

POSITHREAD



SLIDING HEAD CATALOGUE

TOOLING FOR MEDICAL · AUTOMOTIVE · AEROSPACE · GENERAL ENGINEERING

NEW PRODUCTS IN THIS CATALOGUE

OFFSET EXTERNAL TOOLING

THREADING AND GROOVING

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EXTERNAL TOOLING FOR SUBSPINDLE

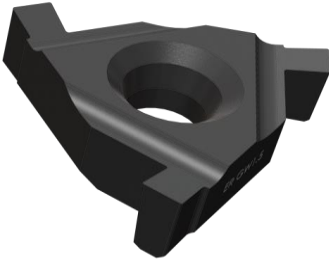
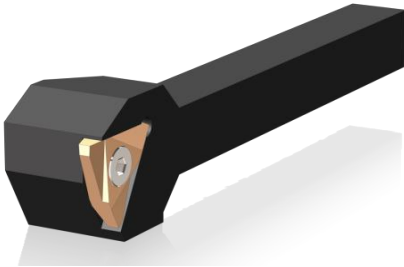
THREADING AND GROOVING

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ON EDGE EXTERNAL TOOLING

THREADING AND GROOVING

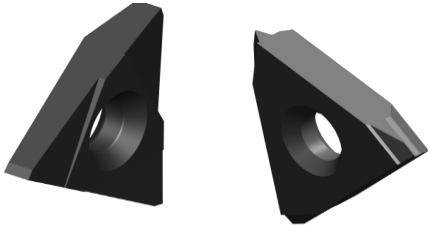
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ON EDGE

THREADING, GROOVING AND TURNING

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LAYDOWN

GROOVING

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MINI SERIES SOLID CARBIDE BARS AND TOOLHOLDERS

THREADING AND GROOVING

- PAGE 12-17 -



EXTERNAL TOOLHOLDERS LAYDOWN STYLE

PARALLEL SHANK

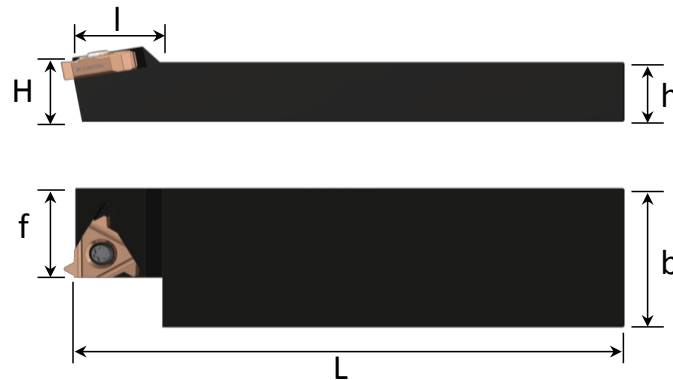
3° HELIX



PART No.	DIMENSIONS (mm)					SPARES		INSERT SIZE	
	H=h	b	L	l	f	Screw	Torq Key	mm	inch
SESR1018-00-16-3	10	18	101	15	18	S16	T15	16	3/8"
SESR1218-00-16-3	12	18	101	15	18	S16	T15	16	3/8"
SESR1618-00-16-3	16	18	101	15	18	S16	T15	16	3/8"

OFFSET SHANK

3° HELIX



PART No.	DIMENSIONS (mm)					SPARES		INSERT SIZE	
	H=h	b	L	l	f	Screw	Torq Key	mm	inch
SESR1028-10-16-3	10	28	101	15	10	S16	T15	16	3/8"
SESR1038-20-16-3	10	38	101	15	20	S16	T15	16	3/8"
SESR1228-10-16-3	12	28	101	15	10	S16	T15	16	3/8"
SESR1238-20-16-3	12	38	101	15	20	S16	T15	16	3/8"
SESR1628-10-16-3	16	28	101	15	10	S16	T15	16	3/8"
SESR1638-20-16-3	16	38	101	15	20	S16	T15	16	3/8"

ROUND SHANK

3° HELIX 10° INCLINATION

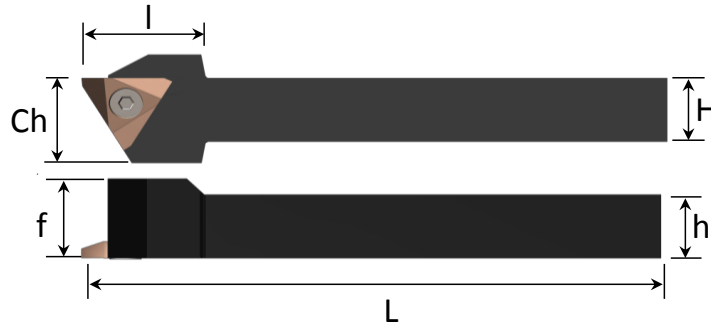


PART No.	DIMENSIONS (mm)				SPARES		INSERT SIZE	
	D	L	h	fn	Screw	Torq Key	mm	inch
SER0016-16-3	16	100	15	11.45	S16	T15	16	3/8"
SER0020-16-3	20	100	19	13.45	S16	T15	16	3/8"
SER0022-16-3	22	100	19	14.45	S16	T15	16	3/8"
SER001905-16-3	19.05	100	17.05	12.98	S16	T15	16	3/8"
SER002540-16-3	25.4	100	23.4	16.15	S16	T15	16	3/8"

Left Hand Tooling designation: **SESL1028-10-16-3 / SESL1028-10-16-3 / SEL0016-16-3**

EXTERNAL TOOLHOLDERS VERTICAL STYLE

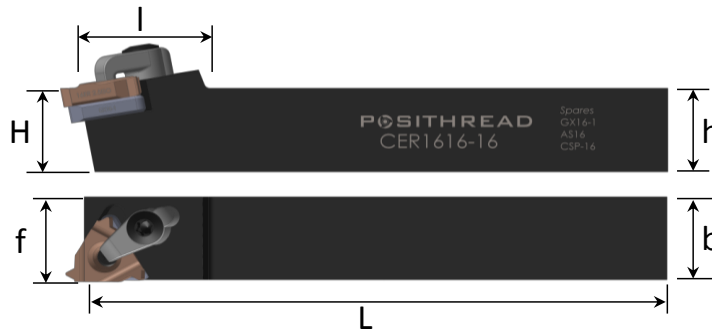
ON EDGE



PART No.	DIMENSIONS (mm)					SPARES		INSERT SIZE	
	H=h	Ch	L	l	f	Screw	Hex Key	mm	inch
SESRV1010-00-32	10	10	101	20	16	VS16	2.0	16	3/8"
SESRV1212-00-32	12	12	101	20	16	VS16	2.0	16	3/8"
SESRV1212-00-43	12	12	101	20	20	VS22	2.5	22	1/2"

STANDARD TOOLING

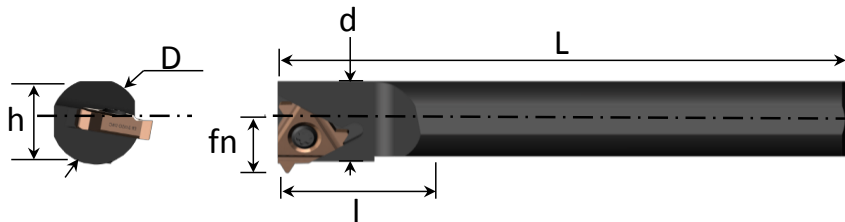
EXTERNAL



PART No.	DIMENSIONS (mm)					SPARES				INSERT SIZE	
	H=h	b	L	l	f	Anvil	Clamp	Screw	Torq Key	mm	inch
CER1616-16	16	16	100	20	16	GX16-1	CSP16	AS16	T8-T15	16	3/8"
CER2020-16	20	20	125	25	20	GX16-1	CSP16	AS16	T8-T15	16	3/8"

