

# CANELA

*API Catalog*



# Threading

• *Inserts Code Key*

**2**

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• *Threading - inserts*

**3**

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• *External Threading*

**12**

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• *Internal Threading*

**20**

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• *Technical information*

**26**

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# Inserts for threading - Code key

<b>L</b>	<b>166</b>	<b>G</b>	<b>-</b>	<b>3</b>	<b>B</b>	<b>A</b>	<b>075</b>
<b>1</b>	<b>2</b>	<b>3</b>		<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>

**1**

**R**      **L**

**2**

**3**

**G**      **L**

**6**

**A** ISO mm.  
**C** SI  
**L** ISO inch  
**K** Whitworth

**4**

	IC=inch	d=mm.
	<b>2</b> 1/4	6,35 11
	<b>3</b> 3/8	9,52 16
	<b>4</b> 1/2	12,70 22

**5**

**60°**

**B**

**7**

p-mm. x 100  
 p-inch x 10

**P**

<b>16</b>	<b>E</b>	<b>L</b>	<b>-</b>	<b>AG</b>	<b>55</b>
<b>1</b>	<b>2</b>	<b>3</b>		<b>4</b>	<b>5</b>

**1**

	IC=inch	d=mm.
	<b>11</b> 1/4	6,35
	<b>16</b> 3/8	9,52
	<b>22</b> 1/2	12,70

**2**

**E**      **N**

**3**

**R**      **L**      **R**      **L**

**4**

p=mm. x 100  
 p=inch x 10

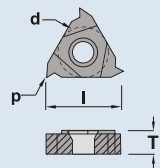
	mm.	TPI
<b>A</b>	0,5-1,5	48-16
<b>AG</b>	0,5-3,0	48-8
<b>G</b>	1,75-3,0	14-8
<b>N</b>	3,5-5,0	7-5

**5**

<b>55</b>	Partial profile 55
<b>60</b>	Partial profile 60
<b>ISO</b>	ISO metric
<b>W</b>	Whitworth, BSW
<b>BSPT</b>	Whitworth, cone
<b>UN</b>	American, UN

# Threading inserts

## 16EL-A



REF.

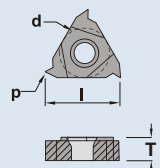
16EL-A55  
16EL-A60  
16EL-AG55  
16EL-AG60  
16EL-G55  
16EL-G60

l	T	d	p
0,650	0,125	0,375	55°
0,650	0,125	0,375	60°
0,650	0,125	0,375	55°
0,650	0,125	0,375	60°
0,650	0,125	0,375	55°
0,650	0,125	0,375	60°

KM15 PM25 PM40 TIN16 TIN17 TIN22 TIN25 TIN32 TIN41

☆  
☆  
★  
★  
☆  
☆

## 16ER-A

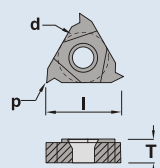


16ER-A55  
16ER-A60  
16ER-AG55  
16ER-AG60  
16ER-G55  
16ER-G60

l	T	d	p
0,650	0,125	0,375	55°
0,650	0,125	0,375	60°
0,650	0,125	0,375	55°
0,650	0,125	0,375	60°
0,650	0,125	0,375	55°
0,650	0,125	0,375	60°

☆  
☆  
★  
★  
☆  
☆

## 16EL-ISO

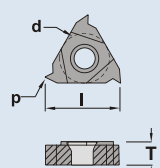


16EL-075ISO  
16EL-100ISO  
16EL-125ISO  
16EL-150ISO  
16EL-175ISO  
16EL-200ISO  
16EL-250ISO  
16EL-300ISO

l	T	d	p
0,650	0,125	0,375	0,75
0,650	0,125	0,375	1,00
0,650	0,125	0,375	1,25
0,650	0,125	0,375	1,50
0,650	0,125	0,375	1,75
0,650	0,125	0,375	2,00
0,650	0,125	0,375	2,50
0,650	0,125	0,375	3,00

★  
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## 16ER-ISO

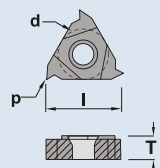


16ER-075ISO  
16ER-100ISO  
16ER-125ISO  
16ER-150ISO  
16ER-175ISO  
16ER-200ISO  
16ER-250ISO  
16ER-300ISO

l	T	d	p
0,650	0,125	0,375	0,75
0,650	0,125	0,375	1,00
0,650	0,125	0,375	1,25
0,650	0,125	0,375	1,50
0,650	0,125	0,375	1,75
0,650	0,125	0,375	2,00
0,650	0,125	0,375	2,50
0,650	0,125	0,375	3,00

★  
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★

## 16EL-W

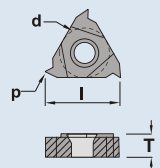


16EL-8W  
16EL-9W  
16EL-10W  
16EL-11W  
16EL-12W  
16EL-14W  
16EL-16W  
16EL-18W  
16EL-19W  
16EL-20W  
16EL-26W  
16EL-28W

l	T	d	p
0,650	0,125	0,375	08
0,650	0,125	0,375	09
0,650	0,125	0,375	10
0,650	0,125	0,375	11
0,650	0,125	0,375	12
0,650	0,125	0,375	14
0,650	0,125	0,375	16
0,650	0,125	0,375	18
0,650	0,125	0,375	19
0,650	0,125	0,375	20
0,650	0,125	0,375	26
0,650	0,125	0,375	28

