,5	11,5	16	1,1	1,5	19,56	266					12,75	666
16 IR 11	11,0	16	1,1	1,5	19,56	268					12,75	668
16 IR 10	10,0	16	1,1	1,5	19,56	270					12,75	670
16 IR 9	9,0	16	1,2	1,7	19,56	272					12,75	672
16 IR 8	8,0	16	1,2	1,6	19,56	274					12,75	674
16 IR 8	8,0	16	1,1	1,5					22,91	774		
22 IR 7	7,0	22	1,6	2,3	30,60	276			32,86	776	20,44	676
22 IR 6	6,0	22	1,6	2,3	30,60	278					20,44	678
22 IR 5	5,0	22	1,7	2,5	30,60	280					20,44	680
22 IN 4,5	4,5	22	2,0	11,0	32,53	282 ¹⁾					22,27	682 ¹⁾
22 IN 4	4,0	22	2,0	11,0	32,53	284 ¹⁾					22,27	684 ¹⁾
Steel					●		●		○			
Stainless steel					●		○		●			
Cast iron							●		○		●	
Non ferrous metals					○		●		○		●	
Heat resistant alloys									○		○	

1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

→ v_c Page 42

Left hand internal thread turning insert

▲ Full profile



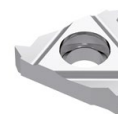
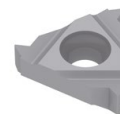
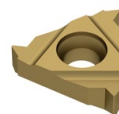
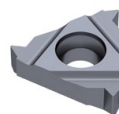
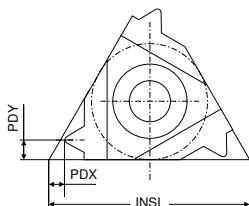
Designation	TPI	INSL	PDX	PDY	IL X3		IL Y1	
					Article no.		Article no.	
					71 270 ...		71 270 ...	
	1/"	mm	mm	mm	EUR		EUR	
11 IL 72	72,0	11	0,8	0,3	25,07	202	16,75	602
11 IL 64	64,0	11	0,8	0,4	25,07	204	16,75	604
11 IL 56	56,0	11	0,7	0,4	25,07	206	16,75	606
11 IL 48	48,0	11	0,6	0,6	25,07	208	16,75	608
11 IL 44	44,0	11	0,6	0,6	25,07	210	16,75	610
11 IL 40	40,0	11	0,6	0,6	25,07	212	16,75	612
11 IL 36	36,0	11	0,6	0,6	25,07	214	16,75	614
11 IL 32	32,0	11	0,6	0,6	25,07	216	16,75	616
11 IL 28	28,0	11	0,6	0,7	25,07	218	15,56	618
11 IL 27	27,0	11	0,7	0,8	25,07	220	15,56	620
11 IL 24	24,0	11	0,7	0,8	25,07	222	15,56	622
11 IL 20	20,0	11	0,8	0,9	25,07	224	15,56	624
11 IL 18	18,0	11	0,8	1,0	25,07	226	15,56	626
11 IL 16	16,0	11	0,9	1,1	25,07	228	15,56	628
11 IL 14	14,0	11	0,9	1,1	25,07	230	15,56	630
16 IL 72	72,0	16	0,8	0,3	25,07	232	16,75	632
16 IL 64	64,0	16	0,8	0,4	25,07	234	16,75	634
16 IL 56	56,0	16	0,7	0,4	25,07	236	16,75	636
16 IL 48	48,0	16	0,6	0,6	25,07	238	16,75	638
16 IL 44	44,0	16	0,6	0,6	25,07	240	16,75	640
16 IL 40	40,0	16	0,6	0,6	25,07	242	16,75	642
16 IL 36	36,0	16	0,6	0,6	25,07	244	16,75	644
16 IL 32	32,0	16	0,6	0,6	25,07	246	16,75	646
16 IL 28	28,0	16	0,6	0,7	25,07	248	15,56	648
16 IL 27	27,0	16	0,7	0,8	25,07	250	15,56	650
16 IL 24	24,0	16	0,7	0,8	25,07	252	15,56	652
16 IL 20	20,0	16	0,8	0,9	25,07	254	15,56	654
16 IL 18	18,0	16	0,8	1,0	25,07	256	15,56	656
16 IL 16	16,0	16	0,9	1,1	25,07	258	15,56	658
16 IL 14	14,0	16	1,0	1,2	25,07	260	15,56	660
16 IL 13	13,0	16	1,0	1,3	25,07	262	15,56	662
16 IL 12	12,0	16	1,1	1,4	25,07	264	12,86	664
16 IL 11,5	11,5	16	1,1	1,5	25,07	266	17,95	666
16 IL 11	11,0	16	1,1	1,5	25,07	268	15,56	668
16 IL 10	10,0	16	1,1	1,5	25,07	270	17,95	670
16 IL 9	9,0	16	1,2	1,7	25,07	272	17,95	672
16 IL 8	8,0	16	1,2	1,6	25,07	274	17,95	674
22 IL 7	7,0	22	1,6	2,3	25,07	276	24,64	676
22 IL 6	6,0	22	1,6	2,3	25,07	278	24,64	678
22 IL 5	5,0	22	1,7	2,5	25,07	280	24,64	680

Steel	●	
Stainless steel	●	
Cast iron		●
Non ferrous metals	○	●
Heat resistant alloys		○

→ v_c Page 42

Right hand external thread turning insert

▲ Full profile



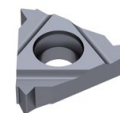
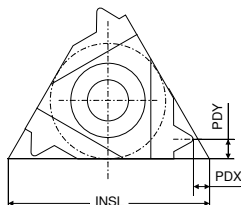
Designation	TPI	INSL	PDX	PDY	ER X3		ER X3		ER X3		ER Y1	
					Article no.		Article no.		Article no.		Article no.	
	1/"	mm	mm	mm	71 256 ...	EUR	71 256 ...	EUR	71 256 ...	EUR	71 256 ...	EUR
16 ER 27	27,0	16	0,7	0,8	21,94	240					14,60	640
16 ER 18	18,0	16	0,8	1,0	21,94	242			24,76	742	14,60	642
16 ER 14	14,0	16	0,9	1,2	21,94	244	20,86	144	22,70	744	14,60	644
16 ER 11,5	11,5	16	1,1	1,5	21,94	246	22,60	146	24,76	746	14,60	646
16 ER 8	8,0	16	1,3	1,8	21,94	248					14,60	648
Steel					●		●		○			
Stainless steel					●		○		●			
Cast iron							●		○		●	
Non ferrous metals					○		●		○		●	
Heat resistant alloys									○		○	

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8

Left hand external thread turning insert

▲ Full profile



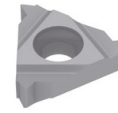
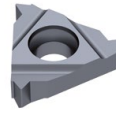
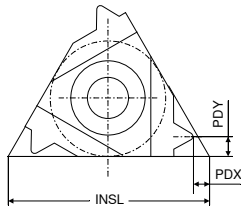
Designation	TPI	INSL	PDX	PDY	EL X3		EL Y1	
					Article no.		Article no.	
	1/"	mm	mm	mm	71 258 ...	EUR	71 258 ...	EUR
16 EL 27	27,0	16	0,7	0,8	25,51	240	17,51	640
16 EL 18	18,0	16	0,8	1,0	25,51	242	17,51	642
16 EL 14	14,0	16	0,9	1,2	25,51	244	17,51	644
16 EL 11,5	11,5	16	1,1	1,5	25,51	246	17,51	646
16 EL 8	8,0	16	1,3	1,8	25,51	248	17,51	648
Steel							●	
Stainless steel							●	
Cast iron								●
Non ferrous metals						○		●
Heat resistant alloys								○

→ v_c Page 42

Right hand internal thread turning insert

▲ Full profile

▲ CCN7525 grade with sintered chip breaker for universal application

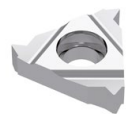
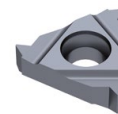
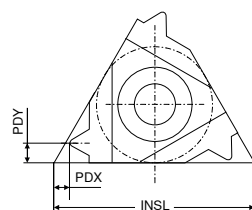


Designation	TPI	INSL	PDX	PDY	IR X3		IR X3		IR Y1		IR X3	
					Article no.		Article no.		Article no.		Article no.	
	1/"	mm	mm	mm	71 260 ...		71 260 ...		71 260 ...		71 260 ...	
					EUR		EUR		EUR		EUR	
11 IR 27	27,0	11	0,7	0,8	21,94	210			14,60	610		
11 IR 18	18,0	11	0,8	1,0	21,94	212			14,60	612		
11 IR 14	14,0	11	0,9	1,1	21,94	214			14,60	614		
16 IR 27	27,0	16	0,7	0,8	21,94	240			14,60	640		
16 IR 18	18,0	16	0,8	1,0	21,94	242			14,60	642		
16 IR 14	14,0	16	0,9	1,2	21,94	244	26,16	744	14,60	644	26,16	944
16 IR 11,5	11,5	16	1,1	1,5	21,94	246			14,60	646	26,49	946
16 IR 8	8,0	16	1,3	1,8	21,94	248			14,60	648		
Steel						●		○				●
Stainless steel						●		●				●
Cast iron								○		●		●
Non ferrous metals						○		○		●		○
Heat resistant alloys								○		○		●

→ v_c Page 42

Left hand internal thread turning insert

▲ Full profile



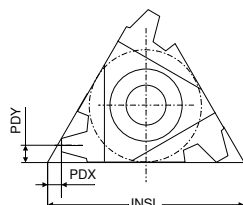
Designation	TPI	INSL	PDX	PDY	IL X3		IL Y1	
					Article no.		Article no.	
	1/"	mm	mm	mm	71 262 ...		71 262 ...	
					EUR		EUR	
11 IL 27	27,0	11	0,7	0,8	25,51	210	17,51	610
11 IL 18	18,0	11	0,8	1,0	25,51	212	17,51	612
11 IL 14	14,0	11	0,9	1,1	25,51	214	17,51	614
16 IL 27	27,0	16	0,7	0,8	25,51	240	17,51	640
16 IL 18	18,0	16	0,8	1,0	25,51	242	17,51	642
16 IL 14	14,0	16	0,9	1,2	25,51	244	17,51	644
16 IL 11,5	11,5	16	1,1	1,5	25,51	246	17,51	646
16 IL 8	8,0	16	1,3	1,8	25,51	248	17,51	648
Steel						●		
Stainless steel						●		
Cast iron								●
Non ferrous metals						○		●
Heat resistant alloys								○

→ v_c Page 42

Right hand external thread turning insert

▲ Full profile

▲ Trapezoidal thread DIN 103

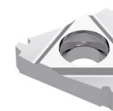
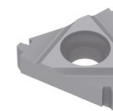
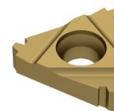
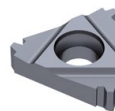


