

Inserts' Kits

Type B Kits

Type B threading inserts.
A combination of ground profile and sintered chip-breaker threading inserts.
BMA Grade: Sub-Micron carbide grade with TiAlN multi-Layer Coating.



EXTERNAL ISO KIT KEMB - BMA

- 16 ER B 1.0 ISO BMA-2 Pcs
- 16 ER B 1.25 ISO BMA-2 Pcs
- 16 ER B 1.5 ISO BMA-2 Pcs
- 16 ER B 1.75 ISO BMA-2 Pcs
- 16 ER B 2.0 ISO BMA-2 Pcs



EX-RH

INTERNAL ISO KIT KIMB - BMA

- 16 IR B 1.0 ISO BMA-2 Pcs
- 16 IR B 1.25 ISO BMA-2 Pcs
- 16 IR B 1.5 ISO BMA-2 Pcs
- 16 IR B 1.75 ISO BMA-2 Pcs
- 16 IR B 2.0 ISO BMA-2 Pcs



IN-RH

Standard Inserts' Kits

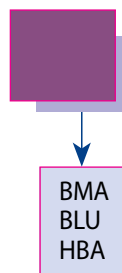
EXTERNAL ISO KIT

- 16 ER 1.0 ISO-2 Pcs
- 16 ER 1.25 ISO-2 Pcs
- 16 ER 1.5 ISO-2 Pcs
- 16 ER 1.75 ISO-2 Pcs
- 16 ER 2.0 ISO-2 Pcs

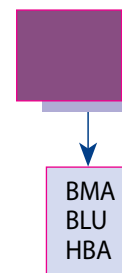
INTERNAL ISO KIT

- 16 IR 1.0 ISO-2 Pcs
- 16 IR 1.25 ISO-2 Pcs
- 16 IR 1.5 ISO-2 Pcs
- 16 IR 1.75 ISO-2 Pcs
- 16 IR 2.0 ISO-2 Pcs

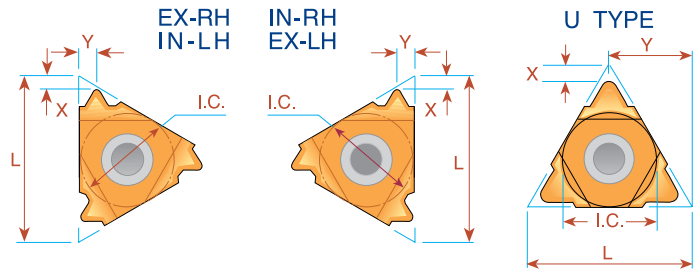
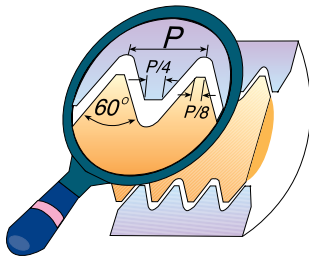
Ordering Code: KEM



Ordering Code: KIM



ISO - metric

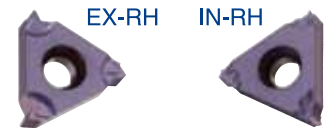
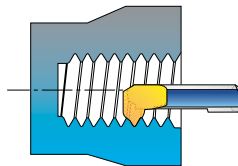