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## 16ER-W



16ER-8W  
16ER-9W  
16ER-10W  
16ER-11W  
16ER-12W  
16ER-14W  
16ER-16W  
16ER-18W  
16ER-19W  
16ER-20W  
16ER-26W  
16ER-28W

l	T	d	p
0,650	0,125	0,375	08
0,650	0,125	0,375	09
0,650	0,125	0,375	10
0,650	0,125	0,375	11
0,650	0,125	0,375	12
0,650	0,125	0,375	14
0,650	0,125	0,375	16
0,650	0,125	0,375	18
0,650	0,125	0,375	19
0,650	0,125	0,375	20
0,650	0,125	0,375	26
0,650	0,125	0,375	28

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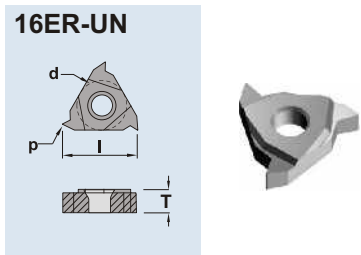
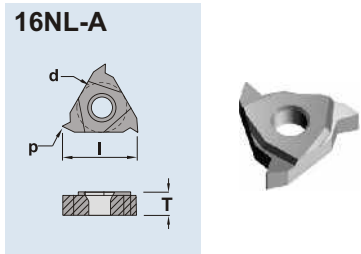
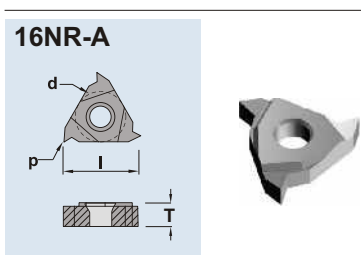
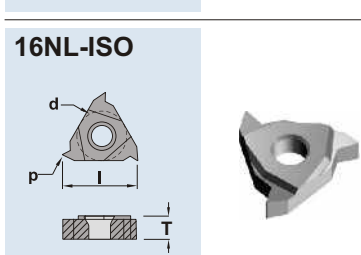

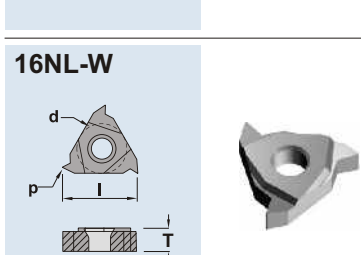
★ Normally available for immediate delivery.  
☆ Only available in a limited quantity.

REF.

T d r H

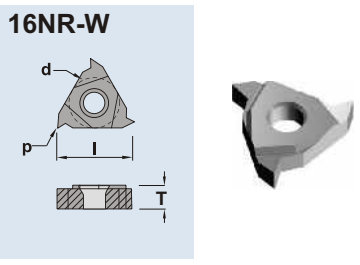
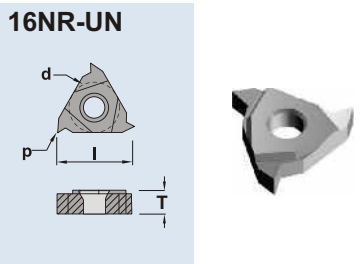
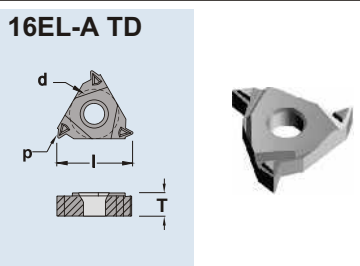
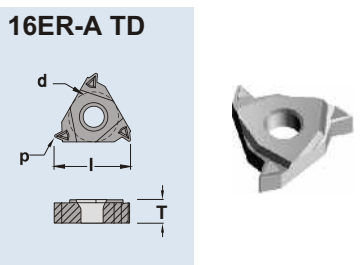
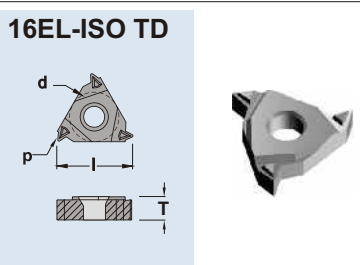
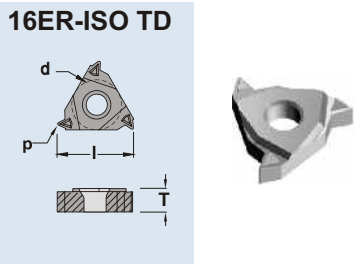
KM15 PM25 PM40 TIN16 TIN17 TIN22 TIN25 TIN32 TIN41

