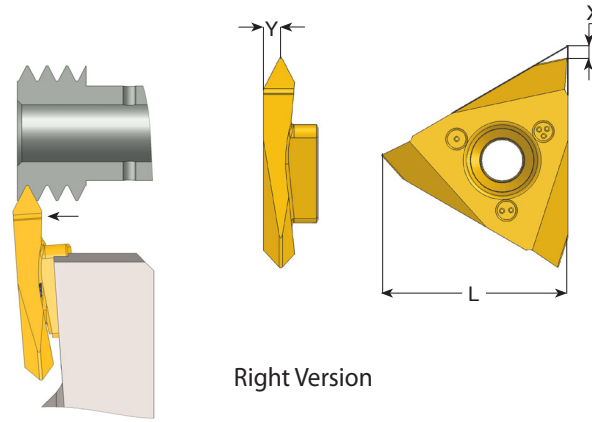


# Threading - Partial Profile 60°

## External Thread



### Right hand cutting

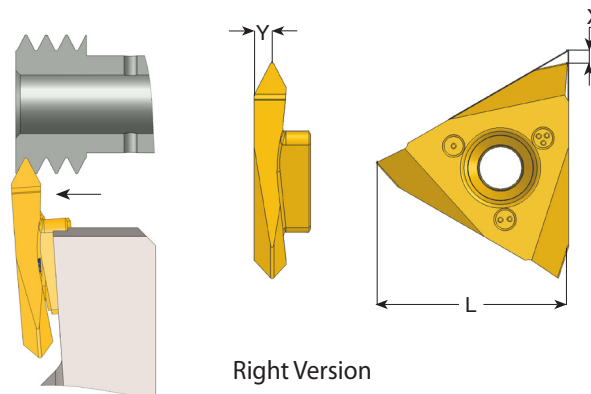
Insert Size L	mm	TPI	Ordering Code	X	Y
19	0.5-1.5	48-16	<b>GT19 R A60</b>	2.8	1.1
	1.75-3.0	14-8	<b>GT19 R G60</b>	2.8	1.7
	0.5-3.0	48-8	<b>GT19 R AG60</b>	2.8	1.7

	K20	BLU
P		●
M	●	●
K	●	○
N	●	
S	●	●
H		≤45 HRc

For L.H, specify GT19 L instead of GT19 R

# Threading - Partial Profile 55°

## External Thread



### Right hand cutting

Insert Size L	mm	TPI	Ordering Code	X	Y
19	0.5-1.5	48-16	<b>GT19 R A55</b>	2.8	1.0
	1.75-3.0	14-8	<b>GT19 R G55</b>	2.8	1.7
	0.5-3.0	48-8	<b>GT19 R AG55</b>	2.8	1.7

	K20	BLU
P		●
M	●	●
K	●	○
N	●	
S	●	●
H		≤45 HRc

For L.H, specify GT19 L instead of GT19 R

● First choice    ○ Alternative

## Swiss-Line

- Swiss style lathes are becoming a popular alternative to large lathes and machining centers in many companies.
- CPT offers a large and versatile product line of inserts and toolholders, developed for automatic and Swiss style lathes.
- Designed for economic production of parting, grooving, profiling threading and chamfering.

## Polygon Inserts and Toolholders

**CPT extends the Swiss Line range by offering a new type of polygon inserts and toolholders for external turning, grooving, parting and threading on Swiss-Type machines. Specially designed for small parts machining.**



### Features

- High precision ground inserts.
- All inserts can be used with same toolholders.
- A combination of the latest carbide and coating technologies guarantees maximum tool life and improved productivity.
- Compatible with a wide range of materials.
- Coated holders provide abrasive resistance.

Carbide grades: BLU, GX7, K20

## 3 Cutting Edges Swiss Line Inserts (16 mm)

### Carbide Grades

#### GX7

New generation of PVD triple layer coated Sub-Micron grade for wide range of materials as: Steel, Stainless Steels, Titanium and hard materials up to 58 HRc. With high toughness for optimized performance.

#### K20

Uncoated Sub-Micron carbide grade for Aluminum and non-ferrous materials, Stainless Steels and Titanium.

### Cutting Data

ISO Standard	Materials	Cutting Speed m/min	
		K20	GX7
<b>P</b>	Low & Medium Carbon Steels <0.55%C	-	80-150
	High Carbon Steels ≥0.55%C	-	70-120
	Alloy Steels, Treated Steels	-	40-80
<b>M</b>	Stainless Steel-Free Cutting	30-80	60-120
	Stainless Steel-Austenitic	20-70	30-90
	Cast Steels	30-80	50-120
<b>K</b>	Cast Iron	50-120	50-120
<b>N</b>	Aluminum ≤12%Si, Copper	120-250	-
	Aluminum >12%Si	90-200	-
	Synthetics, Duroplastics, Thermoplastics	70-150	-
<b>S</b>	Nickel Alloys, Titanium Alloys	20-50	30-70
<b>H</b>	Hardened Steel, 45-58HRc	-	20-50

# Product Identification - Ordering Codes

## Polygon Inserts