Pitch mm	L	I.C. in	EXTERNAL		X	Y	INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand			Ordering Code Right Hand	Ordering Code Left Hand		
3.5	22	1/2	22 ER 3.5 ISO	22 EL 3.5 ISO	1.6	2.3	22 IR 3.5 ISO	22 IL 3.5 ISO	1.6	2.3
4.0	22	1/2	22 ER 4.0 ISO	22 EL 4.0 ISO	1.6	2.3	22 IR 4.0 ISO	22 IL 4.0 ISO	1.6	2.3
4.5	22	1/2	22 ER 4.5 ISO	22 EL 4.5 ISO	1.7	2.4	22 IR 4.5 ISO	22 IL 4.5 ISO	1.6	2.4
5.0	22	1/2	22 ER 5.0 ISO	22 EL 5.0 ISO	1.7	2.5	22 IR 5.0 ISO	22 IL 5.0 ISO	1.6	2.3
5.5	22	1/2	22 ER 5.5 ISO	22 EL 5.5 ISO	1.7	2.6	22 IR 5.5 ISO	22 IL 5.5 ISO	1.6	2.3
6.0	22	1/2	**22 ER 6.0 ISO	**22 EL 6.0 ISO	1.9	2.7	22 IR 6.0 ISO	22 IL 6.0 ISO	1.6	2.4
5.5	22U	1/2U	22U ER/L 5.5 ISO		2.3	11.0	22U IR/L 5.5 ISO		2.4	11.0
6.0	22U	1/2U	22U ER/L 6.0 ISO		2.6	11.0	22U IR/L 6.0 ISO		2.1	11.0
5.5	27	5/8	27 ER 5.5 ISO	27 EL 5.5 ISO	1.9	2.7	27 IR 5.5 ISO	27 IL 5.5 ISO	1.6	2.3
6.0	27	5/8	27 ER 6.0 ISO	27 EL 6.0 ISO	2.0	2.9	27 IR 6.0 ISO	27 IL 6.0 ISO	1.8	2.5
8.0	27U	5/8U	27U ER/L 8.0 ISO		2.4	13.7	27U IR/L 8.0 ISO		2.4	13.7
12.0	33U	3/4U	33U ER/L 12.0 ISO		2.5	16.5	33U IR/L 12.0 ISO		3.5	16.9

Order example: 22 IR 3.5 ISO BMA

For small bore threading see page 83

** Special holder required



Type B

Ground Profile with Sintered Chip-breaker

Pitch mm	L	I.C. in	EXTERNAL		X	Y	INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand			Ordering Code Right Hand	Ordering Code Left Hand		
0.5	11	1/4					11 IR B 0.5 ISO		0.6	0.6
0.75	11	1/4					11 IR B 0.75 ISO		0.6	0.6
0.8	11	1/4					11 IR B 0.8 ISO		0.6	0.6
1.0	11	1/4					11 IR B 1.0 ISO		0.6	0.6
1.25	11	1/4					11 IR B 1.25 ISO		0.8	0.9
1.5	11	1/4					11 IR B 1.5 ISO		0.8	0.9
1.75	11	1/4					11 IR B 1.75 ISO		0.8	0.9
2.0	11	1/4					11 IR B 2.0 ISO		0.8	0.9
0.8	16	3/8	16 ER B 0.8 ISO		0.6	0.6				
1.0	16	3/8	16 ER B 1.0 ISO		0.7	0.7	16 IR B 1.0 ISO		0.6	0.7
1.25	16	3/8	16 ER B 1.25 ISO		0.8	0.9	16 IR B 1.25 ISO		0.8	0.9
1.5	16	3/8	16 ER B 1.5 ISO		0.8	1.0	16 IR B 1.5 ISO		0.8	1.0
1.75	16	3/8	16 ER B 1.75 ISO		0.9	1.2	16 IR B 1.75 ISO		0.9	1.2
2.0	16	3/8	16 ER B 2.0 ISO		1.0	1.3	16 IR B 2.0 ISO		1.0	1.3
2.5	16	3/8	16 ER B 2.5 ISO		1.1	1.5	16 IR B 2.5 ISO		1.1	1.5
3.0	16	3/8	16 ER B 3.0 ISO		1.2	1.6	16 IR B 3.0 ISO		1.1	1.5

Order example: 16 IR B 1.5 ISO BMA

For Carbide Grade and Cutting Speed see page 60-61

Carbide Grade Selection

Choose the C.P.T. grade specifically formulated for your application from the following list:

Coated Grades

HBA
(H10-H25)
(S10-S25)

Extra-fine sub-micron grade with high toughness, for optimized performance on hardened steels and cast iron up to 62HRC, titanium alloys and super alloys (hastelloy, inconel and nickel based alloys).