# Threading inserts

	REF.	l	T	d	p	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32	TIN41
<b>16ER-UN</b> 	16ER-11UN	0,650	0,125	0,375	11		☆							
	16ER-14UN	0,650	0,125	0,375	14		☆							
	16ER-18UN	0,650	0,125	0,375	18		☆							
<b>16NL-A</b> 	16NL-A55	0,650	0,125	0,375	55°		☆							
	16NL-A60	0,650	0,125	0,375	60°		★							
	16NL-AG60	0,650	0,125	0,375	60°		★							
	16NL-G55	0,650	0,125	0,375	55°		☆							
	16NL-G60	0,650	0,125	0,375	60°		☆							
<b>16NR-A</b> 	16NR-A55	0,650	0,125	0,375	55°		☆							
	16NR-A60	0,650	0,125	0,375	60°		☆							
	16NR-AG55	0,650	0,125	0,375	55°		★							
	16NR-AG60	0,650	0,125	0,375	60°		★							
	16NR-G55	0,650	0,125	0,375	55°		☆							
	16NR-G60	0,650	0,125	0,375	60°		☆							
<b>16NL-ISO</b> 	16NL-075ISO	0,650	0,125	0,375	0,75		★							
	16NL-100ISO	0,650	0,125	0,375	1,00		★							
	16NL-125ISO	0,650	0,125	0,375	1,25		★							
	16NL-150ISO	0,650	0,125	0,375	1,50		★							
	16NL-175ISO	0,650	0,125	0,375	1,75		★							
	16NL-200ISO	0,650	0,125	0,375	2,00		★							
	16NL-250ISO	0,650	0,125	0,375	2,50		★							
16NL-300ISO	0,650	0,125	0,375	3,00		★								
<b>16NR-ISO</b> 	16NR-075ISO	0,650	0,125	0,375	0,75		★							
	16NR-100ISO	0,650	0,125	0,375	1,00		★							
	16NR-125ISO	0,650	0,125	0,375	1,25		★							
	16NR-150ISO	0,650	0,125	0,375	1,50		★							
	16NR-175ISO	0,650	0,125	0,375	1,75		★							
	16NR-200ISO	0,650	0,125	0,375	2,00		★							
	16NR-250ISO	0,650	0,125	0,375	2,50		★							
	16NR-300ISO	0,650	0,125	0,375	3,00		★							
<b>16NL-W</b> 	16NL-8W	0,650	0,125	0,375	08		☆							
	16NL-9W	0,650	0,125	0,375	09		☆							
	16NL-10W	0,650	0,125	0,375	10		☆							
	16NL-11W	0,650	0,125	0,375	11		☆							
	16NL-12W	0,650	0,125	0,375	12		☆							
	16NL-14W	0,650	0,125	0,375	14		☆							
	16NL-16W	0,650	0,125	0,375	16		★							
	16NL-18W	0,650	0,125	0,375	18		☆							
	16NL-19W	0,650	0,125	0,375	19		☆							
	16NL-20W	0,650	0,125	0,375	20		☆							
	16NL-26W	0,650	0,125	0,375	26		☆							
16NL-28W	0,650	0,125	0,375	28		☆								
	REF.	T	d	r	H	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32	TIN41

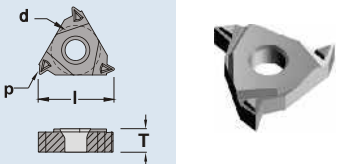
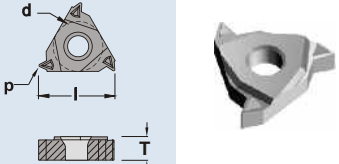
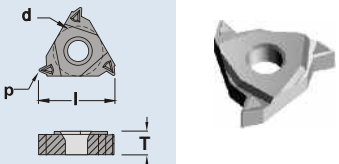
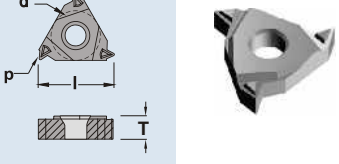
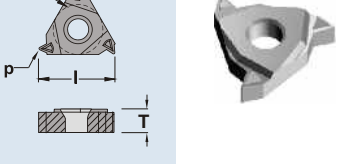
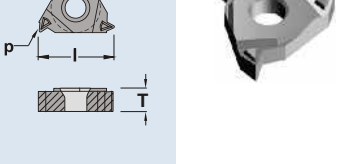
★ Normally available for immediate delivery.  
 ☆ Only available in a limited quantity.

