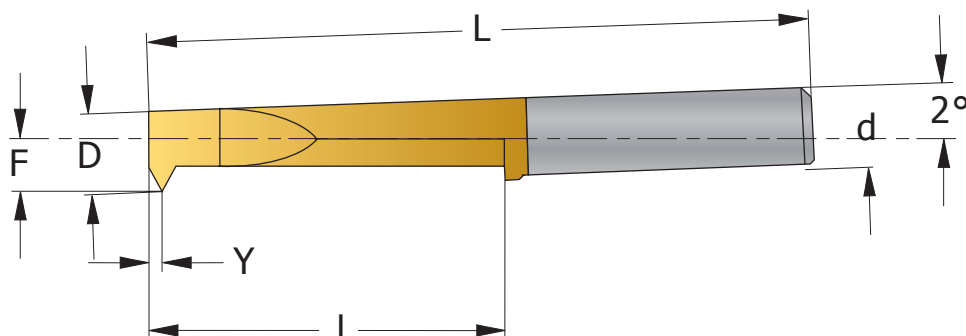


# THREAD TURNING INSERTS

## Micro



## 60°

### PARTIAL PROFILE 60°

Pitch mm	TPI	D mm	INTERNAL Part Number	d mm	l mm	L mm	F mm	Y mm
0,2-0,4	80 - 64	0,8	WR308_P60_BC	3	4	24	0,5	0,2
0,2-0,6	80 - 44	1,6	WR316_P60_BC	3	7	24	0,75	0,3
0,2-0,8	80 - 32	2,2	WR322_P60_BC	3	10	24	1,25	0,4
0,2-1,0	80 - 28	3,0	WR330_P60_BC	3	12	24	1,5	0,5
0,25-1,25	80 - 20	4,0	WR440_P60_BC	4	16,5	32	2	0,6
0,25-1,5	80 - 18	5,0	WR550_P60_BC	5	21	40	2,5	0,7
0,25-1,75	80 - 14	6,0	WR660_P60_BC	6	27	48	3	0,8
0,35-2,5	72 - 10	8,0	WR880_P60_BC	8	45	72	4	1,2

## 55°

### PARTIAL PROFILE 55°

Pitch mm	TPI	D mm	INTERNAL Part Number	d mm	l mm	L mm	F mm	Y mm
0,25-1,25	80 - 20	4,0	WR440_P55_BC	4	16,5	32	2	0,6
0,25-1,75	80 - 18	6,0	WR660_P55_BC	6	27	48	3	0,8

■ Also available for Grooving and Turning

## Minimum Bore Diameter

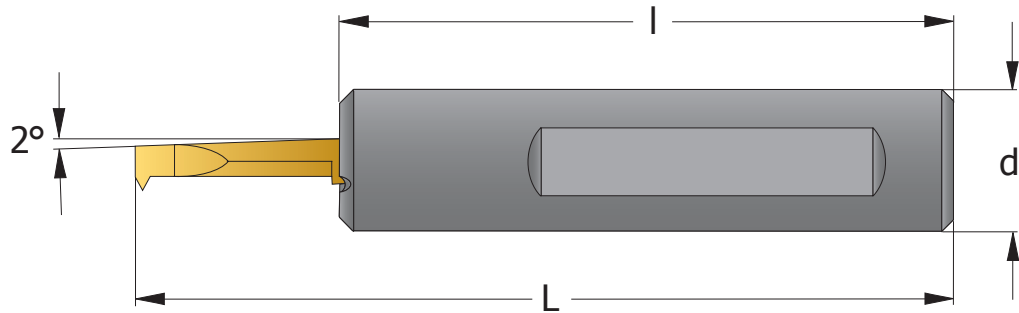
To obtain highest possible stability the threading inserts are ground in an angle of 2°. Therefore the minimum bore diameter is dependent on the thread length according to the table below.

D mm	Thread Length (mm)															
	2	4	6	8	10	12	14	16	18	21	24	27	30	35	40	45
0,8	0,87	0,94														
1,6	1,67	1,74	1,81													
2,2	2,27	2,34	2,41	2,48	2,55											
3,0	3,07	3,14	3,21	3,28	3,35	3,42										
4,0	4,07	4,14	4,21	4,28	4,35	4,42	4,49	4,56								
5,0	5,07	5,14	5,21	5,28	5,35	5,42	5,49	5,56	5,63	5,74						
6,0	6,07	6,14	6,21	6,28	6,35	6,42	6,49	6,56	6,63	6,74	6,84	6,95				
8,0	8,07	8,14	8,21	8,28	8,35	8,42	8,49	8,56	8,63	8,74	8,84	8,95	9,05	9,23	9,40	9,58

■ Minimum Bore Diameter = D + (thread length x 0,035)

# THREAD TURNING TOOLHOLDERS

## Micro



Insert mm	Part Number	d mm	l mm	L mm
3,0	WRC3N_0012E-2	12	70	82
3,0	WRC3N_0016F-2	16	80	92
3,0	WRC3N_0020H-2	20	100	112
3,0	WRC3N_0022J-2	22	110	122
3,0	WRC3N_0025J-2	25	110	122
4,0	WRC4N_0012E-2	12	75	91,5
4,0	WRC4N_0016F-2	16	85	101,5
4,0	WRC4N_0020H-2	20	105	121,5
4,0	WRC4N_0022J-2	22	115	131,5
4,0	WRC4N_0025J-2	25	115	131,5
5,0	WRC5N_0016G-2	16	90	111
5,0	WRC5N_0020J-2	20	110	131
5,0	WRC5N_0022J-2	22	120	141
5,0	WRC5N_0025J-2	25	120	141
6,0	WRC6N_0016G-2	16	95	121
6,0	WRC6N_0020J-2	20	115	141
6,0	WRC6N_0022K-2	22	125	151
6,0	WRC6N_0025K-2	25	125	151
8,0	WRC8N_0020J-2	20	120	165
8,0	WRC8N_0022K-2	22	130	175
8,0	WRC8N_0025K-2	25	130	175

■ Also available in 3/4" och 1" (for Citizen).

*Micro Thread Turning  
from pitch 0,2 mm.*