BLU
(M10-M20)
(K05-K20)
(N10-N20)
(S10-S20)

PVD triple layer coated sub-micron grade for stainless steels, cast iron, titanium, non ferrous metals and most of the high temperature alloys.

BMA
(P20-P40)
(K20-K30)

PVD TiAlN coated sub-micrograin grade for stainless steels and exotic materials at medium to high cutting speeds.

P25C
(P15-P35)

PVD TiN coated grade for treated and hard alloy steels (25 HRc & up) at medium to low cutting speeds.

MXC
(K10-K20)
(P10-P25)

PVD TiN coated micrograin for free cutting untreated alloy steels (below 30 HRc), for stainless steels and cast iron.

BXC
(P30-P50)
(K25-K40)

PVD TiN coated grade for low cutting speed. Works well with wide range of stainless steels.

Uncoated Grades

P30*
(P20-P30)

Carbide grade for carbon and cast steels, works well at medium to low cutting speeds.

K20*
(K10-K30)

Carbide grade for non ferrous metals, aluminum and cast iron.

* Upon request

Note: Due to our unique and specialized production techniques, C.P.T. coated inserts provide superior cutting performance and exceptionally long tool life.

Grade availability per inserts size

Grade	HBA	BLU	BMA	P25C	MXC	BXC	P30	K20
Insert sizes	11, 16, 22, 27	11, 16, 22	06, 08, 11, 16, 22, 27, 33U,	11, 16, 22, 27, 33U	11, 16, 22, 27, 33U	06, 08	11, 16, 22, 27, 33U	06, 08, 11, 16, 22, 27, 33U
			Type-B 11, 16					

Type B - Threading Inserts

A combination of ground profile, and sintered chip-breaker threading inserts. Unlike most other manufactures' inserts, this combination ensures a consistent high quality thread, with precise shape and dimensions. Two different unique styles of chip-breaker were designed to suit the different specific requirements of Internal threads and External threads. All of C.P.T. Type B inserts are made of BMA Sub-Micrograin grade.



Recommended cutting speed (m/min) for thread turning inserts

ISO Standard	Material		Condition							
				HBA	BLU	BMA	P25C	MXC	BXC	K20
P	Non-Alloy Steel and Cast Steel, Free Cutting Steel	<0.25%C	Annealed	110-210	120-180	100-180	100-180	70-150	50-130	
		≥0.25%C	Annealed							
		<0.55%C	Quenched & Tempered							
		≥0.55%C	Annealed							
	Low Alloy Steel and Cast Steel (less than 5% alloying elements)	Annealed		90-140	80-130	70-120	70-120	60-90	50-80	
		Quenched & Tempered								
High Alloy Steel, Cast Steel, and Tool Steel	Annealed		70-90	60-80	50-60	55-70	50-60	40-50		
	Quenched & Tempered									
M	Stainless Steel and Cast Steel		Ferritic / Martensitic	110-160	90-130	60-90	60-90	50-80	50-80	
			Martensitic							
			Austenitic							
K	Cast Iron Nodular (GGG)		Ferritic / Pearlitic	120-150	100-130	80-110	60-90			
			Pearlitic							
	Grey Cast Iron (GG)		Ferritic	140-150	120-130	90-100	65-85			
			Pearlitic							
Malleable Cast Iron		Ferritic	110-140	100-130	80-100	60-85				
		Pearlitic								
N	Aluminum-Wrought Alloy		Not Cureable	700-1000			600-800	450-600	600-800	350-500
			Cured							
	Aluminum-Cast, Alloyed	≤12% Si	Not Cureable	280-750			200-550	150-350	200-550	110-300
			Cured							
		>12% Si	High Temperature							
	Copper Alloys	>1% Pb	Free Cutting	190-350			150-250	110-180	150-250	90-150
			Brass							
Electrolytic Copper										
Non Metallic		Duroplastics, Fiber Plastics				200-300	150-210	100-200	110-150	
		Hard Rubber								
S	High Temp. Alloys, Super Alloys	Fe based	Annealed	20-80	30-65	25-60				
			Cured							
		Ni or Co based	Annealed							
			Cured							
	Titanium Alloys		Alpha +Beta Alloys Cured	30-60	40-50	35-45			35-45	
H	Hardened Steel		Hardened 45-50 HRc	30-60	40-50	35-45				
			Hardened 51-55 HRc							
			Hardened 56-62 HRc							
	Chilled Cast Iron		Cast	20-50	30-40	25-35				
Cast Iron		Hardened	20-40	20-30	15-25					