# Threading inserts

	REF.	l	T	d	p	KM15	PM25	PM40	TiN16	TiN17	TiN22	TiN25	TiN32	TiN41
<b>16NR-W</b> 	16NR-8W	0,650	0,125	0,375	08		☆							
	16NR-9W	0,650	0,125	0,375	09		☆							
	16NR-10W	0,650	0,125	0,375	10		☆							
	16NR-11W	0,650	0,125	0,375	11		★							
	16NR-12W	0,650	0,125	0,375	12		★							
	16NR-14W	0,650	0,125	0,375	14		☆							
	16NR-16W	0,650	0,125	0,375	16		★							
	16NR-18W	0,650	0,125	0,375	18		★							
	16NR-19W	0,650	0,125	0,375	19		☆							
	16NR-20W	0,650	0,125	0,375	20		☆							
	16NR-26W	0,650	0,125	0,375	26		☆							
16NR-28W	0,650	0,125	0,375	28		☆								
<b>16NR-UN</b> 	16NR-20UN	0,650	0,125	0,375	20		☆							
	16NR-24UN	0,650	0,125	0,375	24		☆							
<b>16EL-A TD</b> 	16EL-A60 TD	0,650	0,125	0,375	60°							★		
	16EL-AG55 TD	0,650	0,125	0,375	55°							★		
	16EL-AG60 TD	0,650	0,125	0,375	60°							★		
	16EL-G55 TD	0,650	0,125	0,375	55°							★		
	16EL-G60 TD	0,650	0,125	0,375	60°							★		
<b>16ER-A TD</b> 	16ER-A60 TD	0,650	0,125	0,375	60°							★		
	16ER-AG55 TD	0,650	0,125	0,375	55°							★		
	16ER-AG60 TD	0,650	0,125	0,375	60°							★		
	16ER-G55 TD	0,650	0,125	0,375	55°							★		
	16ER-G60 TD	0,650	0,125	0,375	60°							★		
<b>16EL-ISO TD</b> 	16EL-100ISO TD	0,650	0,125	0,375	1,00							★		
	16EL-125ISO TD	0,650	0,125	0,375	1,25							★		
	16EL-150ISO TD	0,650	0,125	0,375	1,50							★		
	16EL-175ISO TD	0,650	0,125	0,375	1,75							★		
	16EL-200ISO TD	0,650	0,125	0,375	2,00							★		
	16EL-250ISO TD	0,650	0,125	0,375	2,50							★		
	16EL-300ISO TD	0,650	0,125	0,375	3,00							★		
<b>16ER-ISO TD</b> 	16ER-100ISO TD	0,650	0,125	0,375	08							★		
	16ER-125ISO TD	0,650	0,125	0,375	09							★		
	16ER-150ISO TD	0,650	0,125	0,375	10							★		
	16ER-175ISO TD	0,650	0,125	0,375	11							★		
	16ER-200ISO TD	0,650	0,125	0,375	12							★		
	16ER-250ISO TD	0,650	0,125	0,375	14							★		
	16ER-300ISO TD	0,650	0,125	0,375	16							★		
	REF.	T	d	r	H	KM15	PM25	PM40	TiN16	TiN17	TiN22	TiN25	TiN32	TiN41

★ Normally available for immediate delivery.  
 ☆ Only available in a limited quantity.

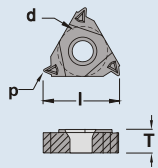
# Threading inserts

	REF.	l	T	d	p	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32	TIN41
<b>16EL-W TD</b> 	16EL-11W TD	0,650	0,125	0,375	11							☆		
	16EL-14W TD	0,650	0,125	0,375	14							☆		
	16EL-16W TD	0,650	0,125	0,375	16							☆		
<b>16ER-W TD</b> 	16ER-11W TD	0,650	0,125	0,375	11							☆		
	16ER-14W TD	0,650	0,125	0,375	14							☆		
	16ER-16W TD	0,650	0,125	0,375	16							☆		
<b>16NL-A TD</b> 	16NL-A60 TD	0,650	0,125	0,375	60°							★		
	16NL-AG55 TD	0,650	0,125	0,375	55°							★		
	16NL-AG60 TD	0,650	0,125	0,375	60°							★		
	16NL-G55 TD	0,650	0,125	0,375	55°							★		
	16NL-G60 TD	0,650	0,125	0,375	60°							★		
<b>16NR-A TD</b> 	16NR-A60 TD	0,650	0,125	0,375	60°							★		
	16NR-AG55 TD	0,650	0,125	0,375	55°							★		
	16NR-AG60 TD	0,650	0,125	0,375	60°							★		
	16NR-G55 TD	0,650	0,125	0,375	55°							★		
	16NR-G60 TD	0,650	0,125	0,375	60°							★		
<b>16NL-ISO TD</b> 	16NL-100ISO TD	0,650	0,125	0,375	1,00							★		
	16NL-125ISO TD	0,650	0,125	0,375	1,25							★		
	16NL-150ISO TD	0,650	0,125	0,375	1,50							★		
	16NL-175ISO TD	0,650	0,125	0,375	1,75							★		
	16NL-200ISO TD	0,650	0,125	0,375	2,00							★		
	16NL-250ISO TD	0,650	0,125	0,375	2,50							★		
	16NL-300ISO TD	0,650	0,125	0,375	3,00							★		
<b>16NR-ISO TD</b> 	16NR-100ISO TD	0,650	0,125	0,375	1,00							★		
	16NR-125ISO TD	0,650	0,125	0,375	1,25							★		
	16NR-150ISO TD	0,650	0,125	0,375	1,50							★		
	16NR-175ISO TD	0,650	0,125	0,375	1,75							★		
	16NR-200ISO TD	0,650	0,125	0,375	2,00							★		
	16NR-250ISO TD	0,650	0,125	0,375	2,50							★		
	16NR-300ISO TD	0,650	0,125	0,375	3,00							★		
	<b>REF.</b>	<b>T</b>	<b>d</b>	<b>r</b>	<b>H</b>	<b>KM15</b>	<b>PM25</b>	<b>PM40</b>	<b>TIN16</b>	<b>TIN17</b>	<b>TIN22</b>	<b>TIN25</b>	<b>TIN32</b>	<b>TIN41</b>

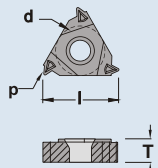
★ Normally available for immediate delivery.  
 ☆ Only available in a limited quantity.