CCN20

CWN1525

HCN2525

CWK20



Designation	TP	INSL	PDX	PDY	ER X3		ER X3		ER X3		ER Y1	
					Article no.		Article no.		Article no.		Article no.	
	mm	mm	mm	mm	71 232 ...		71 232 ...		71 232 ...		71 232 ...	
					EUR		EUR		EUR		EUR	
16 ER 1,5	1,5	16	1,0	1,1	23,68	240					15,89	640
16 ER 2,0	2,0	16	1,1	1,3	23,68	242					15,89	642
16 ER 2,0	2,0	16	1,0	1,3			22,27	142	25,07	742		
16 ER 3,0	3,0	16	1,3	1,5	23,68	244	21,18	144			15,89	644
22 ER 4,0	4,0	22	1,7	1,9	32,65	270					22,27	670
22 ER 4,0	4,0	22	1,8	1,9			30,26	170	34,15	770		
22 ER 5,0	5,0	22	2,0	2,4			33,30	172				
22 ER 5,0	5,0	22	2,1	2,5	34,05	272					23,45	672
22 ER 6,0	6,0	22	2,3	2,7	35,45	274					24,64	674
22 EN 6,0	6,0	22	2,0	11,0	35,45	276 ¹⁾					24,64	676 ¹⁾
22 EN 7,0	7,0	22	2,3	11,0	36,87	278 ¹⁾					25,73	678 ¹⁾
Steel					●		●		○			
Stainless steel					●		○		●			
Cast iron									○		●	
Non ferrous metals					○		●		○		●	
Heat resistant alloys									○		○	

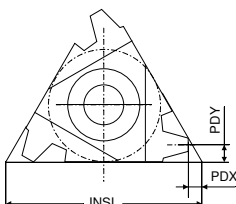
1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

→ v_c Page 42

Left hand external thread turning insert

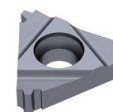
▲ Full profile

▲ Trapezoidal thread DIN 103



CCN20

CWK20



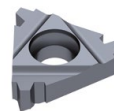
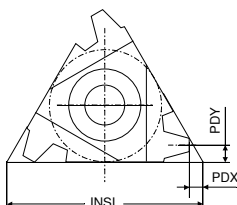
Designation	TP	INSL	PDX	PDY	EL X3		EL Y1	
					Article no.		Article no.	
	mm	mm	mm	mm	71 234 ...		71 234 ...	
					EUR		EUR	
16 EL 1,5	1,5	16	1,0	1,1	27,46	240	19,14	640
16 EL 2,0	2,0	16	1,1	1,3	27,46	242	19,14	642
16 EL 3,0	3,0	16	1,3	1,5	27,46	244	19,14	644
22 EL 4,0	4,0	22	1,7	1,9	38,26	270	26,70	670
22 EL 5,0	5,0	22	2,1	2,5	39,99	272	28,22	672
22 EL 6,0	6,0	22	2,3	2,7	41,61	274	29,40	674
Steel						●		
Stainless steel						●		
Cast iron								●
Non ferrous metals						○		●
Heat resistant alloys								○

→ v_c Page 42

Right hand internal thread turning insert

▲ Full profile

▲ Trapezoidal thread DIN 103



Designation	TP	INSL	PDX	PDY	IR X3		IR X3		IR Y1	
					Article no. 71 236 ...		Article no. 71 236 ...		Article no. 71 236 ...	
	mm	mm	mm	mm	EUR		EUR		EUR	
11 IR 1,5	1,5	11	0,8	0,9	23,45	210			15,89	610
16 IR 1,5	1,5	16	1,0	1,1	23,45	240			15,89	640
16 IR 2,0	2,0	16	1,1	1,3	23,45	242			15,89	642
16 IR 3,0	3,0	16	1,3	1,5	23,45	244	24,22	144	15,89	644
22 IR 4,0	4,0	22	1,8	1,9			31,89	170		
22 IR 4,0	4,0	22	1,7	1,9	32,65	270			22,27	670
22 IR 5,0	5,0	22	2,0	2,4			33,07	172		
22 IR 5,0	5,0	22	2,1	2,5	34,05	272			23,45	672
22 IR 6,0	6,0	22	2,3	2,7	35,45	274			24,64	674
22 IN 6,0	6,0	22	2,0	11,0	35,45	276 ¹⁾			24,64	676 ¹⁾
22 IN 7,0	7,0	22	2,3	11,0	36,87	278 ¹⁾			25,73	678 ¹⁾
Steel					●		●			
Stainless steel					●		○			
Cast iron							●		●	
Non ferrous metals					○		●		●	
Heat resistant alloys									○	

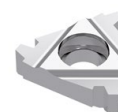
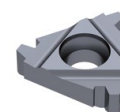
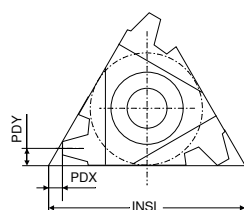
1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

→ v_c Page 42

Left hand internal thread turning insert

▲ Full profile

▲ Trapezoidal thread DIN 103



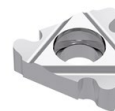
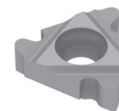
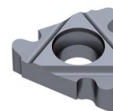
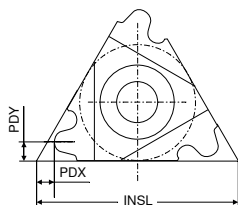
Designation	TP	INSL	PDX	PDY	IL X3		IL Y1	
					Article no. 71 238 ...		Article no. 71 238 ...	
	mm	mm	mm	mm	EUR		EUR	
11 IL 1,5	1,5	11	0,8	0,9	27,46	210	19,14	610
16 IL 1,5	1,5	16	1,0	1,1	27,46	240	19,14	640
16 IL 2,0	2,0	16	1,1	1,3	27,46	242	19,14	642
16 IL 3,0	3,0	16	1,3	1,5	27,46	244	19,14	644
22 IL 4,0	4,0	22	1,7	1,9	38,26	270	26,70	670
22 IL 5,0	5,0	22	2,1	2,5	38,26	272	26,70	672
22 IL 6,0	6,0	22	2,3	2,7	39,99	274	28,22	674
Steel						●		
Stainless steel						●		
Cast iron								●
Non ferrous metals						○		●
Heat resistant alloys								○

→ v_c Page 42

Right hand external thread turning insert

▲ Full profile

▲ Round thread DIN 405



Designation	TPI	INSL	PDX	PDY	ER X3		ER X3		ER Y1	
					Article no. 71 248 ...		Article no. 71 248 ...		Article no. 71 248 ...	
	1/"	mm	mm	mm	EUR		EUR		EUR	
16 ER 10	10	16	1,1	1,2	23,45	240			15,89	640
16 ER 8	8	16	1,4	1,3	23,45	242			15,89	642
16 ER 6	6	16	1,5	1,7	23,45	246	26,81	746	15,89	646
22 ER 6	6	22	1,5	1,7	32,76	270			22,48	670
22 ER 4	4	22	2,2	2,3	35,45	272			24,64	672
Steel					●		○			
Stainless steel					●		●			
Cast iron							○		●	
Non ferrous metals					○		○		●	
Heat resistant alloys							○		○	

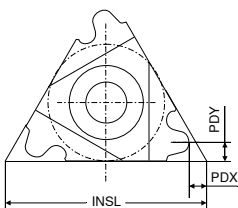
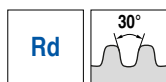
→ v_c Page 42

8

Left hand external thread turning insert

▲ Full profile

▲ Round thread DIN 405



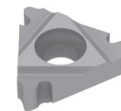
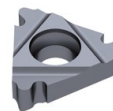
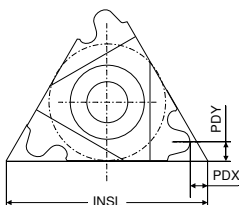
Designation	TPI	INSL	PDX	PDY	EL X3		EL Y1	
					Article no. 71 250 ...		Article no. 71 250 ...	
	1/"	mm	mm	mm	EUR		EUR	
16 EL 10	10	16	1,1	1,2	27,35	240	19,14	640
16 EL 8	8	16	1,4	1,3	27,35	242	19,14	642
16 EL 6	6	16	1,5	1,7	27,35	246	19,14	646
22 EL 6	6	22	1,5	1,7	38,37	270	26,81	670
22 EL 4	4	22	2,2	2,3	41,61	272	29,40	672
Steel							●	
Stainless steel							●	
Cast iron								●
Non ferrous metals					○		○	●
Heat resistant alloys								○

→ v_c Page 42

Right hand internal thread turning insert

▲ Full profile

▲ Round thread DIN 405



Designation	TPI	INSL	PDX	PDY	IR X3		IR X3		IR Y1	
					Article no. 71 252 ...		Article no. 71 252 ...		Article no. 71 252 ...	
	1/''	mm	mm	mm	EUR		EUR		EUR	
16 IR 10	10	16	1,1	1,2	23,45	240			15,89	640
16 IR 8	8	16	1,4	1,4	23,45	242			15,89	642
16 IR 6	6	16	1,4	1,5	23,45	246	27,13	746	15,89	646
22 IR 6	6	22	1,5	1,7	32,76	270			22,48	670
22 IR 4	4	22	2,2	2,3	35,45	272			24,64	672

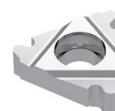
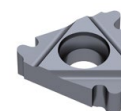
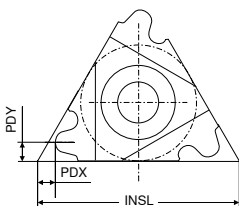
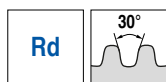
Steel	●	○
Stainless steel	●	●
Cast iron		○
Non ferrous metals	○	○
Heat resistant alloys		○

→ v_c Page 42

Left hand internal thread turning insert

▲ Full profile

▲ Round thread DIN 405



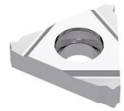
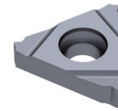
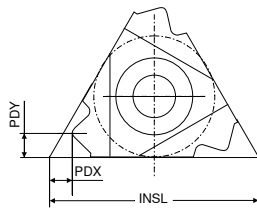
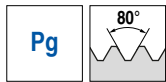
Designation	TPI	INSL	PDX	PDY	IL X3		IL Y1	
					Article no. 71 254 ...		Article no. 71 254 ...	
	1/''	mm	mm	mm	EUR		EUR	
16 IL 10	10	16	1,1	1,2	21,94	240	19,14	640
16 IL 8	8	16	1,4	1,4	21,94	242	19,14	642
16 IL 6	6	16	1,4	1,5	21,94	246	19,14	646
22 IL 6	6	22	1,5	1,7	30,80	270	26,81	670
22 IL 4	4	22	2,2	2,3	33,19	272	29,40	672

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	○
Heat resistant alloys	○

→ v_c Page 42

Right hand external thread turning insert

- ▲ Full profile
- ▲ Conduit thread DIN 40430



Designation	TPI	INSL	PDX	PDY
	1/''	mm	mm	mm
16 ER 20	20	16	0,8	0,8
16 ER 18	18	16	0,8	0,9
16 ER 16	16	16	0,8	1,0