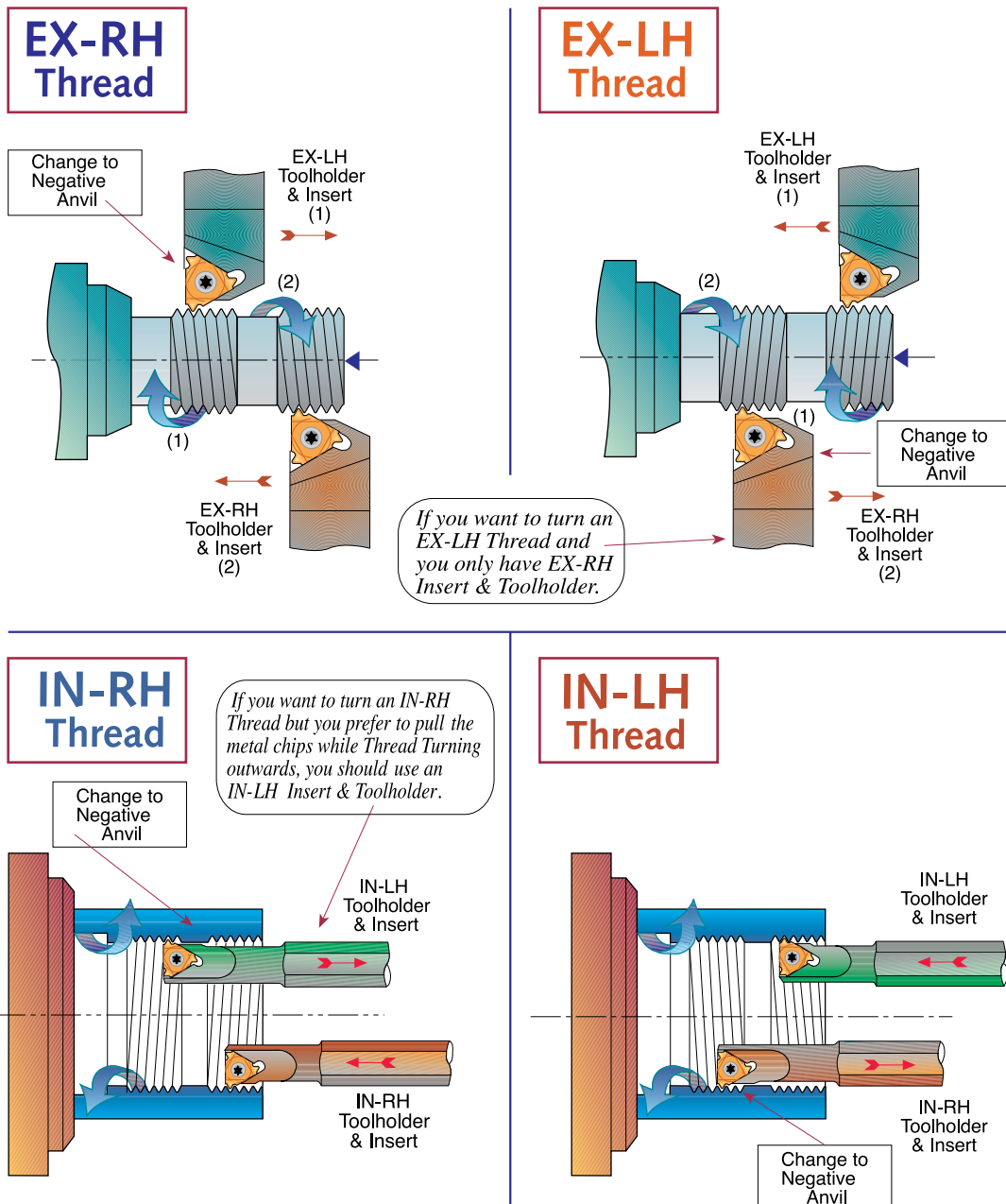
Number of threading passes selection for single point inserts