# Threading inserts

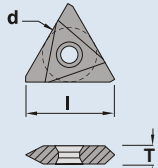
## 16NL-W TD



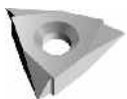
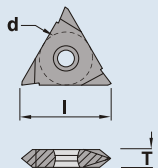
## 16NR-W TD



## TNMC



## TPMC

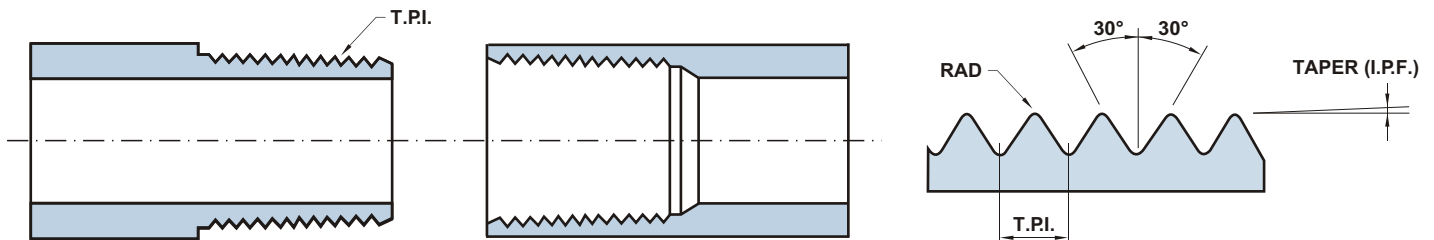


REF.	l	T	d	p	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32	TIN41
16NL-11W TD 16NL-14W TD 16NL-16W TD	0,650 0,650 0,650	0,125 0,125 0,125	0,375 0,375 0,375	11 14 16							☆ ☆ ☆		
16NR-11W TD 16NR-14W TD 16NR-16W TD	0,650 0,650 0,650	0,125 0,125 0,125	0,375 0,375 0,375	11 14 16							☆ ☆ ☆		
TNMC 1603XX TNMC 2204XX	16,50 22,00	3,18 4,76	9,52 12,70			☆ ★		☆ ☆					
TPMC 1603XX TPMC 2204XX	16,50 22,00	3,18 4,76	9,52 12,70		☆ ☆	☆ ☆							
REF.	T	d	r	H	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32	TIN41

★ Normally available for immediate delivery.  
☆ Only available in a limited quantity.

# Oilfield connectors

REF. PART NUMBER	TPI	TPI	Ratio	Angle with centre line	Connector Number / Size	Part N°
API V0.038R	4	2,000	1:6	4° 45' 49"	NC23, NC26, NC31, NC35, NC40, NC44, NC46 NC50, 4FH, 2 $\frac{3}{8}$ IF, 2 $\frac{1}{2}$ IF, 3 $\frac{1}{2}$ IF, 4IF, 4 $\frac{1}{2}$ IF, 5 $\frac{1}{2}$ IF	4API 386
API V0.038R	4	3,000	1:4	7° 7' 30"	NC56, NC61, NC70, NC77	4API 384
API V0.040	5	3,000	1:4	7° 7' 30"	2 $\frac{3}{8}$ REG, 2 $\frac{1}{2}$ REG, 3 $\frac{1}{2}$ REG, 4 $\frac{1}{2}$ REG, 3 $\frac{1}{2}$ FH, 4 $\frac{1}{2}$ FH	5API 404
API V0.050	4	2,000	1:6	4° 45' 49"	6 $\frac{5}{8}$ REG, 5 $\frac{1}{2}$ FH, 6 $\frac{5}{8}$ FH	4API 506
API V0.050	4	3,000	1:4	7° 7' 30"	5 $\frac{1}{2}$ REG, 7 $\frac{5}{8}$ REG, 8 $\frac{5}{8}$ REG	4API 504
API V0.055	6	1,500	1:8	3° 34' 35"	NC10, NC12, NC13, NC16	6API 558
API V0.065	4	2,000	1:6	4° 45' 49"	4FH, 2 $\frac{3}{8}$ IF, 2 $\frac{1}{2}$ IF, 3 $\frac{1}{2}$ IF, 4IF, 4 $\frac{1}{2}$ IF, 5 $\frac{1}{2}$ IF	4API 656
EXTREME LINE CASING	6	1,500	1:8	3° 34' 35"	5-7 $\frac{7}{8}$	6ELC
EXTREME LINE CASING	5	1,250	1:9,6	2° 58' 53"	8 $\frac{5}{8}$ -10 $\frac{3}{4}$	5ELC
BUTRESS CASING	5	0,750	1:6	1° 47' 24"	4 $\frac{1}{2}$ -13 $\frac{3}{8}$	5API 2,5
BUTRESS CASING	5	1,000	1:12	2° 23' 9"	16-20	5API 2,6
PAC	4	0,125	1:8	3° 34' 35"	2 $\frac{3}{8}$ , 2 $\frac{1}{2}$ , 3 $\frac{1}{2}$	4PAC