ER X3	ER Y1
Article no.	Article no.
71 240 ...	71 240 ...
EUR	EUR
23,45 240	15,89 640
23,45 242	15,89 642
23,45 244	15,89 644

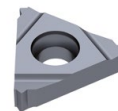
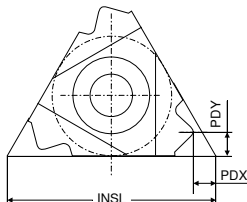
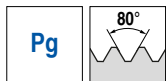
Steel	•
Stainless steel	•
Cast iron	•
Non ferrous metals	○
Heat resistant alloys	○

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Left hand external thread turning insert

- ▲ Full profile
- ▲ Conduit thread DIN 40430



Designation	TPI	INSL	PDX	PDY
	1/''	mm	mm	mm
16 EL 20	20	16	0,8	0,8
16 EL 18	18	16	0,8	0,9
16 EL 16	16	16	0,8	1,0

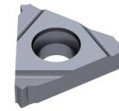
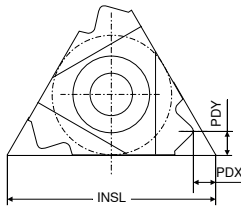
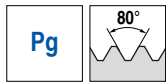
EL X3	EL Y1
Article no.	Article no.
71 242 ...	71 242 ...
EUR	EUR
25,83 240	17,72 640
25,83 242	17,72 642
25,83 244	17,72 644

Steel	•
Stainless steel	•
Cast iron	•
Non ferrous metals	○
Heat resistant alloys	○

→ v_c Page 42

Right hand internal thread turning insert

- ▲ Full profile
- ▲ Conduit thread DIN 40430

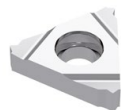
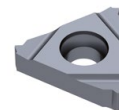
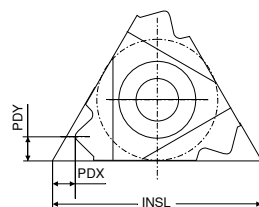


Designation	TPI	INSL	PDX	PDY	IR X3		IR Y1	
					Article no. 71 244 ...		Article no. 71 244 ...	
	1/"	mm	mm	mm	EUR		EUR	
11 IR 18	18	11	0,8	0,9	23,45	238	15,89	638
16 IR 18	18	16	0,8	0,9	23,45	242	15,89	642
16 IR 16	16	16	0,8	1,0	23,45	244	15,89	644
Steel					●			
Stainless steel					●			
Cast iron							●	
Non ferrous metals					○		●	
Heat resistant alloys							○	

→ v_c Page 42

Left hand internal thread turning insert

- ▲ Full profile
- ▲ Conduit thread DIN 40430



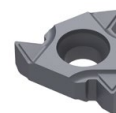
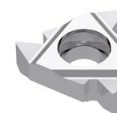
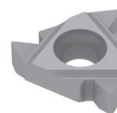
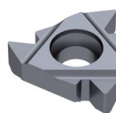
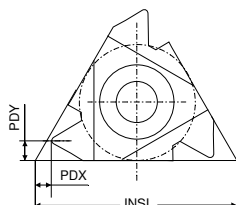
Designation	TPI	INSL	PDX	PDY	IL X3		IL Y1	
					Article no. 71 246 ...		Article no. 71 246 ...	
	1/"	mm	mm	mm	EUR		EUR	
11 IL 18	18	11	0,8	0,9	25,83	238	17,72	638
16 IL 18	18	16	0,8	0,9	25,83	242	17,72	642
16 IL 16	16	16	0,8	1,0	25,83	244	17,72	644
Steel					●			
Stainless steel					●			
Cast iron							●	
Non ferrous metals					○		●	
Heat resistant alloys							○	

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Right hand external thread turning insert

▲ Partial profile

▲ CCN7525 grade with sintered chip breaker for universal application



Designation	TP	INSL	PDX	PDY	ER X3		ER X3		ER X3		ER Y1		ER X3	
					Article no. 71 206 ...		Article no. 71 206 ...		Article no. 71 206 ...		Article no. 71 206 ...		Article no. 71 206 ...	
	mm	mm	mm	mm	EUR		EUR		EUR		EUR		EUR	
16 ER A60	0,5 - 1,5	16	0,8	0,9	18,16	240	16,22	140	17,95	740	11,78	640	17,95	940
16 ER G60	1,75 - 3	16	1,2	1,7	18,70	242	17,62	142	19,14	742	12,11	642	19,14	942
16 ER AG60	0,5 - 3	16	1,2	1,7	18,70	244	15,56	144	17,18	744	12,11	644	17,18	944
22 ER N60	3,5 - 5	22	1,7	2,5	29,18	270	29,94	170			19,56	670		
22 EN U60	5,5 - 8	22	0,9	11,0	29,18	272 ¹⁾					19,56	672 ¹⁾		

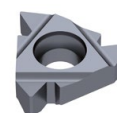
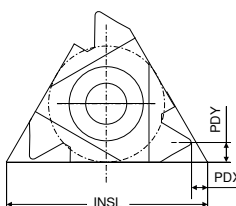
Steel	•	•	•	•
Stainless steel	•	•	•	•
Cast iron	•	•	•	•
Non ferrous metals	•	•	•	•
Heat resistant alloys	•	•	•	•

1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

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Left hand external thread turning insert

▲ Partial profile



Designation	TP	INSL	PDX	PDY	EL X3		EL Y1	
					Article no. 71 208 ...		Article no. 71 208 ...	
	mm	mm	mm	mm	EUR		EUR	
16 EL A60	0,5 - 1,5	16	0,8	0,9	19,90	240	13,08	640
16 EL G60	1,75 - 3	16	1,2	1,7	20,98	242	14,37	642
16 EL AG60	0,5 - 3	16	1,2	1,7	20,98	244	14,37	644
22 EL N60	3,5 - 5	22	1,7	2,5	34,05	270	23,45	670

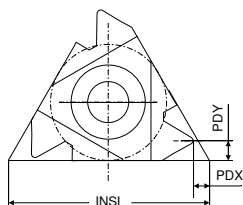
Steel	•	•	•	•
Stainless steel	•	•	•	•
Cast iron	•	•	•	•
Non ferrous metals	•	•	•	•
Heat resistant alloys	•	•	•	•

→ v_c Page 42

Right hand internal thread turning insert

▲ Partial profile

▲ CCN7525 grade with sintered chip breaker for universal application



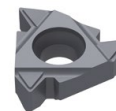
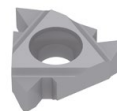
CCN20

CWN1525

HCN2525

CWK20

CCN7525



Designation	TP	INSL	PDX	PDY	IR X3		IR X3		IR X3		IR Y1		IR X3	
					Article no.		Article no.		Article no.		Article no.		Article no.	
					71 210 ...		71 210 ...		71 210 ...		71 210 ...		71 210 ...	
	mm	mm	mm	mm	EUR		EUR		EUR		EUR		EUR	
11 IR A60	0,5 - 1,5	11	0,8	0,9	18,16	210	16,54	110			11,78	610		
16 IR A60	0,5 - 1,5	16	0,8	0,9	18,16	240	20,00	140			11,78	640		
16 IR G60	1,75 - 3	16	1,2	1,7	18,70	242	17,62	142			12,11	642		
16 IR AG60	0,5 - 3	16	1,2	1,7	18,70	244	16,54	144	18,16	744	12,11	644	18,16	944
22 IR N60	3,5 - 5	22	1,7	2,5	29,18	270	28,22	170			19,56	670		
22 IN U60	5,5 - 8	22	0,9	11,0	29,18	272 ¹⁾					19,56	672 ¹⁾		

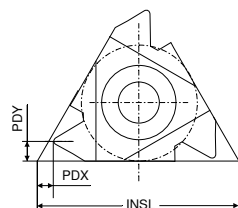
Steel	•	•	•	•
Stainless steel	•	•	•	•
Cast iron	•	•	•	•
Non ferrous metals	•	•	•	•
Heat resistant alloys	•	•	•	•

1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

→ v_c Page 42

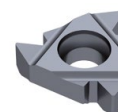
Left hand internal thread turning insert

▲ Partial profile



CCN20

CWK20



Designation	TP	INSL	PDX	PDY	IL X3		IL Y1	
					Article no.		Article no.	
					71 212 ...		71 212 ...	
	mm	mm	mm	mm	EUR		EUR	
11 IL A60	0,5 - 1,5	11	0,8	0,9	19,90	210	13,08	610
16 IL A60	0,5 - 1,5	16	0,8	0,9	19,90	240	13,08	640
16 IL G60	1,75 - 3	16	1,2	1,7	20,98	242	14,37	642
16 IL AG60	0,5 - 3	16	1,2	1,7	20,98	244	14,37	644
22 IL N60	3,5 - 5	22	1,7	2,5	34,05	270	23,45	670

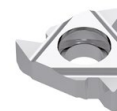
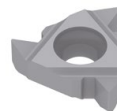
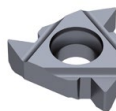
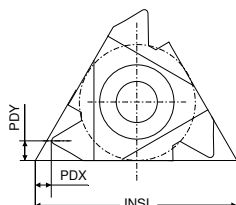
Steel	•	•	•	•
Stainless steel	•	•	•	•
Cast iron	•	•	•	•
Non ferrous metals	•	•	•	•
Heat resistant alloys	•	•	•	•

→ v_c Page 42

Right hand external thread turning insert

▲ Partial profile

▲ CCN7525 grade with sintered chip breaker for universal application



Designation	TPI	INSL	PDX	PDY	ER X3		ER X3		ER X3		ER Y1		ER X3	
					Article no. 71 200 ...	EUR	Article no. 71 200 ...	EUR	Article no. 71 200 ...	EUR	Article no. 71 200 ...	EUR	Article no. 71 200 ...	EUR
16 ER A55	48 - 16	16	0,8	0,9	19,02	240	19,46	140	20,75	740	13,29	640	20,75	940
16 ER AG55	48 - 8	16	1,2	1,7	20,32	244	17,62	144	19,14	744	13,29	644	19,14	944
16 ER G55	14 - 8	16	1,2	1,7	20,32	242	19,46	142	21,08	742	13,29	642	21,08	942
22 ER N55	7 - 5	22	1,7	2,5	31,68	270	31,89	170	34,69	770	21,40	670		
22 EN U55	4,5 - 3,25	22	0,9	11,0	31,68	272 ¹⁾					21,40	672 ¹⁾		

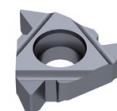
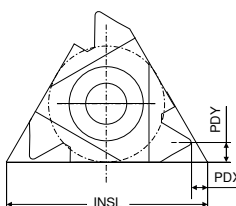
Steel	•	•	•	•
Stainless steel	•	•	•	•
Cast iron	•	•	•	•
Non ferrous metals	•	•	•	•
Heat resistant alloys	•	•	•	•