Pitch:	mm TPI	0.5 48	0.8 32	1.0 24	1.25 20	1.5 16	1.75 14	2.0 12	2.5 10	3.0 8	4.0 6	6.0 4
Number of Passes		3-6	4-7	4-9	6-10	5-11	9-12	6-13	7-15	8-17	10-20	11-22

NOTES:

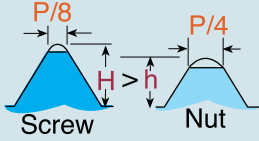
1. For most standard applications the middle of the range is a good starting point.
2. For most materials, the tougher the material, the higher the number of cutting passes you should select.
3. As a general rule of thumb, fewer passes are better than more speed.

Thread Turning Methods

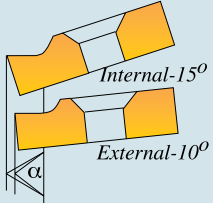


Important Points about C.P.T. Threading Inserts

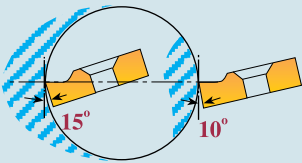
1. In most thread forms internal and external threads have different depth and radii, thus tools are not interchangeable




4. Profiles of C.P.T. internal & external threading inserts are precision ground to ensure accurate thread geometry when used in their corresponding toolholders. Using internal inserts with an external holder will result in distortion of angle and insert geometry.



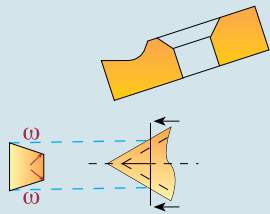
2. The Insert relief angle of a standard C.P.T. external toolholder is 10°; for an internal toolholder it is 15°. This 5° difference is to provide additional necessary radial clearance.



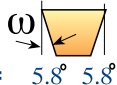
5. Insert and toolholder should always match. An IN-RH insert must be used with an IN-RH toolholder. No mismatch is allowed.



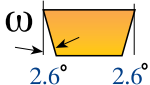
3. Our built-in relief angles ensure automatic insert flank angle clearance.



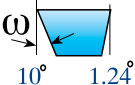
Flank Clearance Angle ω



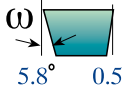
$\omega = 5.8^\circ \quad 5.8^\circ$



$\omega = 2.6^\circ \quad 2.6^\circ$



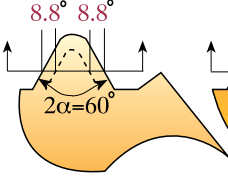
$\omega = 10^\circ \quad 1.24^\circ$



$\omega = 5.8^\circ \quad 0.5^\circ$

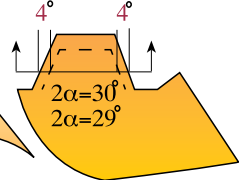
$\omega = \text{ArcTan} (\text{Tan } \alpha \times \text{Tan } \phi)$

$\phi = 10^\circ$ for External toolholders



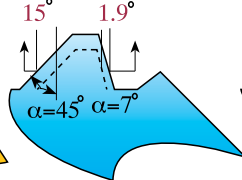
$\omega = 8.8^\circ \quad 8.8^\circ$
 $2\alpha = 60^\circ$