INTERNAL

15°/20° INCLINATION



PART No.	DIMENSIONS (mm)							SPARES		INSERT SIZE	
	D	d	L	l	h	fn	Min Bore	Screw	Torq Key	mm	inch
SNR0006-06S	12	5.8	100	13	11	4.2	6.0	S8	T6	06	5/32"
SNR0006-08S	16	6.3	125	17	17	5.1	7.8	S8	T6	08	3/16"
SNR0008-08S	16	7.8	125	17	14	5.8	10.0	S8	T6	08	3/16"
SNR0010-11	10	-	125	-	10	7.5	13.0	S11	T7	11	1/4"
SNR0010-11S	16	10	125	30	14	7.5	12.0	S11	T7	11	1/4"
SNR0013-11S	16	13	125	35	14	8	15.0	S11	T7	11	1/4"
SNR0016-16	16	-	150	-	14	10.3	19.0	S16	T15	16	3/8"

Left Hand Tooling designation: **SESLV1010-00-32 / CEL1616-16 / SNL0016-16**

INSERTS LAYDOWN STYLE

Partial Profile 60°



Pitch	TPI	L mm	I.C. Inch	Description External	R Max	X mm	Y mm	Description Internal	R Max	X mm	Y mm
0.5 - 1.5	48 - 16	08	3/16"	-	-	-	-	08NR A60	0.04	0.6	0.7
0.5 - 1.5	48 - 16	11	1/4"	-	-	-	-	11NR A60	0.04	0.7	0.8
0.5 - 1.5	48 - 16	16	3/8"	16ER A60	0.07	0.7	0.8	16NR A60	0.04	0.7	0.8
0.5 - 3.0	48 - 8	16	3/8"	16ER AG60	0.07	1.3	1.5	16NR AG60	0.04	1.3	1.5
1.0 - 2.5	24 - 11	16	3/8"	16ER MR60	0.14	1.3	1.5	16NR MR60	0.07	1.3	1.5
1.75 - 3.0	14 - 8	16	3/8"	16ER G60	0.25	1.3	1.5	16NR G60	0.13	1.3	1.5
0.5 - 1.5	48 - 16	16	3/8"	16ER A60 TD	0.07	0.7	0.8	16NR A60 TD	0.04	0.7	0.8
0.5 - 3.0	48 - 8	16	3/8"	16ER AG60 TD	0.07	1.3	1.5	16NR AG60 TD	0.04	1.3	1.5
1.75 - 3.0	14 - 8	16	3/8"	16ER G60 TD	0.25	1.3	1.5	16NR G60 TD	0.13	1.3	1.5

Partial Profile 55°

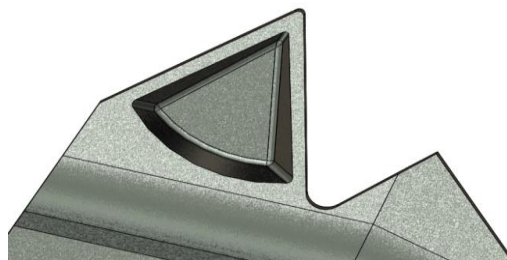
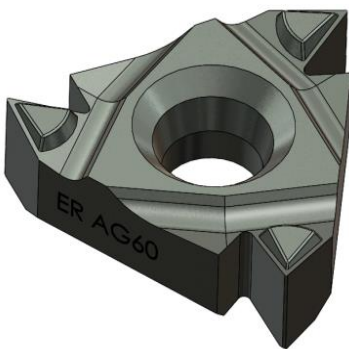


Pitch	TPI	L mm	I.C. Inch	Description External	R Max	X mm	Y mm	Description Internal	R Max	X mm	Y mm
0.5 - 1.5	48 - 16	08	3/16"	-	-	-	-	08NR A55	0.04	0.6	0.7
0.5 - 1.5	48 - 16	11	1/4"	-	-	-	-	11NR A55	0.04	0.7	0.8
0.5 - 1.5	48 - 16	16	3/8"	16ER A55	0.07	0.7	0.8	16NR A55	0.04	0.7	0.8
0.5 - 1.5	48 - 8	16	3/8"	16ER AG55	0.07	1.3	1.5	16NR AG55	0.04	1.3	1.5
1.0 - 2.5	24 - 11	16	3/8"	16ER MR55	0.14	1.3	1.5	16NR MR55	0.07	1.3	1.5
1.75 - 3.0	14 - 8	16	3/8"	16ER G55	0.25	1.3	1.5	16NR G55	0.13	1.3	1.5
0.5 - 1.5	48 - 16	16	3/8"	16ER A55 TD	0.07	0.7	0.8	16NR A55 TD	0.04	0.7	0.8
0.5 - 3.0	48 - 8	16	3/8"	16ER AG55 TD	0.07	1.3	1.5	16NR AG55 TD	0.04	1.3	1.5
1.75 - 3.0	14 - 8	16	3/8"	16ER G55 TD	0.25	1.3	1.5	16NR G55 TD	0.13	1.3	1.5

TD CHIPBREAKER

The TD geometry will break swarf into small chips if the correct surface speed, threading cycle and infeed are applied. This will change with different material specifications.

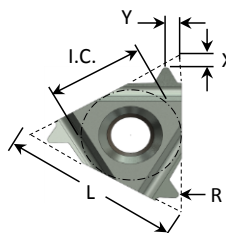
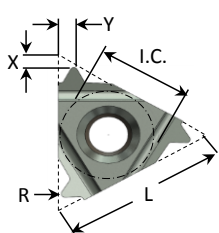
The TD is also available on some Full Form Inserts .



Left Hand Insert designation: EL or NL: 16EL A60 / 16NL A60

INSERTS LAYDOWN STYLE

ISO DIN13



Pitch	L mm	I.C. Inch	Description External	R Max	X mm	Y mm	Description Internal	R Max	X mm	Y mm
0.25	06	5/32"	-	-	-	-	06NR 0.25ISO	0.018	0.5	0.5
0.35	06	5/32"	-	-	-	-	06NR 0.35ISO	0.025	0.5	0.5
0.5	06	5/32"	-	-	-	-	06NR 0.5ISO	0.036	0.5	0.5
0.75	06	5/32"	-	-	-	-	06NR 0.75ISO	0.054	0.5	0.5
1.0	06	5/32"	-	-	-	-	06NR 1.0ISO	0.072	0.6	0.6
1.25	06	5/32"	-	-	-	-	06NR 1.25ISO	0.090	0.6	0.7
0.5	08	3/16"	-	-	-	-	08NR 0.5ISO	0.036	0.5	0.5
0.75	08	3/16"	-	-	-	-	08NR 0.75ISO	0.054	0.5	0.5
1.0	08	3/16"	-	-	-	-	08NR 1.0ISO	0.072	0.6	0.6
1.25	08	3/16"	-	-	-	-	08NR 1.25ISO	0.090	0.6	0.7
1.5	08	3/16"	-	-	-	-	08NR 1.5ISO	0.108	0.7	0.8
0.25	11	1/4"	-	-	-	-	11NR 0.25ISO	0.018	0.5	0.4
0.35	11	1/4"	-	-	-	-	11NR 0.35ISO	0.025	0.5	0.4
0.5	11	1/4"	-	-	-	-	11NR 0.5ISO	0.036	0.7	0.5
0.6	11	1/4"	-	-	-	-	11NR 0.6ISO	0.043	0.7	0.5
0.7	11	1/4"	-	-	-	-	11NR 0.7ISO	0.051	0.7	0.5
0.75	11	1/4"	-	-	-	-	11NR 0.75ISO	0.054	0.7	0.5
0.8	11	1/4"	-	-	-	-	11NR 0.8ISO	0.058	0.7	0.5
1.0	11	1/4"	-	-	-	-	11NR 1.0ISO	0.072	0.7	0.8
1.25	11	1/4"	-	-	-	-	11NR 1.25ISO	0.090	0.7	0.8
1.5	11	1/4"	-	-	-	-	11NR 1.5ISO	0.108	0.7	0.9
1.75	11	1/4"	-	-	-	-	11NR 1.75ISO	0.126	0.7	0.9
2.0	11	1/4"	-	-	-	-	11NR 2.0ISO	0.144	0.7	1.0
0.25	16	3/8"	16ER 0.25ISO	0.036	0.5	0.4	16NR 0.25ISO	0.018	0.5	0.4
0.35	16	3/8"	16ER 0.35ISO	0.051	0.5	0.4	16NR 0.35ISO	0.025	0.5	0.4
0.5	16	3/8"	16ER 0.5ISO	0.072	0.7	0.5	16NR 0.5ISO	0.036	0.7	0.5
0.6	16	3/8"	16ER 0.6ISO	0.087	0.7	0.5	16NR 0.6ISO	0.043	0.7	0.5
0.7	16	3/8"	16ER 0.7ISO	0.101	0.7	0.5	16NR 0.7ISO	0.051	0.7	0.5
0.75	16	3/8"	16ER 0.75ISO	0.108	0.7	0.5	16NR 0.75ISO	0.054	0.7	0.5
0.8	16	3/8"	16ER 0.8ISO	0.115	0.7	0.5	16NR 0.8ISO	0.058	0.7	0.5
1.0	16	3/8"	16ER 1.0ISO	0.144	0.7	0.8	16NR 1.0ISO	0.072	0.8	0.8
1.25	16	3/8"	16ER 1.25ISO	0.180	0.7	0.8	16NR 1.25ISO	0.090	0.7	0.8
1.5	16	3/8"	16ER 1.5ISO	0.217	0.7	0.8	16NR 1.5ISO	0.108	0.8	0.8
1.75	16	3/8"	16ER 1.75ISO	0.253	1.3	1.5	16NR 1.75ISO	0.126	1.3	1.5
2.0	16	3/8"	16ER 2.0ISO	0.289	1.3	1.5	16NR 2.0ISO	0.144	1.3	1.5
2.5	16	3/8"	16ER 2.5ISO	0.361	1.3	1.5	16NR 2.5ISO	0.180	1.3	1.5
3.0	16	3/8"	16ER 3.0ISO	0.433	1.3	1.5	16NR 3.0ISO	0.217	1.3	1.5
3.5	16	3/8"	16ER 3.5ISO	0.505	1.3	1.5	16NR 3.5ISO	0.253	1.3	1.5