1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

→ v_c Page 42

Left hand external thread turning insert

▲ Partial profile



Designation	TPI	INSL	PDX	PDY	EL X3		EL Y1	
					Article no. 71 202 ...	EUR	Article no. 71 202 ...	EUR
16 EL A55	48 - 16	16	0,8	0,9	21,83	240	14,60	640
16 EL AG55	48 - 8	16	1,2	1,7	23,68	244	16,10	644
16 EL G55	14 - 8	16	1,2	1,7	23,68	242	16,10	642
22 EL N55	7 - 5	22	1,7	2,5	36,97	270	25,83	670

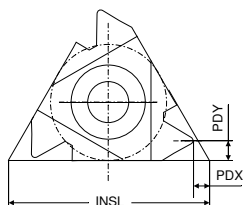
Steel	•	•
Stainless steel	•	•
Cast iron	•	•
Non ferrous metals	•	•
Heat resistant alloys	•	•

→ v_c Page 42

Right hand internal thread turning insert

▲ Partial profile

▲ CCN7525 grade with sintered chip breaker for universal application

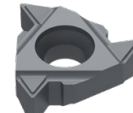
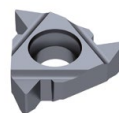


CCN20

CWN1525

CWK20

CCN7525



Designation	TPI	INSL	PDX	PDY	IR X3		IR X3		IR Y1		IR X3	
					Article no. 71 204 ...	EUR	Article no. 71 204 ...	EUR	Article no. 71 204 ...	EUR	Article no. 71 204 ...	EUR
11 IR A55	48 - 16	11	0,8	0,9	19,02	210			13,29	610		
16 IR A55	48 - 16	16	0,8	0,9	19,02	240			13,29	640		
16 IR AG55	48 - 8	16	1,2	1,7	20,32	244			13,29	644		
16 IR G55	14 - 8	16	1,2	1,7	20,32	242	19,46	142	13,29	642	21,08	942
22 IR N55	7 - 5	22	1,7	2,5	31,68	270			21,40	670		
22 IN U55	4,5 - 3,25	22	0,9	11,0	31,68	272 ¹⁾			21,40	672 ¹⁾		

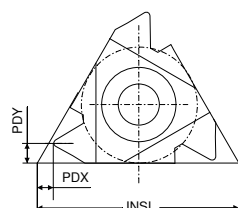
Steel	●	●	●
Stainless steel	●	○	●
Cast iron		●	●
Non ferrous metals	○	●	○
Heat resistant alloys			○

1) Neutral version (N) – for right and left hand thread applications. Neutral Toolholder marked (U) is required.

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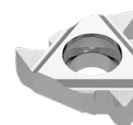
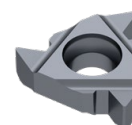
Left hand internal thread turning insert

▲ Partial profile



CCN20

CWK20



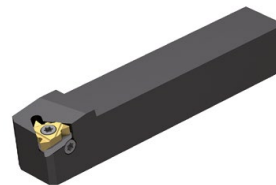
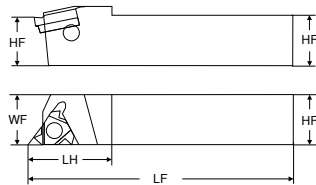
Designation	TPI	INSL	PDX	PDY	IL X3		IL Y1	
					Article no. 71 203 ...	EUR	Article no. 71 203 ...	EUR
11 IL A55	48 - 16	11	0,8	0,9	21,83	210	14,60	610
16 IL A55	48 - 16	16	0,8	0,9	21,83	240	14,60	640
16 IL AG55	48 - 8	16	1,2	1,7	23,68	244	16,10	644
16 IL G55	14 - 8	16	1,2	1,7	23,68	242	16,10	642
22 IL N55	7 - 5	22	1,7	2,5	36,97	270	25,83	670

Steel	●	●
Stainless steel	●	●
Cast iron		●
Non ferrous metals	○	●
Heat resistant alloys		○

→ v_c Page 42

Standard External Thread Turning Holder

▲ Tool Holder with Approach Angle $\beta = 1,5^\circ$



Illustrations show right-hand versions

Designation	HF mm	WF mm	LF mm	LH mm	Insert	Left-hand Y2		Right-hand Y2	
						Article no. 71 281 ... EUR		Article no. 71 280 ... EUR	
SE R/L 08 08 H11	8	11	100	16	11 ..	66,79	908 ²⁾	66,79	908 ²⁾
SE R/L 10 10 H11	10	12	100	18	11 ..	71,20	910 ²⁾	71,20	910 ²⁾
SE R/L 12 12 K11	12	12	125	20	11 ..	74,87	912 ²⁾	74,87	912 ²⁾
SE R/L 12 12 F16	12	16	80	22	16 ..	78,01	012	78,01	012
SE R/L 16 16 H16	16	16	100	25	16 ..	96,05	016	96,05	016
SE R/L 20 20 K16	20	20	125	30	16 ..	96,05	020	96,05	020
SE R/L 25 25 M16	25	25	150	30	16 ..	110,10	025	110,10	025
SE R/L 32 32 P16	32	32	170	30	16 ..	120,60	032	120,60	032
SE R/L 25 25 M22	25	25	150	32	22 ..	120,60	125	120,60	125
SE R 32 32 P22	32	32	170	34	22 ..			125,90	132
SE R 32 32 P22U	32	21	170	32	22 ..N			125,90	232 ¹⁾

1) Neutral insert indicated by marking (N)

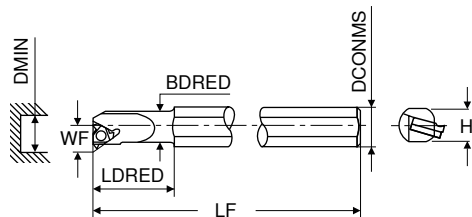
2) without shim

		Y2		Y2		Y2		Y7		Y2	
Spare parts		Article no. 71 950 ... EUR		Article no. 71 950 ... EUR		Article no. 71 950 ... EUR		Article no. 80 950 ... EUR		Article no. 71 950 ... EUR	
for Article no.											
71 280 908 / 71 281 908								T08		110	
71 280 910 / 71 281 910								T08		110	
71 280 912 / 71 281 912								T08		110	
71 280 012	ER 16 / IL 16	12,48	101	ER 16 / IL 16	9,26	121	1,09	234	T10	9,14	112
71 281 012	EL 16 / IR 16	12,48	108	EL 16 / IR 16	8,42	129	1,09	234	T10	9,14	112
71 280 016	ER 16 / IL 16	12,48	101	ER 16 / IL 16	9,26	121	1,09	234	T10	9,14	112
71 281 016	EL 16 / IR 16	12,48	108	EL 16 / IR 16	8,42	129	1,09	234	T10	9,14	112
71 280 020	ER 16 / IL 16	12,48	101	ER 16 / IL 16	9,26	121	1,09	234	T10	9,14	112
71 281 020	EL 16 / IR 16	12,48	108	EL 16 / IR 16	8,42	129	1,09	234	T10	9,14	112
71 280 025	ER 16 / IL 16	12,48	101	ER 16 / IL 16	9,26	121	1,09	234	T10	9,14	112
71 281 025	EL 16 / IR 16	12,48	108	EL 16 / IR 16	8,42	129	1,09	234	T10	9,14	112
71 280 032	ER 16 / IL 16	12,48	101	ER 16 / IL 16	9,26	121	1,09	234	T10	9,14	112
71 281 032	EL 16 / IR 16	12,48	108	EL 16 / IR 16	8,42	129	1,09	234	T10	9,14	112
71 280 125	ER 22 / IL 22	15,10	110	ER 22 / IL 22	13,42	137	1,65	235	T20	9,95	114
71 281 125	EL 22 / IR 22	15,10	115	EL 22 / IR 22	13,42	145	1,65	235	T20	9,95	114
71 280 132				ER 22 / IL 22	13,42	137	1,65	235	T20	9,95	114
71 280 232				ER 22U / IL 22U	13,42	153	1,65	235	T20	9,95	114

Shims for correction of helix angle see page → Page 39.

Standard Internal Thread Turning Holder

▲ Tool Holder with Approach Angle $\beta = 1,5^\circ$



Illustrations show right-hand versions



Designation	H mm	LF mm	LDRED mm	DCONMS mm	BDRED mm	WF mm	DMIN mm	Insert	Left-hand Y2		Right-hand Y2	
									Article no. 71 283 ...		Article no. 71 282 ...	
									EUR		EUR	
SI R 0010 H11	9,0	100	25	10	9,5	7,4	12	11 ..	84,09	010 ¹⁾	110,10	011 ¹⁾
SI R/L 0010 K11	14,0	125	25	16	10,0	7,4	12	11 ..			84,09	010 ¹⁾
SI R 0013 L11	14,0	140	32	16	12,0	8,9	15	11 ..			90,07	013 ¹⁾
SI R/L 0013 M16	14,0	150	32	16	13,0	10,2	16	16 ..	91,64	015 ¹⁾	91,64	015 ¹⁾
SI R/L 0016 P16	18,0	170	40	20	15,0	11,7	19	16 ..	91,64	016 ¹⁾	91,64	016 ¹⁾
SI R/L 0020 P16	18,0	170	40	20	19,5	13,7	24	16 ..	108,10	020	108,10	020
SI R 0025 R16	22,6	200	40	25	24,5	16,2	29	16 ..	141,60	032	131,10	026
SI R/L 0032 S16	28,8	250	50	32	31,5	19,7	36	16 ..			141,60	032
SI R 0040 T16	36,0	300	50	40	39,5	23,7	44	16 ..			209,70	040
SI R 0020 P22	18,0	170	40	20	19,5	15,6	24	22 ..	118,50	126	102,10	120 ¹⁾
SI R/L 0025 R22	22,6	200	40	25	24,5	18,1	29	22 ..			131,10	126
SI R 0032 S22	28,8	250	50	32	31,5	21,6	38	22 ..			145,70	132
SI R 0040 T22	36,0	300	60	40	39,5	25,6	46	22 ..			215,00	140
SI R 0032 S22U	28,8	250	60	32	31,5	24,4	38	22 ..N			122,70	133 ²⁾

1) without shim

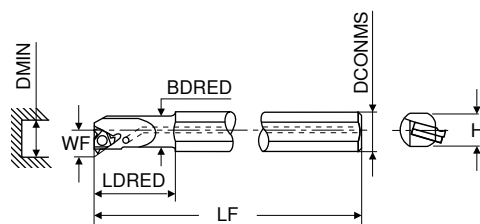
2) Neutral insert indicated by marking (N)