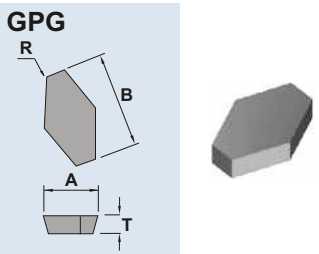
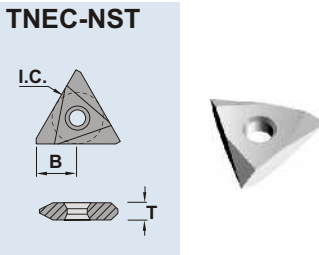
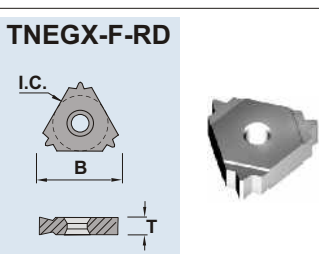
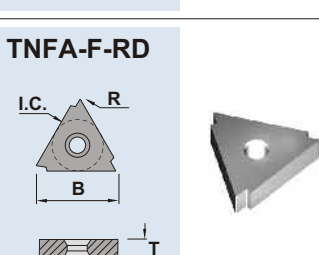
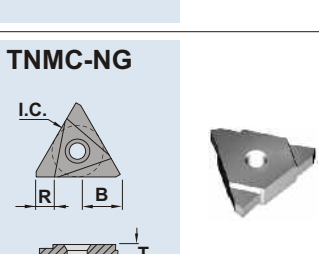
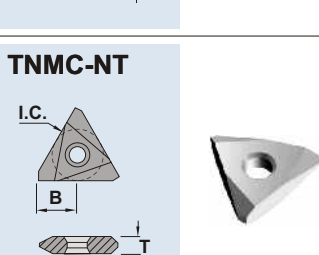


## Inserts (8 RD and 10 RD A.P.I Thread)

	REF.	L	A (I.C.)	IPF	X	Y	PM25	TIN25
<b>API-V0R</b> 	22E/NR 4API 386	22	0,500	2	2,0	2,9	★	★
	22E/NR 4API 384	22	0,500	3	1,9	2,8	★	★
	27E/NR 4API 386	27	0,625	2	2,0	2,9	★	★
	27E/NR 4API 384	27	0,625	3	1,9	2,8	★	★
<b>API-V0</b> 	22E/NR 5API 404	22	0,500	3,0	1,8	2,5	★	★
	22E/NR 6API 558	22	0,500	1,5	1,8	2,5	★	★
	27E/NR 4API 506	27	0,625	2,0	2,0	2,9	★	★
	27E/NR 4API 504	27	0,625	3,0	2,0	2,9	★	★
	27E/NR 4API 656	27	0,625	2,0	2,5	3,2	★	★
<b>API-PAC</b> 	27E/NR 4PAC	27	0,625	1,5	2,5	3,0	★	★
★ Normally available for immediate delivery. ☆ Only available in a limited quantity.	REF.	L	A (I.C.)	IPF	X	Y	PM25	TIN25



# Threading inserts

	REF.	HOLE SIZE	A (I.C.)	T	R	B	A.P.I. THD FORM	PM25	TIN25
<b>GPG</b> 	GPG-47-3-198-2	-	0,475	0,187	0,031	0,750	-	★	★
	GPG-57-3-198-2	-	0,573	0,187	0,031	1,000	-	★	★
	GPG 57-3-280-2	-	0,573	0,187	0,031	0,807	-	★	★
	GPG-57-3-299-2	-	0,573	0,187	0,031	0,762	-	★	★
	GPG-57-3-328-2	-	0,573	0,187	0,031	0,694	-	★	★
<b>TNEC-NST</b> 	TNEC-32NST-8P	0,150	0,375	0,1250	-	0,306	8P	★	★
	TNEC-32NST-10P	0,150	0,375	0,1250	-	0,306	10P	★	★
	TNEC-32NST-12P	0,150	0,375	0,1250	-	0,306	12P	★	★
	TNEC-32NST-14P	0,150	0,375	0,1250	-	0,306	14P	★	★
	TNEC-43NST-4P	0,202	0,500	0,1875	-	0,415	4P	★	★
	TNEC-43NST-5P	0,202	0,500	0,1875	-	0,415	5P	★	★
	TNEC-43NST-6P	0,202	0,500	0,1875	-	0,415	6P	★	★
TNEC-54NST-3P	0,251	0,625	0,2500	-	0,522	3P	★	★	
<b>TNEGX-F-RD</b> 	TNEGX-43F-8RD	0,202	0,500	0,1925	0,017	0,602	8RD	★	★
<b>TNFA-F-RD</b> 	TNFA-43F-8RD	0,202	0,500	0,1875	0,017	0,629	8RD	★	★
	TNFA-43F-10RD	0,202	0,500	0,1875	0,014	0,646	10RD	★	★
<b>TNMC-NG</b> 	TNMC-32NG	0,150	0,375	0,125	0,156	0,306	-	★	★
	TNMC-32NGR/L-062	0,150	0,375	0,125	0,156	0,306	-	★	★
	TNMC-32NGR/L-092	0,150	0,375	0,125	0,156	0,306	-	★	★
	TNMC-43NG	0,202	0,500	0,187	0,234	0,415	-	★	★
	TNMC-43NGR/L-125	0,202	0,500	0,187	0,234	0,415	-	★	★
	TNMC-43NGR/L-156	0,202	0,500	0,187	0,234	0,415	-	★	★
	TNMC-54NG	0,251	0,625	0,250	0,296	0,522	-	★	★
	TNMC-54NGR/L-187	0,251	0,625	0,250	0,296	0,522	-	★	★
	TNMC-64NG	0,315	0,750	0,250	0,375	0,631	-	★	★
TNMC-66NG	0,315	0,750	0,375	0,375	0,631	-	★	★	
<b>TNMC-NT</b> 	TNMC-32NT-6P	0,150	0,375	0,125	-	0,306	6P	★	★
	TNMC-32NT-8P	0,150	0,375	0,125	-	0,306	8P	★	★
	TNMC-32NT-10P	0,150	0,375	0,125	-	0,306	10P	★	★
	TNMC-32NT-12P	0,150	0,375	0,125	-	0,306	12P	★	★
	TNMC-43NT-4P	0,202	0,500	0,187	-	0,415	4P	★	★
	TNMC-43NT-5P	0,202	0,500	0,187	-	0,415	5P	★	★
	TNMC-43NT-6P	0,202	0,500	0,187	-	0,415	6P	★	★
	TNMC-54NT-3P	0,251	0,625	0,250	-	0,522	3P	★	★
	TNMC-66NT-2P	0,315	0,750	0,375	-	0,631	2P	★	★
	REF.	HOLE SIZE	A (I.C.)	T	R	B	A.P.I. THD FORM	PM25	TIN25