Left Hand Insert designation: EL or NL: 16EL 1.0ISO / 16NL 1.0ISO

INSERTS LAYDOWN STYLE

Unified 'UN' (Full Form) ASME/ANSI B1.1

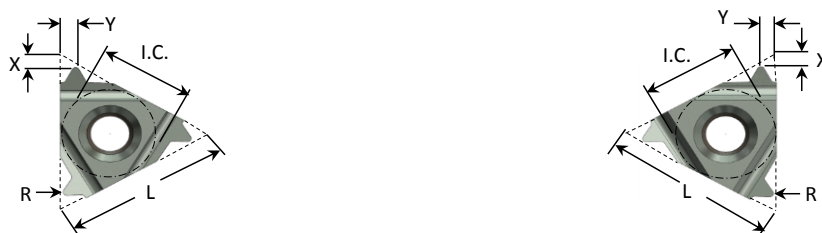


TPI	L mm	I.C. Inch	Description External	R Max	X mm	Y mm	Description Internal	R Max	X mm	Y mm
40	06	5/32"	-	-	-	-	06NR 40UN	0.046	0.5	0.5
36	06	5/32"	-	-	-	-	06NR 36UN	0.051	0.5	0.5
32	06	5/32"	-	-	-	-	06NR 32UN	0.057	0.5	0.5
28	06	5/32"	-	-	-	-	06NR 28UN	0.065	0.5	0.5
24	06	5/32"	-	-	-	-	06NR 24UN	0.076	0.6	0.6
20	06	5/32"	-	-	-	-	06NR 20UN	0.092	0.6	0.7
40	08	3/16"	-	-	-	-	08NR 40UN	0.046	0.5	0.5
36	08	3/16"	-	-	-	-	08NR 36UN	0.051	0.5	0.5
32	08	3/16"	-	-	-	-	08NR 32UN	0.057	0.5	0.5
28	08	3/16"	-	-	-	-	08NR 28UN	0.065	0.5	0.5
24	08	3/16"	-	-	-	-	08NR 24UN	0.076	0.6	0.6
20	08	3/16"	-	-	-	-	08NR 20UN	0.092	0.6	0.7
18	08	3/16"	-	-	-	-	08NR 18UN	0.102	0.7	0.8
72	11	1/4"	-	-	-	-	11NR 72UN	0.025	0.5	0.4
60	11	1/4"	-	-	-	-	11NR 60UN	0.031	0.5	0.4
56	11	1/4"	-	-	-	-	11NR 56UN	0.033	0.7	0.5
36	11	1/4"	-	-	-	-	11NR 36UN	0.051	0.7	0.5
28	11	1/4"	-	-	-	-	11NR 28UN	0.065	0.7	0.5
24	11	1/4"	-	-	-	-	11NR 24UN	0.076	0.7	0.5
20	11	1/4"	-	-	-	-	11NR 20UN	0.092	0.7	0.5
18	11	1/4"	-	-	-	-	11NR 18UN	0.102	0.7	0.8
16	11	1/4"	-	-	-	-	11NR 16UN	0.115	0.7	0.8
14	11	1/4"	-	-	-	-	11NR 14UN	0.131	0.7	0.9
12	11	1/4"	-	-	-	-	11NR 12UN	0.153	0.7	0.9
11	11	1/4"	-	-	-	-	11NR 11UN	0.167	0.7	1.0
72	16	3/8"	16ER 72UN	0.051	0.5	0.4	16NR 72UN	0.026	0.5	0.4
64	16	3/8"	16ER 64UN	0.057	0.5	0.4	16NR 64UN	0.029	0.5	0.4
56	16	3/8"	16ER 56UN	0.065	0.7	0.5	16NR 56UN	0.033	0.7	0.5
44	16	3/8"	16ER 44UN	0.083	0.7	0.5	16NR 44UN	0.042	0.7	0.5
40	16	3/8"	16ER 40UN	0.092	0.7	0.5	16NR 40UN	0.046	0.7	0.5
36	16	3/8"	16ER 36UN	0.102	0.7	0.5	16NR 36UN	0.051	0.7	0.5
32	16	3/8"	16ER 32UN	0.115	0.7	0.5	16NR 32UN	0.058	0.7	0.5
28	16	3/8"	16ER 28UN	0.131	0.7	0.8	16NR 28UN	0.066	0.8	0.8
27	16	3/8"	16ER 27UN	0.136	0.7	0.8	16NR 27UN	0.068	0.7	0.8
24	16	3/8"	16ER 24UN	0.153	0.7	0.8	16NR 24UN	0.077	0.8	0.8
20	16	3/8"	16ER 20UN	0.183	1.3	1.5	16NR 20UN	0.092	1.3	1.5
18	16	3/8"	16ER 18UN	0.204	1.3	1.5	16NR 18UN	0.102	1.3	1.5
16	16	3/8"	16ER 16UN	0.229	1.3	1.5	16NR 16UN	0.115	1.3	1.5
14	16	3/8"	16ER 14UN	0.262	1.3	1.5	16NR 14UN	0.131	1.3	1.5
13	16	3/8"	16ER 13UN	0.282	1.3	1.5	16NR 13UN	0.141	1.3	1.5
12	16	3/8"	16ER 12UN	0.306	1.3	1.5	16NR 12UN	0.153	1.3	1.5
11	16	3/8"	16ER 11UN	0.333	1.3	1.5	16NR 11UN	0.167	1.3	1.5
10	16	3/8"	16ER 10UN	0.367	1.3	1.5	16NR 10UN	0.184	1.3	1.5
9	16	3/8"	16ER 9UN	0.407	1.3	1.5	16NR 9UN	0.204	1.3	1.5
8	16	3/8"	16ER 8UN	0.458	1.3	1.5	16NR 8UN	0.229	1.3	1.5
7	16	3/8"	16ER 7UN	0.524	1.3	1.5	16NR 7UN	0.262	1.3	1.5