		Y2  Multi tooth shim				Y2  Shim				Y2  Screw-U				Y7  Key D				Y2  Clamping screw	
Spare parts		Article no. 71 950 ...		Article no. 71 950 ...		Article no. 71 950 ...		Article no. 80 950 ...		Article no. 71 950 ...									
for Article no.		EUR		EUR		EUR		EUR		EUR									
71 282 011								T08	7,80	110	1,09	230							
71 282 010 / 71 283 010								T08	7,80	110	1,09	230							
71 282 013								T08	7,80	110	1,09	230							
71 282 015 / 71 283 015								T10	9,14	112	1,64	236							
71 282 016 / 71 283 016								T10	9,14	112	1,64	236							
71 282 020	EL 16 / IR 16	12,48	108	EL 16 / IR 16	8,42	129	1,09	234	T10	9,14	112	1,09	231						
71 283 020	ER 16 / IL 16	12,48	101	ER 16 / IL 16	9,26	121	1,09	234	T10	9,14	112	1,09	231						
71 282 026	EL 16 / IR 16	12,48	108	EL 16 / IR 16	8,42	129	1,09	234	T10	9,14	112	1,09	231						
71 282 032	EL 16 / IR 16	12,48	108	EL 16 / IR 16	8,42	129	1,09	234	T10	9,14	112	1,09	231						
71 283 032	ER 16 / IL 16	12,48	101	ER 16 / IL 16	9,26	121	1,09	234	T10	9,14	112	1,09	231						
71 282 040	EL 16 / IR 16	12,48	108	EL 16 / IR 16	8,42	129	1,09	234	T10	9,14	112	1,09	231						
71 282 120							1,09	234	T20	9,95	114	1,65	237						
71 282 126	EL 22 / IR 22	15,10	115	EL 22 / IR 22	13,42	145	1,65	235	T20	9,95	114	1,65	232						
71 283 126	ER 22 / IL 22	15,10	110	ER 22 / IL 22	13,42	137	1,65	235	T20	9,95	114	1,65	232						
71 282 132	EL 22 / IR 22	15,10	115	EL 22 / IR 22	13,42	145	1,65	235	T20	9,95	114	1,65	232						
71 282 140	EL 22 / IR 22	15,10	115	EL 22 / IR 22	13,42	145	1,65	235	T20	9,95	114	1,65	232						

❗ Shims for correction of helix angle see page → Page 39.

Standard Internal Thread Turning Holder with thro' coolant

▲ Tool Holder with Approach Angle $\beta = 1,5^\circ$

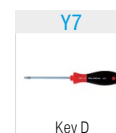


Illustrations show right-hand versions



Designation	H mm	LF mm	LDRED mm	DCONMS mm	BDRED mm	WF mm	DMIN mm	Insert	Left-hand Y2		Right-hand Y2	
									Article no. 71 283 ... EUR		Article no. 71 282 ... EUR	
SI R 0010 M11CB	9,0	150	25	10	9,5	7,4	12	11 ..			343,90	510 ²⁾
SI R 0012 P11CB	11,0	170	30	12	11,5	8,4	15	11 ..			365,90	512 ²⁾
SI R/L 0010 K11B	14,0	125	25	16	10,0	7,4	12	11 ..	100,80	310	100,80	310
SI R/L 0013 M16B	14,0	150	32	16	13,0	10,2	16	16 ..	110,10	315	110,10	315
SI R 0016 P16B	18,0	170	40	20	16,0	11,7	19	16 ..			110,10	316
SI R 0020 P16B	18,0	170	40	20	19,5	13,7	24	16 ..			128,90	320 ¹⁾
SI R/L 0032 S16B	28,8	250	50	32	31,5	19,7	36	16 ..	159,40	332 ¹⁾	159,40	332 ¹⁾

- 1) with shim seat
2) Carbide version



Spare parts

for Article no.

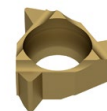
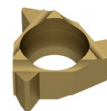
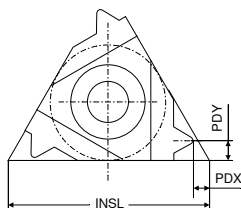
	Article no. 71 950 ... EUR	Article no. 71 950 ... EUR	Article no. 71 950 ... EUR	Article no. 80 950 ... EUR	Article no. 71 950 ... EUR
71 282 510				T08 7,80 110	1,09 230
71 282 512				T08 7,80 110	1,09 230
71 282 310 / 71 283 310				T08 7,80 110	1,09 230
71 282 315 / 71 283 315				T10 9,14 112	1,64 236
71 282 316				T10 9,14 112	1,64 236
71 282 320	EL 16 / IR 16 12,48 108	EL 16 / IR 16 8,42 129	1,09 234	T10 9,14 112	1,09 231
71 282 332	EL 16 / IR 16 12,48 108	EL 16 / IR 16 8,42 129	1,09 234	T10 9,14 112	1,09 231
71 283 332	ER 16 / IL 16 12,48 101	ER 16 / IL 16 9,26 121	1,09 234	T10 9,14 112	1,09 231

i Shims for correction of helix angle see page → Page 39.

Right hand internal thread turning insert – Mini size 06

▲ Full profile

▲ Thread production from diameter 6mm



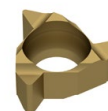
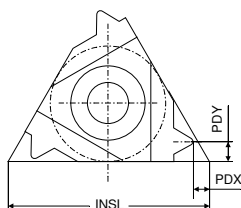
Designation	TP	PDX	PDY	INSL	HSS IR Y1		IR X3		IR Y1	
					Article no.		Article no.		Article no.	
					71 276 ...		71 271 ...		71 276 ...	
	mm	mm	mm	mm	EUR		EUR		EUR	
06 IR 0,5	0,50	0,9	0,5	6	24,10	710	22,37	110	24,10	310
06 IR 0,75	0,75	0,8	0,5	6	24,10	712	22,37	112	24,10	312
06 IR 1,0	1,00	0,7	0,6	6	24,10	714	22,37	114	24,10	314
06 IR 1,25	1,25	0,6	0,6	6	24,10	716	22,37	116	24,10	316
Steel					○		●		●	
Stainless steel					●		●		●	
Cast iron					○		●		○	
Non ferrous metals					○		○		○	
Heat resistant alloys									○	

→ v_c Page 42

Right hand internal thread turning insert – Mini size 06

▲ Full profile

▲ Thread production from diameter 6mm



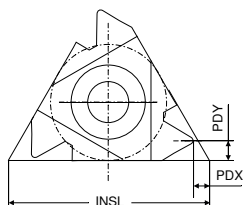
Designation	TPI	PDX	PDY	INSL	HSS IR Y1		IR Y1	
					Article no.		Article no.	
					71 278 ...		71 278 ...	
	1/"	mm	mm	mm	EUR		EUR	
06 IR 26	26	0,6	0,6	6	22,79	716	24,10	316
06 IR 22	22	0,6	0,6	6	27,24	720	24,10	320
06 IR 20	20	0,6	0,6	6	22,79	722	24,10	322
06 IR 19	19	0,6	0,6	6	22,79	724	24,10	324
06 IR 18	18	0,6	0,6	6	22,79	726	24,10	326
Steel					○		●	
Stainless steel					●		●	
Cast iron					○		○	
Non ferrous metals					○		○	
Heat resistant alloys							○	

→ v_c Page 42

Right hand internal thread turning insert – Mini size 06

▲ Partial profile

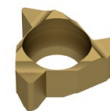
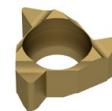
▲ Thread production from diameter 6mm



CWS80

CCN1525

CWN30



Designation	TP	INS	PDX	PDY	HSS		IR		IR	
					IR		Y1		X3	
	mm	mm	mm	mm	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
06 IR A60	0,5 - 1,25	6	0,6	0,6	71 272 ...	71 274 ...	71 272 ...	71 274 ...	71 272 ...	71 274 ...
					EUR	EUR	EUR	EUR	EUR	EUR
					24,10	22,37	24,10	22,37	24,10	22,37
					710	210	310	210	310	210
Steel					○	●	○	●	○	●
Stainless steel					●	○	●	○	●	○
Cast iron					○	○	○	○	○	○
Non ferrous metals					○	○	○	○	○	○
Heat resistant alloys					○	○	○	○	○	○

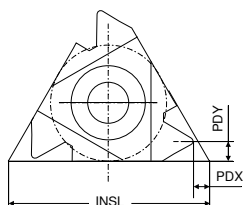
→ v_c Page 42

8

Right hand internal thread turning insert – Mini size 06

▲ Partial profile

▲ Thread production from diameter 6mm



CWS80

CWN30



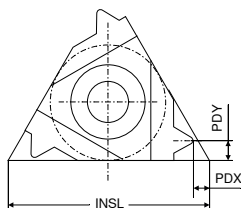
Designation	TPI	INS	PDX	PDY	HSS		IR		IR	
					IR		Y1		Y1	
	1/"	mm	mm	mm	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
06 IR A55	48 - 20	6	0,5	0,6	71 274 ...	71 274 ...	71 274 ...	71 274 ...	71 274 ...	71 274 ...
					EUR	EUR	EUR	EUR	EUR	EUR
					24,10	22,37	24,10	22,37	24,10	22,37
					710	210	310	210	310	210
Steel					○	●	○	●	○	●
Stainless steel					●	○	●	○	●	○
Cast iron					○	○	○	○	○	○
Non ferrous metals					○	○	○	○	○	○
Heat resistant alloys					○	○	○	○	○	○

→ v_c Page 42

Right hand internal thread turning insert – Mini size 08

▲ Full profile

▲ Thread production from diameter 8mm



Designation	TP	PDX	PDY	INSL
	mm	mm	mm	mm
08 IR 0,5	0,50	0,6	0,5	8
08 IR 0,75	0,75	0,6	0,5	8
08 IR 1,0	1,00	0,6	0,6	8
08 IR 1,25	1,25	0,6	0,7	8
08 IR 1,5	1,50	0,6	0,7	8
08 IR 1,75	1,75	0,6	0,8	8
08 IN 2,0	2,00	1,0	4,0	8

HSS IR Y1	Article no. 71 277 ...	IR Y1	Article no. 71 277 ...
EUR		EUR	
24,10	710	24,10	310
24,10	712	24,10	312
24,10	714	24,10	314
24,10	716	24,10	316
24,10	718	24,10	318
23,14	720	23,14	320
24,10	784 ¹⁾	24,10	384 ¹⁾

Steel	○	●
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys		○

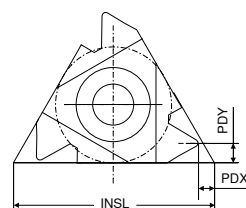
1) Neutral version (N)

→ v_c Page 42

Right hand internal thread turning insert – Mini size 08

▲ Partial profile

▲ Thread production from diameter 8mm



Designation	TP	PDX	PDY	INSL	HSS IR Y1	Article no. 71 273 ...	IR Y1	Article no. 71 273 ...
	mm	mm	mm	mm	EUR		EUR	
08 IR A60	0,5 - 1,5	0,6	0,7	8	24,10	710	24,10	310
08 IN M60	1,75 - 2,0	0,8	4,0	8	24,10	772 ¹⁾	24,10	372 ¹⁾