★ Normally available for immediate delivery.  
 ☆ Only available in a limited quantity.



# CLS

POSITIVE RAKE

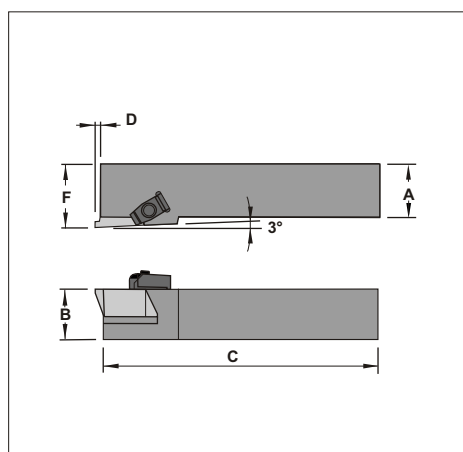
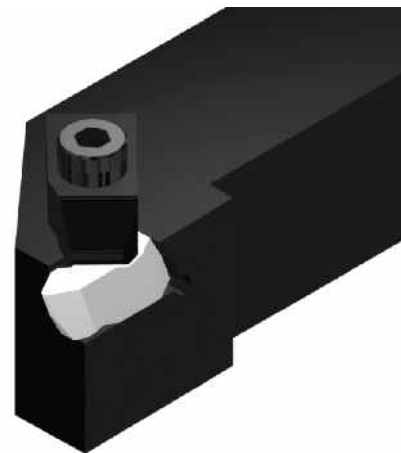
## Characteristics:

External toolholder for positive inserts.







The simplicity of the tool design does not require shim selection for thread helix angles. A very rigid insert clamping design assures best tool life, Surface finish and workpiece quality.


## Applications:

An excellent choice for heavy-duty applications like machining of Acme, buttress and round threads. To reduce inventory, you can use the same toolholders and boring bars with either threading and grooving inserts.



REF.	A	B	C	D	F
CLS R/L 12-3B	0,750	0,750	4,500	0,210	1,000
CLS R/L 12-3C	0,750	0,750	5,000	0,210	1,000
CLS R/L 16-3D	1,000	1,000	6,000	0,210	1,250
CLS R/L 20-3D	1,250	1,250	6,000	0,210	1,500
CLS R/L 16-4D	1,000	1,000	6,000	0,294	1,250
CLS R/L 20-4D	1,250	1,250	6,000	0,294	1,500

REF.			 R	 L		
CLS R/L 12-3B	-	-	TF-72	TF-73	5104	1297
CLS R/L 12-3C	-	-	TF-72	TF-73	5104	1297
CLS R/L 16-3D	-	-	TF-72	TF-73	5104	1297
CLS R/L 20-3D	-	-	TF-72	TF-73	5104	1297
CLS R/L 16-4D	3521	1625	TF-72	TF-73	5104	1297
CLS R/L 20-4D	3521	1625	TF-72	TF-73	5104	1297

INSERT SIZE	NT
	
3	NT-3
4	NT-4

# MXGNR

NEGATIVE RAKE

## Characteristics:

Threading toolholder for negative lay down inserts.

The double clamping by means of central pin and clamp ensures a maximal fixing which gives an optimal safety when the tool is working.

The insert is positioned with a  $-9^\circ$  cutting angle, and a  $0^\circ$  clearance angle.

Toolholder supplied with all the spare parts except the insert.

## Uses:

Although it can be used in any kind of machine, this toolholder is the first option for NC lathes.



External toolholder		REF.	A	B	C	D	E	F
		MXGNR-16-4 API	1,00	1,00	6,00	1,25	1,38	1,25
		MXGNR-20-4 API	1,25	1,25	7,00	1,25	1,62	1,50
		MXGNR-24-4 API	1,00	1,50	8,00	1,25	2,12	2,00
		MXGNR-16-5 API	1,00	1,00	6,00	1,25	1,38	1,25
		MXGNR-20-5 API	1,25	1,25	7,00	1,25	1,62	1,50
		MXGNR-24-5 API	1,50	1,50	8,00	1,25	2,12	2,00

REF.						
MXGNR-16-4 API	3420	1678	2522	1466	5124	5126
MXGNR-20-4 API	3420	1678	2522	1466	5124	5126
MXGNR-24-4 API	3420	1678	2522	1466	5124	5126
MXGNR-16-5 API	3421	1679	2527	1488	5103	5104
MXGNR-20-5 API	3421	1679	2527	1488	5103	5104
MXGNR-24-5 API	3421	1679	2527	1488	5103	5104