Left Hand Insert designation: **EL or NL: 16EL 28UN / 16NL 28UN**

INSERTS LAYDOWN STYLE

WHITWORTH 55° (Full Form) DIN 2999/BS84

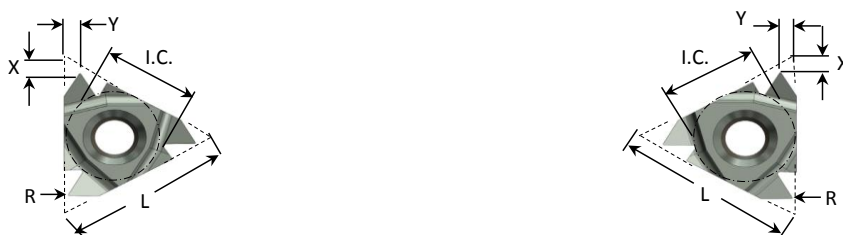


TPI	L mm	I.C. Inch	Description External	R Max	X mm	Y mm	Description Internal	R Max	X mm	Y mm
40	06	5/32"	-	-	-	-	06NR 40W	0.087	0.5	0.5
36	06	5/32"	-	-	-	-	06NR 36W	0.097	0.5	0.5
32	06	5/32"	-	-	-	-	06NR 32W	0.109	0.5	0.5
28	06	5/32"	-	-	-	-	06NR 28W	0.125	0.5	0.5
24	06	5/32"	-	-	-	-	06NR 24W	0.145	0.6	0.6
20	06	5/32"	-	-	-	-	06NR 20W	0.174	0.6	0.7
28	08	3/16"	-	-	-	-	08NR 28W	0.125	0.5	0.5
26	08	3/16"	-	-	-	-	08NR 26W	0.134	0.5	0.5
20	08	3/16"	-	-	-	-	08NR 20W	0.174	0.6	0.6
19	08	3/16"	-	-	-	-	08NR 19W	0.184	0.6	0.7
16	08	3/16"	-	-	-	-	08NR 16W	0.218	0.7	0.8
72	11	1/4"	-	-	-	-	11NR 72W	0.048	0.7	0.5
60	11	1/4"	-	-	-	-	11NR 60W	0.058	0.7	0.5
56	11	1/4"	-	-	-	-	11NR 56W	0.062	0.7	0.5
48	11	1/4"	-	-	-	-	11NR 48W	0.073	0.7	0.5
40	11	1/4"	-	-	-	-	11NR 40W	0.087	0.7	0.5
36	11	1/4"	-	-	-	-	11NR 36W	0.097	0.7	0.5
32	11	1/4"	-	-	-	-	11NR 32W	0.109	0.7	0.5
28	11	1/4"	-	-	-	-	11NR 28W	0.125	0.7	0.8
26	11	1/4"	-	-	-	-	11NR 26W	0.134	0.7	0.8
24	11	1/4"	-	-	-	-	11NR 24W	0.145	0.7	0.8
22	11	1/4"	-	-	-	-	11NR 22W	0.159	0.7	0.8
20	11	1/4"	-	-	-	-	11NR 20W	0.174	0.7	0.8
19	11	1/4"	-	-	-	-	11NR 19W	0.184	0.7	0.8
14	11	1/4"	-	-	-	-	11NR 14W	0.249	0.7	0.8
72	16	3/8"	16ER 72W	0.048	0.7	0.5	16NR 72W	0.048	0.7	0.5
60	16	3/8"	16ER 60W	0.058	0.7	0.5	16NR 60W	0.058	0.7	0.5
56	16	3/8"	16ER 56W	0.062	0.7	0.5	16NR 56W	0.062	0.7	0.5
48	16	3/8"	16ER 48W	0.073	0.7	0.5	16NR 48W	0.073	0.7	0.5
40	16	3/8"	16ER 40W	0.087	0.7	0.5	16NR 40W	0.087	0.7	0.5
36	16	3/8"	16ER 36W	0.097	0.7	0.8	16NR 36W	0.097	0.8	0.5
32	16	3/8"	16ER 32W	0.109	0.7	0.8	16NR 32W	0.109	0.8	0.5
28	16	3/8"	16ER 28W	0.125	0.7	0.8	16NR 28W	0.125	0.8	0.8
26	16	3/8"	16ER 26W	0.134	0.7	0.8	16NR 26W	0.134	0.7	0.8
22	16	3/8"	16ER 22W	0.159	0.7	0.8	16NR 22W	0.159	0.8	0.8
20	16	3/8"	16ER 20W	0.174	0.7	0.8	16NR 20W	0.174	0.7	0.8
19	16	3/8"	16ER 19W	0.184	0.7	0.8	16NR 19W	0.184	0.8	0.8
14	16	3/8"	16ER 14W	0.249	1.3	1.5	16NR 14W	0.249	1.3	1.5
12	16	3/8"	16ER 12W	0.291	1.3	1.5	16NR 12W	0.291	1.3	1.5
11	16	3/8"	16ER 11W	0.317	1.3	1.5	16NR 11W	0.317	1.3	1.5
10	16	3/8"	16ER 10W	0.349	1.3	1.5	16NR 10W	0.349	1.3	1.5
9	16	3/8"	16ER 9W	0.388	1.3	1.5	16NR 9W	0.388	1.3	1.5
8	16	3/8"	16ER 8W	0.436	1.3	1.5	16NR 8W	0.436	1.3	1.5
7	16	3/8"	16ER 7W	0.498	1.3	1.5	16NR 7W	0.498	1.3	1.5

Left Hand Insert designation: **EL or NL: 16EL 12W / 16NL 12W**

INSERTS LAYDOWN STYLE

NPT (full form) ASME/ANSI B1.20.1



TPI	L mm	I.C. Inch	Description External	R Max	X mm	Y mm	Description Internal	R Max	X mm	Y mm
27	06	5/32"	-	-	-	-	06NR 27NPT	0.060	0.6	0.6
27	08	3/16"	-	-	-	-	08NR 27NPT	0.060	0.6	0.6
18	08	3/16"	-	-	-	-	08NR 18NPT	0.084	0.7	0.8
27	11	1/4"	-	-	-	-	11NR 27NPT	0.060	0.7	0.8
18	11	1/4"	-	-	-	-	11NR 18NPT	0.084	0.7	0.8
14	11	1/4"	-	-	-	-	11NR 14NPT	0.094	0.7	1.0
27	16	3/8"	16ER 27NPT	0.060	0.7	0.8	16NR 27NPT	0.060	0.7	0.8
18	16	3/8"	16ER 18NPT	0.084	0.7	0.8	16NR 18NPT	0.084	0.7	0.8
14	16	3/8"	16ER 14NPT	0.094	1.3	1.5	16NR 14NPT	0.094	1.3	1.5
11.5	16	3/8"	16ER 11.5NPT	0.107	1.3	1.5	16NR 11.5NPT	0.107	1.3	1.5
8	16	3/8"	16ER 8NPT	0.132	1.3	1.7	16NR 8NPT	0.132	1.3	1.7

BSPT (Full Form) BS21



TPI	L mm	I.C. Inch	Description External	R Max	X mm	Y mm	Description Internal	R Max	X mm	Y mm
28	06	5/32"	-	-	-	-	06NR 28BSPT	0.125	0.5	0.6
19	11	1/4"	-	-	-	-	11NR 19BSPT	0.184	0.7	0.8
28	11	1/4"	-	-	-	-	11NR 28BSPT	0.125	0.7	0.8
19	11	1/4"	-	-	-	-	11NR 19BSPT	0.184	0.7	0.8
28	16	3/8"	16ER 28BSPT	0.125	0.7	0.8	16NR 28BSPT	0.125	0.7	0.8
19	16	3/8"	16ER 19BSPT	0.18	0.7	0.8	16NR 19BSPT	0.184	0.7	0.8
14	16	3/8"	16ER 14BSPT	0.249	1.3	1.5	16NR 14BSPT	0.249	1.3	1.5
11	16	3/8"	16ER 11BSPT	0.317	1.3	1.5	16NR 11BSPT	0.317	1.3	1.5