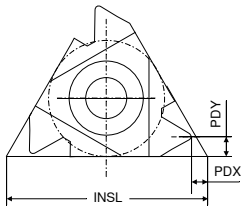
Steel	○	●
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys		○

1) Neutral version (N)

→ v_c Page 42

Right hand internal thread turning insert – Mini size 08

- ▲ Partial profile
- ▲ Thread production from diameter 8mm



CWS80

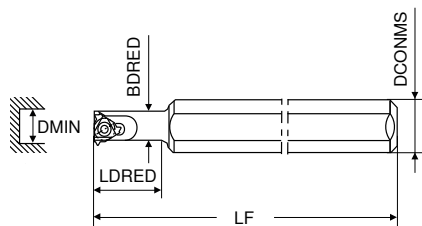
CWN30



Designation	TPI	INSL	PDX	PDY	HSS		IR	
					Y1		Y1	
	1/"	mm	mm	mm	Article no.		Article no.	
					71 275 ...		71 275 ...	
08 IR A55	48 - 16	8	0,6	0,7	EUR		EUR	
08 IN M55	14 - 11	8	0,9	4,0	24,10 710		24,10 310	
					24,10 772 1)		24,10 372 1)	
Steel					○		●	
Stainless steel					●		●	
Cast iron					○		○	
Non ferrous metals					○		○	
Heat resistant alloys							○	

1) Neutral version (N)

Right Hand Internal Thread Holder – Mini size 06



Designation	LF	LDRED	DCONMS	BDRED	DMIN	Insert	Right-hand Y2	
	mm	mm	mm	mm	mm		Article no.	
SI R 0005 H06	100	12	12	5,2	6	06 ..	71 294 ...	005
SI R 0005 H06 C	100	25	6	5,2	6	06 ..	EUR 112,20	105 ¹⁾
							EUR 205,50	

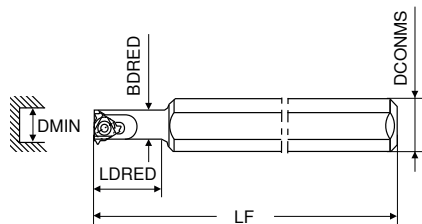
1) Solid Carbide Shank with Thro' Coolant

Spare parts

for Article no.

		Article no.	EUR		Article no.	EUR	
71 294 005	T06	80 950 ...	8,44	108	71 950 ...	1,88	029
71 294 105	T06		8,44	108		1,88	029

Right Hand Internal Thread Holder – Mini size 08



Designation	LF	LDRED	DCONMS	BDRED	DMIN	Insert	Right-hand Y2	
	mm	mm	mm	mm	mm		Article no.	
SI R 0007 K08	125	18	16	6,7	7,8	08 ..	71 295 ...	007
SI R 0007 K08U	125	21	16	7,5	9,0	08 .N	EUR 112,20	008 ¹⁾
SI R 0007 K08C	125	30	8	6,5	7,8	08 ..	EUR 125,90	107 ²⁾
							EUR 258,00	

1) Neutral insert indicated by marking (N)

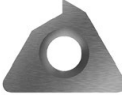
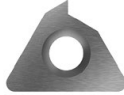
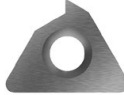
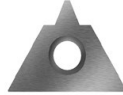
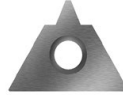
2) Solid Carbide Shank with Thro' Coolant

Spare parts

for Article no.

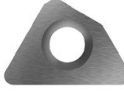
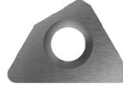
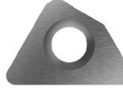
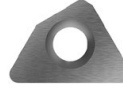
		Article no.	EUR		Article no.	EUR	
71 295 007	T06	80 950 ...	8,44	108	71 950 ...	1,88	033
71 295 008	T06		8,44	108		1,88	033
71 295 107	T06		8,44	108		1,88	033

Shims for Standard Threading Inserts

												
	AE 16		AI 16		AE 22		AI 22		AE 22 U		AI 22 U	
	ER 16 / IL 16		EL 16 / IR 16		ER 22 / IL 22		EL 22 / IR 22		ER 22 / IL 22		EL 22 / IR 22	
	Y2		Y2		Y2		Y2		Y2		Y2	
Pitch-angle β	Article no. 71 950 ...		Article no. 71 950 ...		Article no. 71 950 ...		Article no. 71 950 ...		Article no. 71 950 ...		Article no. 71 950 ...	
	EUR		EUR		EUR		EUR		EUR		EUR	
+ 4,5°	10,59	118	10,59	126	16,99	134	16,99	142	16,99	150 ¹⁾	16,99	158 ¹⁾
+ 3,5°	10,59	119	10,59	127	16,99	135	16,99	143	16,99	151 ¹⁾	16,99	159 ¹⁾
+ 2,5°	10,59	120	10,59	128	16,99	136	16,99	144	16,99	152 ¹⁾	16,99	160 ¹⁾
+ 1,5°	9,26	121	8,42	129	13,42	137	13,42	145	13,42	153 ¹⁾	13,42	161 ¹⁾
+ 0,5°	10,59	122	10,59	130	16,99	138	16,99	146	16,99	154 ¹⁾	16,99	162 ¹⁾
0°	10,59	123	10,59	131	16,99	139	16,99	147				
- 0,5°	10,59	124	10,59	132	16,99	140	16,99	148	16,99	156 ¹⁾	16,99	164 ¹⁾
- 1,5°	10,59	125	10,59	133	16,99	141	16,99	149	16,99	157 ¹⁾	16,99	165 ¹⁾

1) Neutral version for tool holder identified by (U).

Shims for Multi-Tooth Threading Inserts

								
	AE 16 M		AI 16 M		AE 22 M		AI 22 M	
	ER 16 / IL 16		EL 16 / IR 16		ER 22 / IL 22		EL 22 / IR 22	
	Y2		Y2		Y2		Y2	
Pitch-angle β	Article no. 71 950 ...		Article no. 71 950 ...		Article no. 71 950 ...		Article no. 71 950 ...	
	EUR		EUR		EUR		EUR	
+ 1,5°	12,48	101	12,48	108	15,10	110	15,10	115

Pitch angle

Important Information about Standard Shims

- ▲ the pitch angle should be determined through calculation or by using the chart below
- ▲ the standard WNT threading holder is supplied with a 1.5° inclined insert seat and a shim without angular correction.
Hence the WNT Tool holders are delivered with an angle of inclination β of 1.5°.

Without the appropriate correction of the helix angle, the following may occur

- ▲ the profile will be distorted.
- ▲ insufficient clearance angle.
- ▲ the tool life of the insert is greatly reduced.

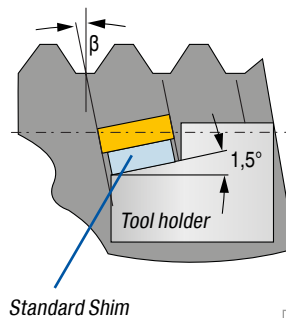


Method 1: Calculation

Calculating the helix angle β :

$$\beta = \frac{20 \times TP}{DMIN}$$

20 = constant
 β = Helix angle (°)
 TP = Pitch (mm)
 DMIN = Nominal diameter (mm)



Example calculation

External thread M24 x 1.5

Feed towards chuck

DMIN = Nominal Ø: M24 = 24 mm

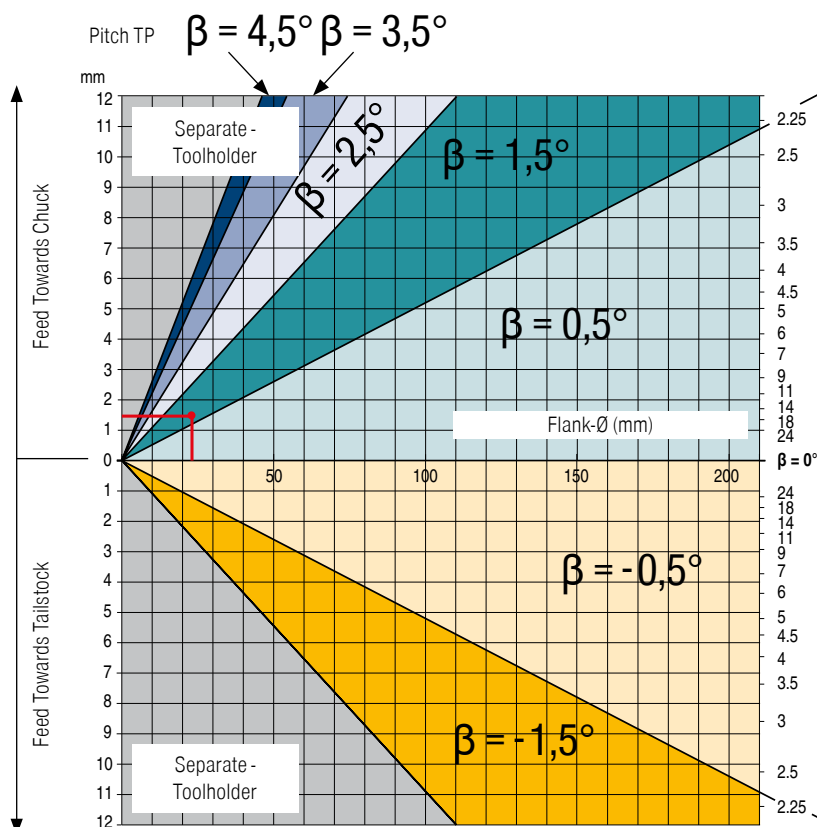
TP = Pitch: 1.5 mm

$$\beta = \frac{20 \times 1,5 \text{ mm}}{24 \text{ mm}}$$

$$\beta = 1,25^\circ$$

Method 2: Diagram

From the flank Ø in the diagram, a line is drawn vertically upwards until it intersects with the line of the pitch of the thread to be produced. In the color-coded region in which it is now, a horizontal line to the edge of the chart indicates the appropriate factor.



calculated pitch angle β value	Shim
0,0°–0,99°	0,5°
1,0°–1,99°	1,5°
2,0°–2,99°	2,5°
3,0°–3,99°	3,5°
4,0°–4,99°	4,5°
0,0°–(-0,99°)	-0,5°
-1,0°–(-1,99°)	-1,5°