ISO, UN
PARTIAL 60
NPT



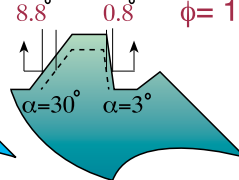
$\omega = 4^\circ \quad 4^\circ$
 $2\alpha = 30^\circ$
 $2\alpha = 29^\circ$

TRAPEZ
ACME
STACME



$\omega = 15^\circ \quad 1.9^\circ$
 $\alpha = 45^\circ \quad \alpha = 7^\circ$

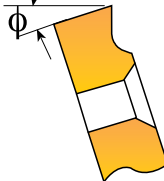
AMERICAN
BUTTRESS



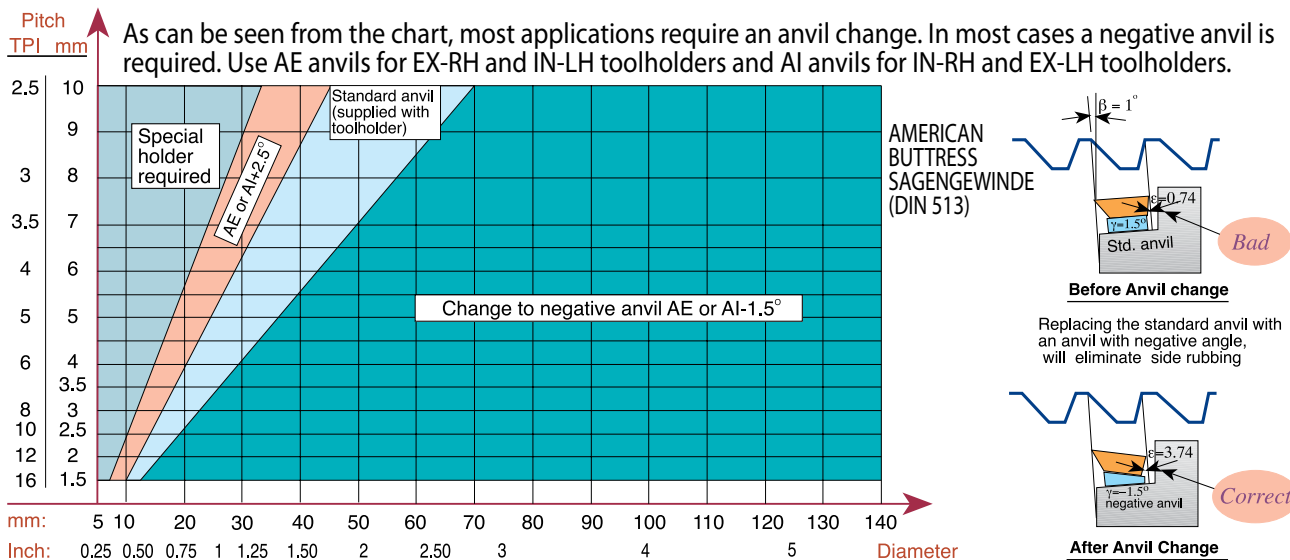