GROOVING

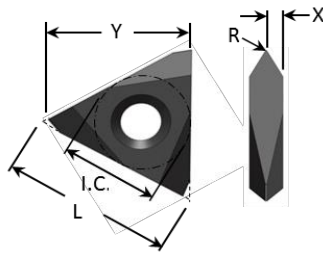


L mm	I.C. Inch	Description External	X mm	Y mm	Description Internal	X mm	Y mm	W mm	D mm	R mm
16	3/8"	16ER GW0.5	1.3	0.35	16NR GW0.5	1.3	0.35	0.50	1.00	0.10
16	3/8"	16ER GW1.0	1.3	0.60	16NR GW1.0	1.3	0.60	1.00	1.80	0.10
16	3/8"	16ER GW1.5	1.3	0.85	16NR GW1.5	1.3	0.85	1.50	2.00	0.10
16	3/8"	16ER GW2.0	1.3	1.10	16NR GW2.0	1.3	1.10	2.00	2.00	0.10

Left Hand Insert designation: EL or NL: 16EL 14NPT / 16NL 14NPT

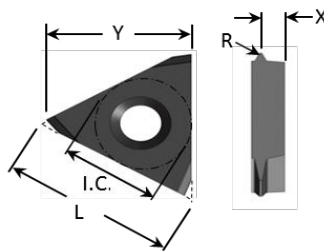
INSERTS ON EDGE STYLE

Partial Profile 55° - 60°



Pitch	TPI	L mm	I.C. Inch	Description External	R Max	W mm	D mm	X mm	Y mm
0.5 - 3.0	48 - 8	16	3/8"	TNEC32 NV60	0.07	-	-	1.588	13.43
0.5 - 3.0	48 - 8	16	3/8"	TNEC32 NV55	0.07	-	-	1.588	13.43
0.5 - 4.5	48 - 8	22	1/2"	TNEC43 NV60	0.07	-	-	2.381	18.64
0.5 - 4.5	48 - 8	22	1/2"	TNEC43 NV55	0.07	-	-	2.381	18.64

ISO DIN13



Pitch	TPI	L mm	I.C. Inch	Description External	R Max	W mm	D mm	X mm	Y mm
0.5	-	16	3/8"	TNEC32 ISO 0.5E	0.072	-	-	2.60	13.43
0.75	-	16	3/8"	TNEC32 ISO 0.75E	0.108	-	-	1.59	13.43
1	-	16	3/8"	TNEC32 ISO 1.0E	0.144	-	-	2.39	13.43
1.25	-	16	3/8"	TNEC32 ISO 1.25E	0.180	-	-	2.27	13.43
1.5	-	16	3/8"	TNEC32 ISO 1.5E	0.216	-	-	2.15	13.43
1.75	-	16	3/8"	TNEC32 ISO 1.75E	0.252	-	-	2.03	13.43
2	-	16	3/8"	TNEC32 ISO 2.0E	0.288	-	-	1.91	13.43
1.5	-	22	1/2"	TNEC43 ISO 1.5E	0.216	-	-	3.70	18.64
1.75	-	22	1/2"	TNEC43 ISO 1.75E	0.252	-	-	3.60	18.64
2.0	-	22	1/2"	TNEC43 ISO 2.0E	0.288	-	-	3.48	18.64
2.5	-	22	1/2"	TNEC43 ISO 2.5E	0.360	-	-	3.20	18.64
3.0	-	22	1/2"	TNEC43 ISO 3.0E	0.432	-	-	3.00	18.64

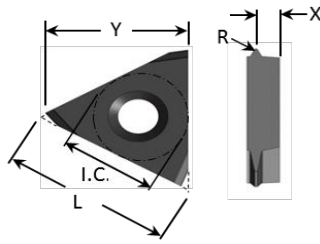
Unified 'UN' (Full Form) ASME/ANSI B1.1

Pitch	TPI	L mm	I.C. Inch	Description External	R Max	W mm	D mm	X mm	Y mm
-	20	16	3/8"	TNEC32 UN 20E	0.183	-	-	2.27	13.43
-	18	16	3/8"	TNEC32 UN 18E	0.203	-	-	2.21	13.43
-	16	16	3/8"	TNEC32 UN 16E	0.229	-	-	2.14	13.43
-	14	16	3/8"	TNEC32 UN 14E	0.261	-	-	2.03	13.43
-	12	16	3/8"	TNEC32 UN 12E	0.305	-	-	1.90	13.43
-	12	22	1/2"	TNEC43 UN 12E	0.305	-	-	3.49	18.64
-	10	22	1/2"	TNEC43 UN 10E	0.366	-	-	3.30	18.64
-	8	22	1/2"	TNEC43 UN 8E	0.457	-	-	3.00	18.64

Left Hand Insert designation: **EL : TNEC32 UN 20EL**

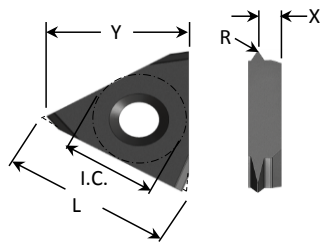
INSERTS ON EDGE STYLE

WHITWORTH 55° (Full Form) DIN 2999/BS84



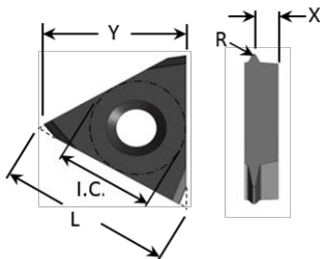
Pitch	TPI	L mm	I.C. Inch	Description External	R Max	W mm	D mm	X mm	Y mm
-	19	16	3/8"	TNEC32 WHIT 19E	0.184	-	-	2.20	13.43
-	14	16	3/8"	TNEC32 WHIT 14E	0.249	-	-	1.90	13.43
-	11	22	1/2"	TNEC43 WHIT 11E	0.317	-	-	3.30	18.64
-	10	22	1/2"	TNEC43 WHIT 10E	0.349	-	-	3.20	18.64

NPT (full form) ASME/ANSI B1.20.1



Pitch	TPI	L mm	I.C. Inch	Description External	R Max	W mm	D mm	X mm	Y mm
-	27	16	3/8"	TNEC32 NPT 27E	0.060	-	-	2.40	13.43
-	18	16	3/8"	TNEC32 NPT 18E	0.084	-	-	2.20	13.43
-	14	16	3/8"	TNEC32 NPT 14E	0.094	-	-	2.00	13.43
-	14	22	1/2"	TNEC43 NPT 14E	0.094	-	-	3.50	18.64
-	11.5	22	1/2"	TNEC43 NPT 11.5E	0.107	-	-	3.30	18.64

BSPT (Full Form) BS21

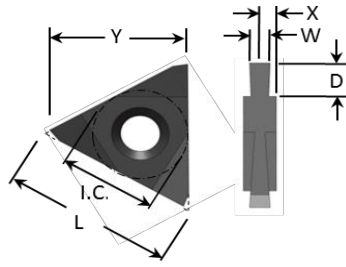


Pitch	TPI	L mm	I.C. Inch	Description External	R Max	W mm	D mm	X mm	Y mm
-	19	16	3/8"	TNEC32 BSPT 19E	0.184	-	-	2.15	13.43
-	14	16	3/8"	TNEC32 BSPT14E	0.249	-	-	1.95	13.43
-	11	22	1/2"	TNEC43 BSPT 11E	0.317	-	-	3.30	18.64