Material examples referring to the cutting data tables

	Index	Material	Strength N/mm ² / HB / HRC	Material number	Material designation	Material number	Material designation	Material number	Material designation
P	1.1	General construction steel	< 800 N/mm ²	1.0402	EN3B				
	1.2	Free cutting steel	< 800 N/mm ²	1.0711	EN1A				
	1.3	Hardened steel, non alloyed	< 800 N/mm ²	1.0401	EN32C				
	1.4	Alloyed hardened steel	< 1000 N/mm ²	1.7325	25 CD4				
	1.5	Tempering steel, unalloyed	< 850 N/mm ²	1.5752	EN36	1.0535	EN9		
	1.6	Tempering steel, unalloyed	< 1000 N/mm ²	1.6582	EN24				
	1.7	Tempering steel, alloyed	< 800 N/mm ²	1.7225	EN19				
	1.8	Tempering steel, alloyed	< 1300 N/mm ²	1.8515	EN40B				
	1.9	Steel castings	< 850 N/mm ²	0.9650	G-X 260 Cr 27	1.6750	GS-20 NiCrMo 3.7	1.6582	GS-34 CrNiMo 6
	1.10	Nitriding steel	< 1000 N/mm ²	1.8509	EN41B				
	1.11	Nitriding steel	< 1200 N/mm ²	1.1186	EN8	1.1160	EN14A		
	1.12	Roller bearing steel	< 1200 N/mm ²	1.3505	534A99				
	1.13	Spring steel	< 1200 N/mm ²		EN45		EN47		EN43
	1.14	High-speed steel	< 1300 N/mm ²	1.3343	M2	1.3249	M34		
	1.15	Cold working tool steel	< 1300 N/mm ²	1.2379	D2	1.2311	P20		
	1.16	Hot working tool steel	< 1300 N/mm ²	1.2344	H13				
M	2.1	Cast steel and sulphured stainless steel	< 850 N/mm ²	1.4581	318				
	2.2	Stainless steel, ferritic	< 750 N/mm ²	1.4000	403				
	2.3	Stainless steel, martensitic	< 900 N/mm ²	1.4057	EN57				
	2.4	Stainless steel, ferritic / martensitic	< 1100 N/mm ²	1.4028	EN56B				
	2.5	Stainless steel, austenitic / ferritic	< 850 N/mm ²	1.4542	17-4PH				
	2.6	Stainless steel, austenitic	< 750 N/mm ²	1.4305	303	1.4401	316	1.4301	304
	2.7	Heat resistant steel	< 1100 N/mm ²	1.4876	Incoloy 800				
K	3.1	Grey cast iron with lamellar graphite	100–350 N/mm ²	0.6015	Grade 150	0.6020	Grade 220	0.6025	Grade 260
	3.2	Grey cast iron with lamellar graphite	300–500 N/mm ²	0.6030	Grade 300	0.6035	Grade 350	0.6040	Grade 400
	3.3	Gray cast iron with spheroidal graphite	300–500 N/mm ²	0.7040	SG 400-12	0.7043	SG 370-17	0.7050	SG 500-7
	3.4	Gray cast iron with spheroidal graphite	500–900 N/mm ²	0.7060	SG 600-3	0.7070	SG 700-2	0.7080	SG 800-2
	3.5	White malleable cast iron	270–450 N/mm ²	0.8035	GTW-35	0.8045	GTW-45		
	3.6	White malleable cast iron	500–650 N/mm ²	0.8055	GTW-55	0.8065	GTW-65		
	3.7	Black malleable cast iron	300–450 N/mm ²	0.8135	GTS-35	0.8145	GTS-45		
	3.8	Black malleable cast iron	500–800 N/mm ²	0.8155	GTS-55	0.8170	GTS-70		
N	4.1	Aluminium (non alloyed, low alloyed)	< 350 N/mm ²	3.0255	1050 A	3.0275	1070 A	3.0285	1080 A (A8)
	4.2	Aluminium alloys < 0.5 % Si	< 500 N/mm ²	3.1325	2017 A (AU4G)	3.4335	7005 (AZ5G)	3.4365	7075 (AZ5GU)
	4.3	Aluminium alloy 0.5–10 % Si	< 400 N/mm ²	3.2315	A-G S1	3.2373	A-S9 G	3.2151	A-S 6 U4
	4.4	Aluminium alloys 10–15 % Si	< 400 N/mm ²	3.2581	A-S12	3.2583	A-S12 U		
	4.5	Aluminum alloys > 15 % Si	< 400 N/mm ²		A-S18		A-S17 U4		
	4.6	Copper (non alloyed, low alloyed)	< 350 N/mm ²	2.0040	Cu-c1	2.0060	Cu-a1	2.0090	Cu-b1
	4.7	Copper wrought alloys	< 700 N/mm ²	2.1247	Cub2 (Beryllium Copper)	2.0855	CuN2S (Nickel Copper)	2.1310	CU-Fe2P
	4.8	Special copper alloys	< 200 HB	2.0916	Cu-A5	2.1525	Cu-S3 M		Ampco 8 (Cu-A6Fe2)
	4.9	Special copper alloys	< 300 HB	2.0978	Cu-A11 Fe5 Ni5		Ampco 18 (Cu- A10 Fe3)		
	4.10	Special copper alloys	> 300 HB	2.1247	Cu Be2		Ampco M4		
	4.11	Short-chipping brass, bronze, red bronze	< 600 N/mm ²	2.0331	Cu Zn36 Pb1,5	2.0380	Cu Zn39 Pb2 (Ms 56)	2.0410	Cu Zn44 Pb2
	4.12	Long-chipping brass	< 600 N/mm ²	2.0335	Cu Zn 36 (Ms63)	2.1293	Cu Cr1 Zr		
	4.13	Thermoplastics		PE	PVC	PS	Polystyrene		Plexiglas
	4.14	Duroplastics		PF	Bakelite		Pertinax		
	4.15	Fibre-reinforced plastics			Carbon Fibre		Fibreglass		Aramid Fibre (Kevlar)
	4.16	Magnesium and magnesium alloys	< 850 N/mm ²	3.5812	Mg A7 Z1	3.5662	Mg A9	3.5105	Mg Tr3 Z2 Zn 1
	4.17	Graphite			R8500X		R8650		Technograph 15
	4.18	Tungsten and tungsten alloys			W-Ni Fe (Densimet)		W- Ni Cu (Inermet)		Denal
	4.19	Molybdenum and molybdenum alloys			TZM		MHQ		Mo W
S	5.1	Pure nickel		2.4066	Ni99 (Nickel 200)	2.4068	Lc Ni99 (Nickel 201)		
	5.2	Nickel alloys		1.3912	Fe-Ni36 (Invar)	1.3917	Fe- Ni42 (N42)	1.3922	Fe-Ni48 (N48)
	5.3	Nickel alloys	< 850 N/mm ²	2.4375	Ni Cu30 Al (Monel K500)	2.4360	Ni Cu30Fe (Monel 400)	2.4668	
	5.4	Nickel molybdenum alloys		2.4600	Ni Mo30Cr2 (Hastelloy B4)	2.4617	Ni Mo28 (Hastelloy B2)	2.4819	Ni Mo16Cr16 Hastell. C276
	5.5	Nickel-chromium alloys	< 1300 N/mm ²	2.4951	Ni Cr20TiAl (Nimonic 80A)	2.4858	Ni Cr21Mo (Inconel 825)	2.4856	Ni Cr22Mo9Nb Inconel 625
	5.6	Cobalt Chrome Alloys	< 1300 N/mm ²	2.4964	Co Cr20 W15 Ni10		Co Cr20 Ni16 Mo7		Co Cr28 Mo 6
	5.7	Heat resistant alloys	< 1300 N/mm ²	1.4718	Z45 C S 9-3	1.4747	Z80 CSN 20-02	1.4845	Z12 CN 25-20
	5.8	Nickel-cobalt-chromium alloys	< 1400 N/mm ²	2.4851	Ni Cr23Fe (Inconel 601)	2.4668	Ni Cr19NbMo (Inconel 718)	2.4602	Ni Cr21Mo14 Hastelloy C22
	5.9	Pure titanium	< 900 N/mm ²	3.7025	T35 (Titanium Grade 1)	3.7034	T40 (Titanium Grade 2)	3.7064	T60 (Titanium Grade 4)
	5.10	Titanium alloys	< 700 N/mm ²		T-A6-Nb7 (367)		T-A5-Sn2-Mo4-Cr4 (Ti17)		T-A3-V2,5 (Gr18)
	5.11	Titanium alloys	< 1200 N/mm ²	3.7165	T-A6-V4 (Ta6V)		T-A4-3V-Mo2-Fe2 (SP700)		T-A5-Sn1-Zr1-V1-Mo (Gr32)
H	6.1		< 45 HRC						
	6.2		46–55 HRC						
	6.3	Tempered steel	56–60 HRC						
	6.4		61–65 HRC						
	6.5		65–70 HRC						

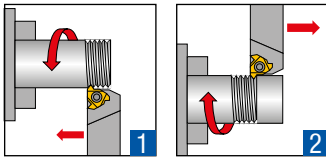
Cutting data approximate values

	Mini CWN30	Mini CWS80	Mini CCN1525	CWN1525	HCN2525	CCN7525	CCN20	CWK20
Index	v _c in m/min							
1.1	20-100	30-50	80-100	120-140	190-210	150-170	120-180	
1.2	20-100	30-50	80-100	120-140	190-210	150-170	140-200	
1.3	20-100	30-50	80-100	120-140	190-210	150-170	110-180	
1.4	20-80	25-40	60-80	70-90	120-140	90-110	100-155	
1.5	20-80	25-40	90-110	100-120	160-180	130-150	110-180	
1.6	20-80	25-40	90-110	100-120	160-180	130-150	100-155	
1.7	20-100	30-50	50-60	50-70	70-90	60-80	110-180	
1.8	20-80	25-40	50-60	50-70	70-90	60-80	80-135	
1.9	20-100	25-40	60-80	90-100	120-140	100-120		
1.10	20-80	25-40	50-60	50-60	60-80	50-70		
1.11	20-80	25-40	50-60	50-60	60-80	50-70		
1.12	20-80	25-40	50-60	50-60	60-80	50-70	80-135	
1.13		25-40	50-60	50-60	60-80	50-70		
1.14			50-60	50-60	60-80	50-70		
1.15			50-60	50-60	60-80	50-70		
1.16			50-60	50-60	60-80	50-70		
2.1	20-70	10-25	40-50	50-70	140-160	90-110	70-120	
2.2	20-70	10-25	40-50	50-70	140-160	90-110	70-120	
2.3	20-70	10-25	40-50	50-70	140-160	90-110	60-95	
2.4	20-70	10-25	40-50	50-70	140-160	90-110	60-95	
2.5	20-70	10-25	40-50	50-70	140-160	90-110	40-90	
2.6	20-70	10-25	40-50	50-70	140-160	90-110	70-100	
2.7	20-70	10-25	40-50	50-70	140-160	90-110	70-100	
3.1	40-90	20-40	60-80	90-110	140-150	120-130		70-100
3.2	40-90	20-40	60-80	90-110	140-150	120-130		70-100
3.3	40-90	20-40	60-80	90-110	140-150	120-130		70-100
3.4	40-90	20-40	60-80	90-110	140-150	120-130		70-100
3.5	40-90	20-40	50-70	80-100	120-130	100-110		70-100
3.6	40-90	20-40	50-70	80-100	120-130	100-110		70-100
3.7	40-90	20-40	50-70	80-100	120-130	100-110		70-100
3.8	40-90	20-40	50-70	80-100	120-130	100-110		70-100
4.1	80-180	40-100	550-570	600-650	800-900			100-250
4.2	80-180	40-100	300-330	480-520	800-900			100-250
4.3	60-150		300-330	480-520	800-900			100-250
4.4	60-130		300-330	480-520	800-900			100-250
4.5	40-120		300-330	480-520	800-900			100-250
4.6	80-150	40-80	120-150	200-220	300-320		80-200	100-250
4.7	80-150	40-80	110-130	180-200	280-300		80-200	100-250
4.8	80-150	40-80	110-130	160-180	250-280		80-200	100-250
4.9	80-150	40-80	110-130	160-180	250-280		80-200	100-250
4.10	80-150	40-80	100-120	150-170	220-250		80-200	100-250
4.11	80-150	40-80	100-120	180-200	230-240		80-200	100-250
4.12	80-150		100-120	180-200	230-240		80-200	100-250
4.13			180-200	250-300				
4.14			180-200	250-300				
4.15			180-200	250-300				
4.16			60-80	80-100	120-150			100-250
4.17			60-80	80-100	120-150	100-120		100-250
4.18			60-80	80-100	120-150			100-250
4.19			60-80	80-100	120-150			100-250
5.1					45-55	30-40		
5.2					45-55	30-40		20-30
5.3					45-55	30-40		20-30
5.4					45-55	30-40		20-30
5.5					35-40	25		20-30
5.6					35-40	25-35		20-30
5.7					35-40	25-35		
5.8					35-40	25-35		
5.9	20-90				40-50	35-45		25-50
5.10	20-90				40-50	35-45		20-30
5.11	20-90				40-50	35-45		20-30
6.1					50-60	45-55	40-60	
6.2					45-55		40-60	
6.3					40-45			
6.4					35-45			
6.5								

