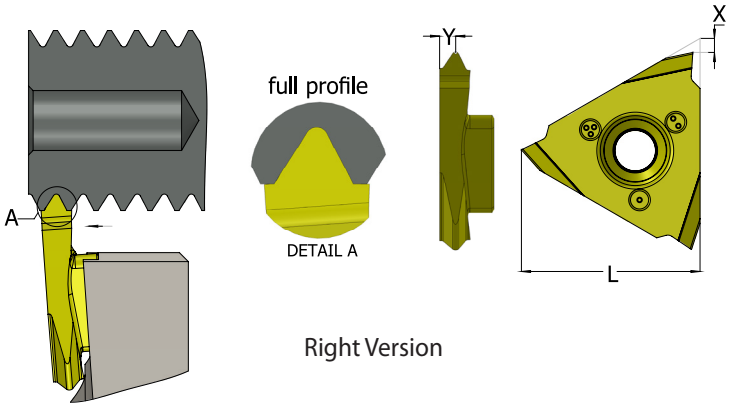
Threading - ISO metric 60° Full Profile

External Thread



Right Version

Right hand cutting

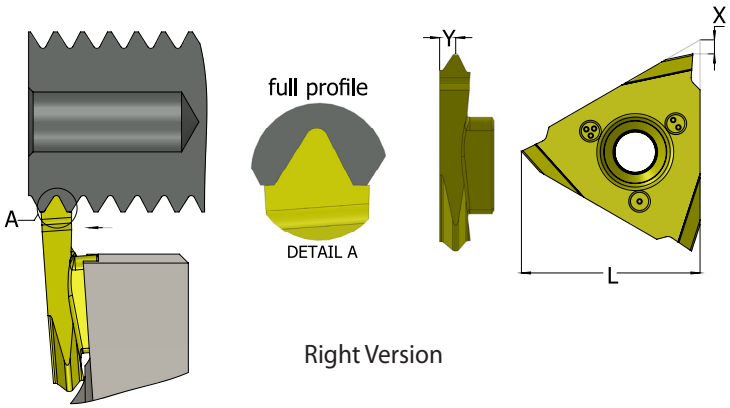
Insert Size L	mm	Ordering Code	X	Y
19	0.5	**GT19 R 0.5 ISO**	2.8	0.6
	0.7	**GT19 R 0.7 ISO**	2.8	0.7
	0.75	**GT19 R 0.75 ISO**	2.8	0.7
	0.8	**GT19 R 0.8 ISO**	2.8	0.7
	1.0	**GT19 R 1.0 ISO**	2.8	0.8
	1.25	**GT19 R 1.25 ISO**	2.8	1.0
	1.5	**GT19 R 1.5 ISO**	2.8	1.1
	1.75	**GT19 R 1.75 ISO**	2.8	1.3

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

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

Threading - UN unified 60° Full Profile

External Thread



Right Version

Right hand cutting

Insert Size L	TPI	Ordering Code	X	Y
19	72	**GT19 R 72UN**	2.8	0.4
	56	**GT19 R 56UN**	2.8	0.6
	40	**GT19 R 40UN**	2.8	0.7
	32	**GT19 R 32UN**	2.8	0.7
	24	**GT19 R 24UN**	2.8	0.8
	20	**GT19 R 20UN**	2.8	1.0

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

Product Identification - Ordering Codes

Polygon Inserts