Left Hand Insert designation: EL : TNEC32 BSPT 14EL

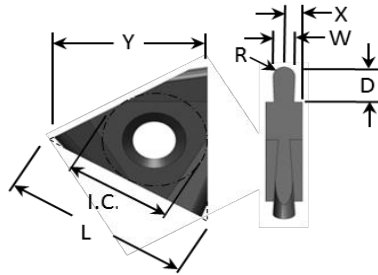
INSERTS ON EDGE STYLE

Square Grooving



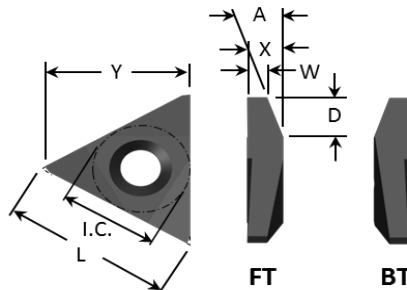
Pitch	TPI	L mm	I.C. Inch	Description External	R Max	W mm	D mm	X mm	Y mm
-	-	16	3/8"	TNEC32 NGC W0.5	0.050	0.50	2.00	1.59	13.43
-	-	16	3/8"	TNEC32 NGC W1.0	0.050	1.00	2.50	1.59	13.43
-	-	16	3/8"	TNEC32 NGC W1.5	0.050	1.50	3.60	1.59	13.43
-	-	16	3/8"	TNEC32 NGC W2.0	0.050	2.00	3.60	1.59	13.43
-	-	16	3/8"	TNEC32 NGC W2.5	0.050	2.50	3.60	1.59	13.43
-	-	22	1/2"	TNEC43 NGC W1.5	0.050	1.50	4.10	2.38	18.64
-	-	22	1/2"	TNEC43 NGC W2.0	0.050	2.00	4.10	2.38	18.64
-	-	22	1/2"	TNEC43 NGC W2.5	0.050	2.50	4.10	2.38	18.64
-	-	22	1/2"	TNEC43 NGC W3.0	0.050	3.00	5.00	2.38	18.64

Radius Grooving



Pitch	TPI	L mm	I.C. Inch	Description External	R Max	W mm	D mm	X mm	Y mm
-	-	16	3/8"	TNEC32 NGC R1.0	0.50	1.00	2.50	1.59	13.43
-	-	16	3/8"	TNEC32 NGC R1.5	0.75	1.50	3.50	1.59	13.43
-	-	16	3/8"	TNEC32 NGC R2.0	1.00	2.00	3.50	1.59	13.43
-	-	22	1/2"	TNEC43 NGC R2.5	1.25	2.50	5.00	2.38	18.64
-	-	22	1/2"	TNEC43 NGC R3.0	1.50	3.00	5.00	2.38	18.64

Turning

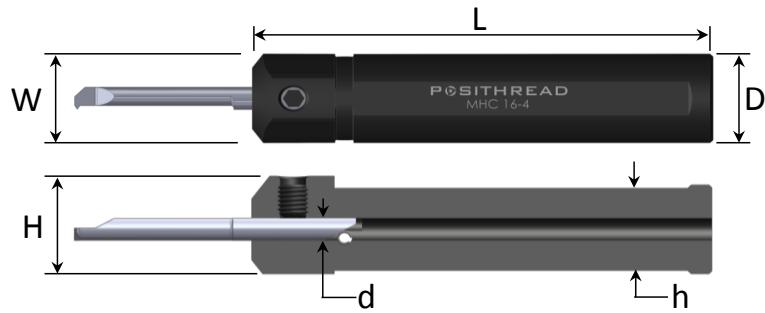


Pitch	TPI	L mm	I.C. Inch	Description External	A Degrees	W mm	D Max	X mm	Y mm
-	-	22	1/2"	TNEC43 FT 2.0	20	2.00	5.00	4.76	13.43
-	-	22	1/2"	TNEC43 BT 2.0	20	2.00	5.00	4.76	13.43

Right and Left Hand Inserts available on request:

MINI SERIES

ROUND SHANK TOOLHOLDERS



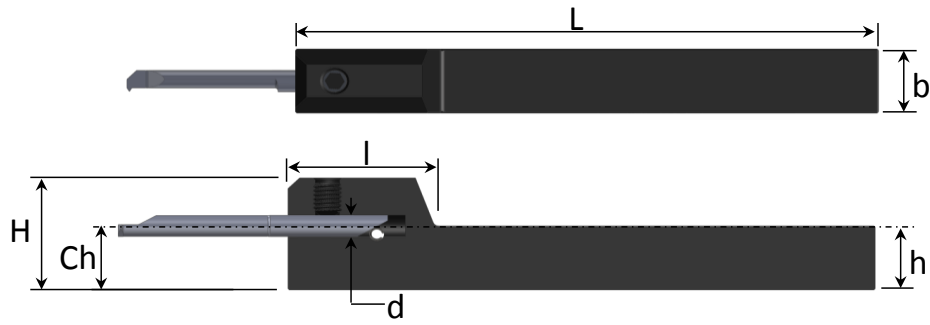
PART No.	DIMENSIONS (mm)				SPARES		INSERT Ø
	D=W	H	h	L	Screw	Torq Key	d
MHC 10-4	10	14.0	8.8	65	SL7DT15	T15	4.0
MHC 12-4	12	16.0	10.8	70			
MHC 16-4	16	17.6	14.8	75			
MHC 20-4	20	22.0	18.8	84			
MHC 10-5	10	14.0	8.8	65	SL7DT15	T15	5.0
MHC 12-5	12	16.0	10.8	70			
MHC 16-5	16	18.6	14.8	75			
MHC 20-5	20	22.0	18.8	84			
MHC 12-6	12	16.0	10.8	70	SL7DT15	T15	6.0
MHC 16-6	16	18.6	14.8	75			
MHC 20-6	20	22.0	18.8	84			

IMPERIAL ROUND SHANK TOOLHOLDERS

PART No.	DIMENSIONS (mm)					SPARES		INSERT Ø
	D	W	H	h	L	Screw	Torq Key	d
MHC 0500-4	12.7/.500"	13	16.4	10	70	SL7DT15	T15	4.0
MHC 0625-4	15.875/.625"	16	18.6	14	75			
MHC 0750-4	19.05/.750"	21	21.0	18	90			
MHC 0500-5	12.7/.500"	13	16.4	10	70	SL7DT15	T15	5.0
MHC 0625-5	15.875/.625"	16	18.6	14	75			
MHC 0750-5	19.05/.750"	21	21.0	18	90			
MHC 0500-6	12.7/.500"	13	16.4	10	70	SL7DT15	T15	6.0
MHC 0625-6	15.875/.625"	16	18.6	14	75			
MHC 0750-6	19.05/.750"	21	21.0	18	90			

MINI SERIES

SQUARE SHANK TOOLHOLDERS



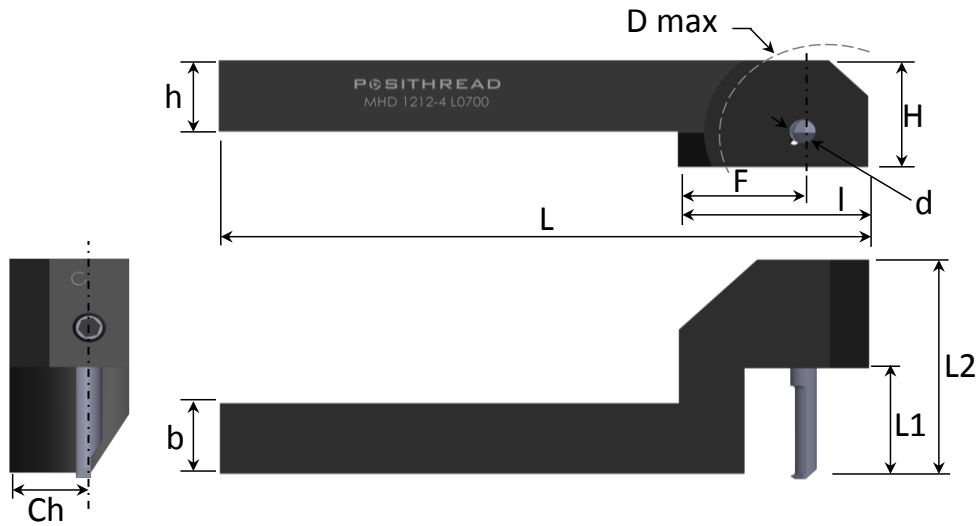
PART No.	DIMENSIONS (mm)				SPARES		INSERT Ø
	Ch=h=b	H	L	l	Screw	Torq Key	d
MHS 1010-4	10	19.0	100	25	SL7DT15	T15	4.0
MHS 1010-5	10	19.5	100	25			5.0
MHS 1212-4	12	21.0	100	25			4.0
MHS 1212-5	12	21.5	100	27			5.0
MHS 1212-6	12	22.0	100	27			6.0