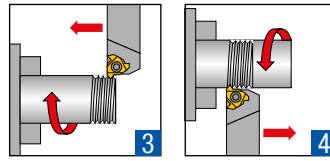
i The cutting data depends extremely on the external conditions, the material and machine type. The indicated values are possible values which have to be increased or reduced according to the application conditions.

Thread turning methods

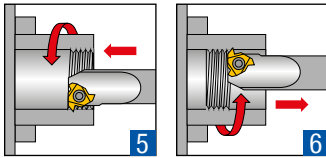
External right-hand thread



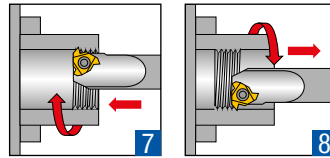
External left-hand thread



Internal right-hand thread



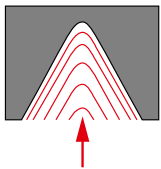
Internal left-hand thread



i The machining examples 2, 4, 6 and 8 require negative shims! These shims can be found on → **Page 39**.

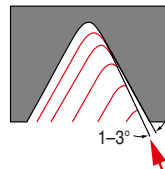
Thread infeed methods

Radial Infeed



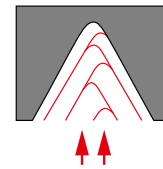
- ▲ for pitches less than 1.5 mm
- ▲ for short chipping materials
- ▲ for machining hardened materials
- ▲ simple and quick method

Flank infeed



- ▲ for pitches larger than 1.5 mm
- ▲ with radial penetration the effective cutting edge length is too large, which may lead to chattering
- ▲ with trapezoidal and ACME threads, chip flow on three sides can be problematic

Alternating infeed



- ▲ with large pitches
- ▲ for long chipping materials
- ▲ uniform wear of the cutting edges
- ▲ complicated programming process

8

Recommended number of cuts and cutting depths

Standard Threading Inserts

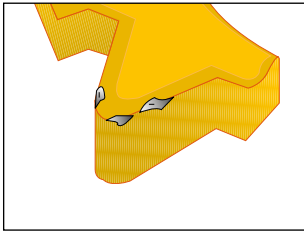
Pitch	mm	0,50	0,75	1,00	1,25	1,50	1,75	2,00	2,50	3,00	3,50	4,00	4,50	5,00	5,50	6,00	8,00
	TPI	48	32	24	20	16	14	12	10	8	7	6	5,5	5	4,5	4	3
Number of passes		4-6	4-7	4-8	5-9	6-10	7-12	7-12	8-14	9-16	10-18	11-18	11-19	12-20	12-20	12-20	15-24
Number of passes	(CCN7525)	3-4	3-4	3-5	4-6	5-6	6-8	6-8	8-10								
Number of passes	Mini Inserts	6-9	6-11	6-12	8-14	9-15	11-18	11-18									

Multi edge thread turning insert

Standard	Insert	Insert size		Pitch	Edges	Designation	Passes	Cutting depth per pass		
		IC	L mm					1	2	3
ISO external	M	3/8"	16	1,0 mm	3	3 ER 1.0 ISO 3M	2	0,38	0,25	
ISO external	M	3/8"	16	1,5 mm	2	3 ER 1.5 ISO 2M	3	0,42	0,30	0,20

Troubleshooting

Edge chipping



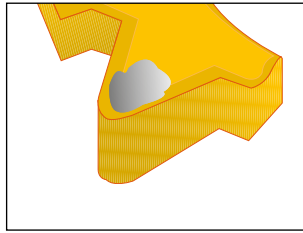
Cause

- ▲ Common in stainless materials
- ▲ Incorrect grade

Corrective measures

- ▲ Minimize tool overhang length
- ▲ Check that the insert is clamped
- ▲ Minimize vibration
- ▲ Use a tougher grade

Cratering



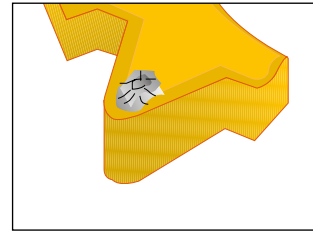
Cause

- ▲ Common in stainless materials
- ▲ Cutting speed too high
- ▲ Incorrect grade

Remedy

- ▲ Apply coolant
- ▲ Reduce depth of cut
- ▲ Use a harder grade

Built-up edge



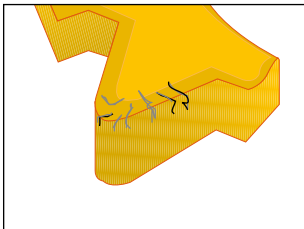
Cause

- ▲ Cutting speed too low
- ▲ Incorrect grade

Remedy

- ▲ Apply coolant
- ▲ Increase cutting speed
- ▲ Use a tougher grade

Thermal cracking



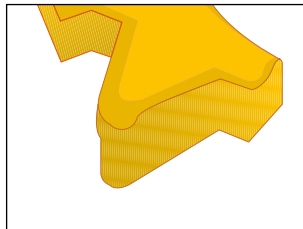
Cause

- ▲ Insufficient coolant
- ▲ Cutting speed too high
- ▲ Incorrect grade

Remedy

- ▲ Apply coolant
- ▲ Reduce cutting speed
- ▲ Use a tougher grade

Plastic deformation



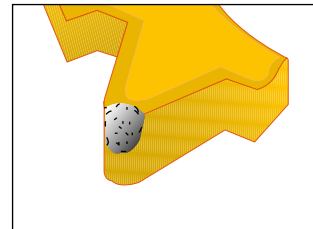
Cause

- ▲ Infeed too large
- ▲ Insufficient coolant
- ▲ Cutting speed too high
- ▲ Incorrect grade

Remedy

- ▲ Apply coolant
- ▲ Reduce depth of cut
- ▲ Reduce cutting speed
- ▲ Use a harder grade

Breakage



Cause

- ▲ Infeed too large
- ▲ Insufficient coolant
- ▲ Plastic deformation
- ▲ Instability
- ▲ Helix angle not appropriate
- ▲ Incorrect grade

Remedy

- ▲ Reduce depth of cut
- ▲ Check machine and tool stability
- ▲ Reduce cutting speed
- ▲ Check helix angle
- ▲ Use a tougher grade

Grade description

Universal

CCN7525

- ▲ Carbide, TiAlN-coated
- ▲ ISO | **P25** | **M25** | **K25** | N25 | **S25**
- ▲ The universal carbide grade with sintered chip breaker for medium to high cutting speeds

CWN30

- ▲ Carbide, TiN-coated
- ▲ ISO | **P30** | **M30**
- ▲ The coated carbide grade for machining steels and stainless steels at low cutting speeds

CCN1525

- ▲ Carbide, TiN-coated
- ▲ ISO | **P25** | **M25**
- ▲ The coated carbide grade for machining steels and stainless steels at low cutting speeds

Non-ferrous metals

CWK20

- ▲ Carbide, uncoated
- ▲ ISO | **N10** | **S10** | K10
- ▲ The wear-resistant carbide grade for machining aluminium and other non-ferrous metals

Steel

CCN20

- ▲ Carbide, TiAlN-coated
- ▲ ISO | **P20** | **M20**
- ▲ The all-round carbide grade for machining steels at low cutting speeds

CWN1525

- ▲ Carbide, TiN-coated
- ▲ ISO | **P25** | M25 | **K25** | **N25**
- ▲ The universal carbide grade for machining steels and non-ferrous metals at low cutting speeds

Stainless steel

HCN2525

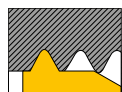
- ▲ Carbide, TiAlN-coated
- ▲ ISO | P25 | **M25** | K25 | N25 | S25
- ▲ The coated carbide grade for machining stainless steels at high cutting speeds
- ▲ Also suitable for exotic materials

CWS80

- ▲ HSS, TiN-coated
- ▲ ISO | P | **M** | K | N
- ▲ The coated HSS grade for stainless machining at low cutting speeds
- ▲ Also suitable for exotic materials

Profile Type Description

Full profile



- ▲ Thread diameter must not be turned to final thread size
- ▲ a minimum infeed of 0.07 mm is necessary
- ▲ Insert can only be used only for a specific pitch

- Advantages:**
- ▲ High-quality thread
 - ▲ No burr formation
 - ▲ No rework
 - ▲ In part longer service life

Partial profile



- ▲ Core diameter must be premachined to the finished size
- ▲ A minimum infeed of 0.07 mm is required

- Advantages:**
- ▲ One threading insert can be used to machine several pitches
 - ▲ Threading insert can be used for any application
 - ▲ Reduced stock requirements

Multi-Tooth Thread Turning Insert



- ▲ Thread diameter must not be turned to final thread size
- ▲ a minimum infeed of 0.07 mm is necessary
- ▲ Insert can only be used only for a specific pitch

- Advantages:**
- ▲ Fewer passes required
 - ▲ Thread production in less time

Attention: ▲ Check there is sufficient thread run-out

Mini Thread Turning Insert



- ▲ From a min. core hole diameter of Ø 6 mm or Ø 8 mm

- Advantages:**
- ▲ Special cutting materials for low cutting speeds
 - ▲ 3 cutting edges for miniature applications