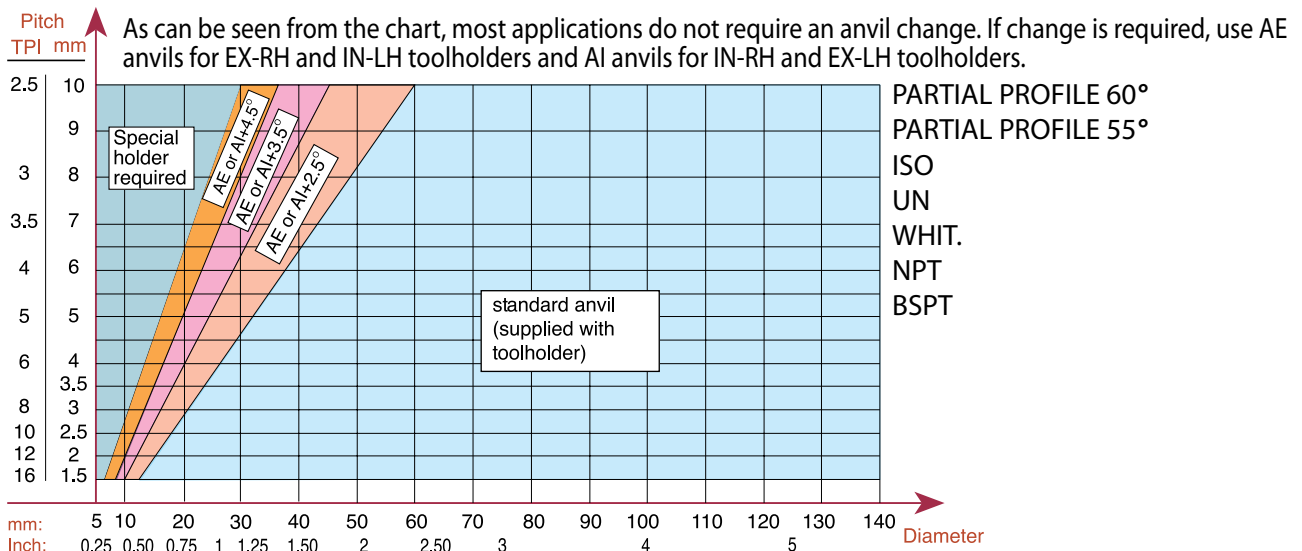
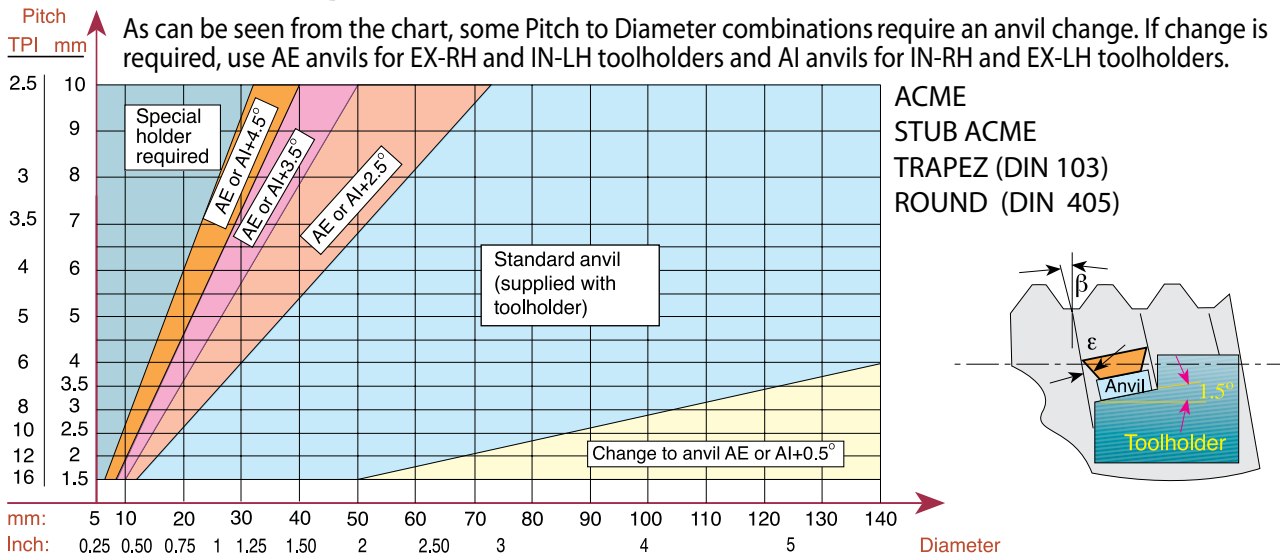
$\omega = 8.8^\circ \quad 0.8^\circ$
 $\alpha = 30^\circ \quad \alpha = 3^\circ$

SAGE
(DIN 513)

$\phi = 15^\circ$ for Internal toolholders



Anvil Change Recommendation



Product Identification

Thread Turning Inserts Ordering Codes