IMPERIAL SQUARE SHANK TOOLHOLDERS

PART No.	DIMENSIONS (mm)				SPARES		INSERT Ø
	Ch=h=b	H	L	l	Screw	Torq Key	d
MHS 0500-4	12.7/.500"	21.0	101.6/4.0"	25	SL7DT15	T15	4.0
MHS 0625-4	15.9/.625"	25.0	127/5.0"	25			5.0
MHS 0500-5	12.7/.500"	21.5	101.6/4.0"	27			4.0
MHS 0625-5	15.9/.625"	25.5	127/5.0"	35			5.0
MHS 0500-6	12.7/.500"	22.0	101.6/4.0"	27			6.0
MHS 0625-6	15.9/.625"	26.0	127/5.0"	35			6.0

MINI SERIES

DROP HEAD TOOLHOLDERS



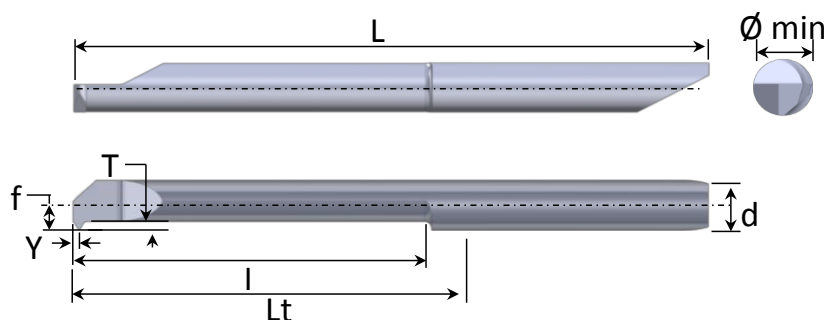
PART No.	DIMENSIONS (mm)								SPARES		INSERT Ø
	Ch=h=b	L2	H	L	I	F	D max	L1	Screw	Torq Key	d
MHD 1010-4 L0500		31.5						13			4.0
MHD 1010-5 L0800	10.0	48.0	16					23			5.0
MHD 1010-6 L1000		53.0						28			6.0
MHD 1212-4 L0700		36.5		99	29	19	26	18	SL7DT15	T15	4.0
MHD 1212-5 L0800	12.0	48.0	18					23			5.0
MHD 1212-6 L1000		53.0						28			6.0

IMPERIAL DROP HEAD TOOLHOLDERS

PART No.	DIMENSIONS (mm)								SPARES		INSERT Ø
	Ch=h=b	L2	H	L	I	F	D max	L1	Screw	Torq Key	d
MHD 0375-4 L0700		36.5						18			4.0
MHD 0375-5 L0800	9.525	48.0	16					23			5.0
MHD 0375-6 L1000		53.0		99	29	19	26	23	SL7DT15	T15	6.0
MHD 0500-4 L0700		36.5						18			4.0
MHD 0500-5 L0800	12.7	48.0	19					23			5.0
MHD 0500-6 L1000		53.0						28			6.0

MINI SERIES

THREADING BARS



ISO

Thread	Ø Min mm	PART No.	DIMENSIONS (mm)						
			Pitch mm	f	Y	l	Lt	L	d
M4x0.5	3.4	CTR429 0.5ISO L16 DBC	0.5	0.9	0.25	16.0	18.4	35.4	4.0
M5x0.5	4.4	CTR439 0.5ISO L16 DBC	0.5	1.9	0.25	16.0	18.4	35.4	4.0
M4x0.7	3.2	CTR429 0.7ISO L16 DBC	0.7	0.9	0.35	16.0	18.4	35.4	4.0
M5x0.8	4.0	CTR429 0.8ISO L16 DBC	0.8	1.9	0.4	16.0	18.4	35.4	4.0
M6x1.0	4.8	CTR439 1.0ISO L16 DBC	1.0	1.7	0.5	16.0	18.4	35.4	4.0
M5.5x0.5	4.9	CTR542 0.5ISO L16 DBC	0.5	1.73	0.5	16.0	18.35	41.2	5.0
M5.5x0.75	4.6	CTR542 0.75ISO L16 DBC	0.75	1.7	0.36	16.0	18.35	41.2	5.0
M7x1.0	5.8	CTR549 1.0ISO L16 DBC	1.0	2.4	0.5	16.0	18.35	41.2	5.0
M6x0.5	5.4	CTR649 0.5ISO L16 DBC	0.5	1.9	0.25	16.0	15.5	42.2	6.0
M6.5x0.75	5.6	CTR649 0.75ISO L16 DBC	0.75	1.9	0.36	16.0	18.5	42.2	6.0
M7.5x1.0	6.3	CTR659 1.0ISO L16 DBC	1.0	2.9	0.5	16.0	18.5	42.2	6.0
M8x1.25	6.5	CTR659 1.25ISO L16 DBC	1.25	2.9	0.63	16.0	18.5	42.2	6.0
M10x1.5	8.3	CTR659 1.5ISO L16 DBC	1.5	2.9	1.0	16.0	18.5	42.2	6.0

Unified 'UN' (Full Form) ASME/ANSI B1.1

Thread	Ø Min mm	PART No.	DIMENSIONS (mm)						
			TPI	f	Y	l	Lt	L	d
No 8-32UNC	3.3	CTR429 32UN L16 DBC	32	0.92	0.4	16.0	18.4	35.4	4.0
No 10-28UNS	3.6	CTR429 28UN L16 DBC	28	0.92	0.46	16.0	18.4	35.4	4.0
1/4"-27UNS	5.3	CTR549 27UN L16 DBC	27	2.4	0.47	16.0	18.35	41.2	5.0
1/4"-24UNS	5.1	CTR542 24UN L16 DBC	24	1.7	0.53	16.0	18.35	41.2	5.0
1/4"-20UNC	4.6	CTR542 20UN L16 DBC	20	1.7	0.64	16.0	18.35	42.2	5.0
5/16"-18UNC	6.3	CTR659 18UN L16 DBC	18	2.9	0.71	16.0	18.5	42.2	6.0
3/8"-16UNC	7.7	CTR659 16UN L16 DBC	16	2.9	0.79	16.0	18.5	42.2	6.0

Partial Profile 60°

Pitch mm/ TPI	Ø Min mm	PART No.	DIMENSIONS (mm)						
			f	Y	l	Lt	L	d	
0.5-1.0 / 48-24	3.2	CTR429 AF60 L16 DBC	-	0.9	0.51	16	18.4	35.4	4.0
0.5-1.0 / 48-24	4.2	CTR439 AF60 L16 DBC	-	1.9	0.51	16	18.4	35.4	4.0
0.5-1.5 / 48-16	6.2	CTR659 A60 L16 DBC	-	2.9	0.71	16	18.5	42.2	6.0

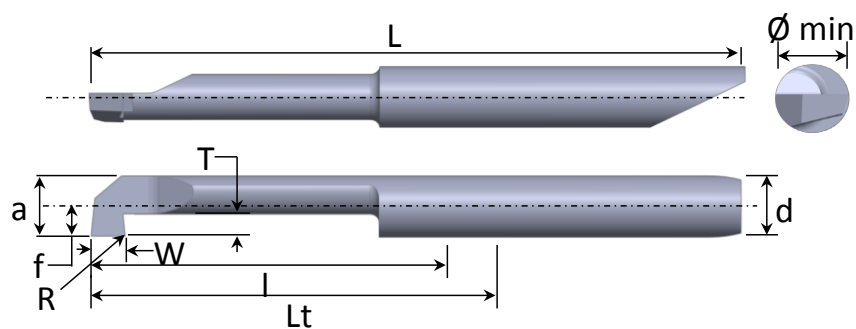
Partial Profile 55°

Pitch mm/ TPI	Ø Min mm	PART No.	DIMENSIONS (mm)						
			f	Y	l	Lt	L	d	
0.5-1.0 / 48-24	3.2	CTR429 AF55 L16 DBC	-	0.9	0.55	16	18.4	35.4	4.0
0.5-1.0 / 48-24	4.2	CTR439 AF55 L16 DBC	-	1.9	0.55	16	18.4	35.4	4.0
0.5-1.5 / 48-16	6.2	CTR659 A55 L16 DBC	-	2.9	0.77	16	18.5	42.2	6.0

Left Hand Inserts available on request:

MINI SERIES

SQUARE GROOVING BARS

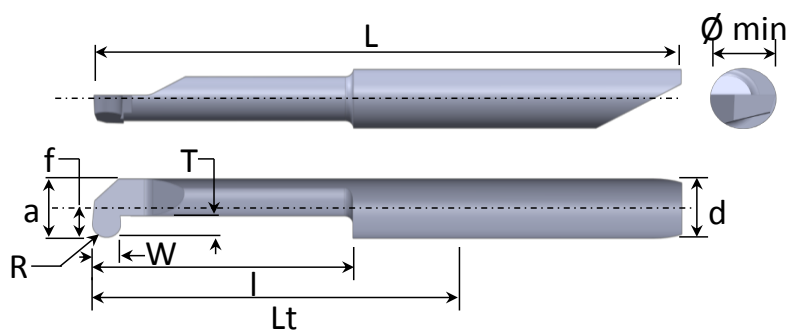


Ø Min mm	PART No.	DIMENSIONS (mm)								
		W	T	R	f	a	l	Lt	L	d
4.2	CGR439 W0.5 L10 DBC	0.5	0.9	0.1	1.9	3.9	10.0	11.5	28.5	4.0
4.2	CGR439 W0.5 L15 DBC	0.5	0.9	0.1	1.9	3.9	15.0	18.4	35.2	4.0
4.2	CGR439 W0.5 L20 DBC	0.5	0.9	0.1	1.9	3.9	20.0	22.8	39.8	4.0
5.2	CGR549 W0.5 L10 DBC	0.5	1.0	0.1	2.4	4.9	10.0	12.15	35.0	5.0
5.2	CGR549 W0.5 L15 DBC	0.5	1.0	0.1	2.4	4.9	15.0	18.15	41.0	5.0
5.2	CGR549 W0.5 L20 DBC	0.5	1.0	0.1	2.4	4.9	20.0	23.15	46.0	5.0
5.2	CGR549 W1.0 L10 DBC	1.0	1.0	0.1	2.4	4.9	10.0	12.15	35.0	5.0
5.2	CGR549 W1.0 L15 DBC	1.0	1.0	0.1	2.4	4.9	15.0	18.15	41.0	5.0
5.2	CGR549 W1.0 L20 DBC	1.0	1.0	0.1	2.4	4.9	20.0	23.15	46.0	5.0
5.2	CGR549 W1.5 L10 DBC	1.5	1.0	0.1	2.4	4.9	10.0	12.15	35.0	5.0
5.2	CGR549 W1.5 L15 DBC	1.5	1.0	0.1	2.4	4.9	15.0	18.15	41.0	5.0
5.2	CGR549 W1.5 L20 DBC	1.5	1.0	0.1	2.4	4.9	20.0	23.15	46.0	5.0
6.2	CGR659 W0.5 L10 DBC	0.5	1.8	0.1	2.9	5.9	10.0	12.3	36.0	6.0
6.2	CGR659 W0.5 L15 DBC	0.5	1.8	0.1	2.9	5.9	15.0	18.3	42.0	6.0
6.2	CGR659 W0.5 L20 DBC	0.5	1.8	0.1	2.9	5.9	20.0	23.3	47.0	6.0
6.2	CGR659 W1.0 L10 DBC	1.0	1.8	0.1	2.9	5.9	10.0	12.3	36.0	6.0
6.2	CGR659 W1.0 L15 DBC	1.0	1.8	0.1	2.9	5.9	15.0	18.3	42.0	6.0
6.2	CGR659 W1.0 L20 DBC	1.0	1.8	0.1	2.9	5.9	20.0	23.3	47.0	6.0
6.2	CGR659 W1.5 L10 DBC	1.5	1.8	0.1	2.9	5.9	10.0	12.3	36.0	6.0
6.2	CGR659 W1.5 L15 DBC	1.5	1.8	0.1	2.9	5.9	15.0	18.3	42.0	6.0
6.2	CGR659 W1.5 L20 DBC	1.5	1.8	0.1	2.9	5.9	20.0	23.3	47.0	6.0

Left Hand Inserts available on request:

MINI SERIES

ROUND GROOVING BARS



Ø Min mm	PART No.	DIMENSIONS (mm)								
		W	T	R	f	a	l	Lt	L	d
4.2	CRR439 R0.5 L15 DBC	1.0	0.8	0.5	1.9	3.9	15.0	18.4	35.2	4.0
5.2	CRR549 R0.5 L20 DBC	1.0	1.0	0.5	2.4	4.9	20.0	23.15	46.0	5.0
5.2	CRR549 R0.75 L20 DBC	1.5	1.0	0.75	2.4	4.9	20.0	23.15	46.0	5.0
5.2	CRR549 R1.0 L20 DBC	2.0	1.0	1.0	2.4	4.9	20.0	23.15	46.0	5.0
6.2	CRR659 R0.5 L20 DBC	1.0	1.8	0.5	2.9	5.9	20.0	28.3	52.0	6.0
6.2	CRR659 R0.75 L20 DBC	1.5	1.8	0.75	2.9	5.9	20.0	28.3	52.0	6.0
6.2	CRR659 R1.0 L20 DBC	2.0	1.8	1.0	2.9	5.9	20.0	28.3	52.0	6.0

Left Hand Inserts available on request:

LAYDOWN AND MINI SERIES

SPEEDS AND FEEDS FOR LAYDOWN THREADING AND GROOVING INSERTS

Materials Specification	PTC2	PTX	DBC
	Metres per Min		
Low/Med Carbon Steel	150 / 200	210 / 250	184 / 259
High Carbon Steel	130 / 180	150 / 210	131 / 217
Alloy Heat Treated Steel	120 / 150	140 / 180	123 / 186
Stainless Steel 316-17-4PH	90 / 115	105 / 135	92 / 140
Stainless Steel 410	115 / 128	135 / 150	118 / 155
Inconel 718		27 / 33	24 / 34
Cast Iron HB 180-250	110 / 140	130 / 180	114 / 186
Non Ferrous Materials	200 / 250	200 / 300	175 / 311
Aerospace Type Materials		40 / 80	35 / 83

General Purpose

PTC2

TiN coating is a multi purpose coating suited to low and medium cutting speeds.

Premium Grades

PTX

AlTiN coating, very good all round grade, increased tool life over PTC2 by up to 50%
Heat Resistance

DBC

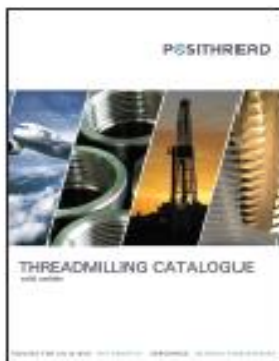
TiSiN coating developed for hard materials, high chrome steels and exotic materials.
Heat Resistance and Oxidation Resistance at cutting temperatures of over 1000°C

SPEEDS AND FEEDS FOR MINI SERIES THREADING AND GROOVING INSERTS

Materials Specification	DBC	FEED
	Metres per Min	f(mm/rev)
Low/Med Carbon Steel	129 / 181	0.05
High Carbon Steel	92 / 152	0.05
Alloy Heat Treated Steel	86 / 130	0.05
Stainless Steel 316-17-4PH	64 / 98	0.05
Stainless Steel 410	83 / 109	0.05
Inconel 718	17 / 24	0.03
Cast Iron HB 180-250	80 / 130	0.04
Non Ferrous Materials	123 / 217	0.04
Aerospace Type Materials	25 / 58	0.03

DBC

TiSiN coating developed for hard materials, high chrome steels and exotic materials.
Heat Resistance and Oxidation Resistance at cutting temperatures of over 1000°C



POSITHREAD

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