INSERT SIZE	API-V0	API-PAC	API-ROUND	API-CASING	API-BUTTRES	API-VAM	API-HUGHES
22	22ER 4API 386 22ER 4API 384 22ER 5API 404 22ER 6API 558		22ER 8RD API 22ER 10RD API	22ER 6ELC 22ER 5ELC	22ER 5API 2.5 22ER 5API 2.6	22ER 8VAM 22ER 6VAM 22ER 5VAM	
27	27ER 4API 386 27ER 4API 384 27ER 5API 506 27ER 6API 656	27ER 4PAC					27ER 3 1/2 H90-2 27ER 3 1/2 H90-3 27ER 3 SL H90

# MTGNR

NEGATIVE RAKE

### Characteristics:

Threading toolholder for negative lay down inserts.

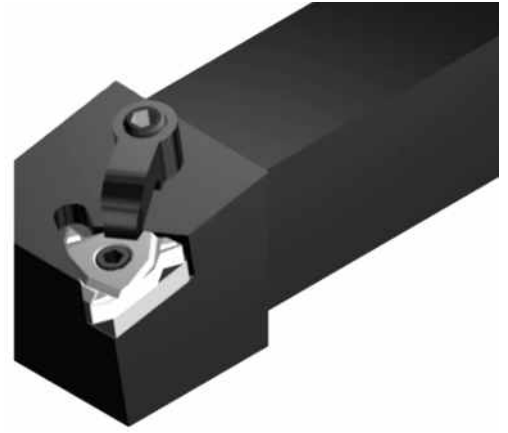
The double clamping by means of central pin and clamp ensures a maximal fixing which gives an optimal safety when the tool is working.

The insert is positioned with a  $-9^\circ$  cutting angle, and a  $0^\circ$  clearance angle.

Toolholder supplied with all the spare parts except the insert.

### Uses:

Although it can be used in any kind of machine, this toolholder is the first option for manual machines.



Single-Point Threading holders	REF.	A	B	C	D	F
	MTGNR-16-4 API	1,00	1,00	6,00	1,25	1,25
	MTGNR-20-4 API	1,25	1,25	7,00	1,25	1,50
	MTGNR-16-5 API	1,00	1,00	6,00	1,25	1,25
	MTGNR-20-5 API	1,25	1,25	7,00	1,25	1,50

REF.						
MTGNR-16-4 API	3420	1678	2522	1466	5124	5126
MTGNR-20-4 API	3420	1678	2522	1466	5124	5126
MTGNR-16-5 API	3421	1679	2527	1488	5103	5104
MTGNR-20-5 API	3421	1679	2527	1488	5103	5104

INSERT SIZE	API-V0	API-PAC	API-ROUND	API-CASING	API-BUTTRES	API-VAM	API-HUGHES
22	22ER 4API 386 22ER 4API 384 22ER 5API 404 22ER 6API 558		22ER 8RD API 22ER 10RD API	22ER 6ELC 22ER 5ELC	22ER 5API 2.5 22ER 5API 2.6	22ER 8VAM 22ER 6VAM 22ER 5VAM	
27	27ER 4API 386 27ER 4API 384 27ER 5API 506 27ER 6API 656	27ER 4PAC					27ER 3½ H90-2 27ER 3½ H90-3 27ER 3 SL H90

# MTEN-API

NEGATIVE RAKE

**Characteristics:**

Toolholder for negative threading inserts.

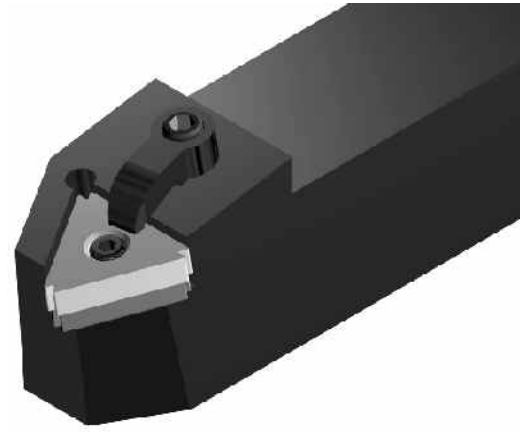
The double clamping by means of central pin and clamp ensures a maximal fixing which gives an optimal safety when the tool is working.

The insert is positioned with a -9° cutting angle, and a 0° clearance angle.

Toolholder supplied with all the spare parts except the insert.

**Uses:**

Multipurpose threading toolholder.



Single-Point Threading holders	REF.	A	B	C	D	F
	MTENR-16-4 API	1,00	1,00	6,00	1,47	0,630
	MTENR-20-4 API	1,25	1,25	7,00	1,47	0,880
	MTENR-24-4 API	1,50	1,50	8,00	1,47	1,130
	MTENL-16-4 API	1,00	1,00	6,00	1,47	0,630
	MTENL-20-4 API	1,25	1,25	7,00	1,47	0,880

REF.						
MTENR-16-4 API	3676	1678	2522	1466	5124	5126
MTENR-20-4 API	3676	1678	2522	1466	5124	5126
MTENR-24-4 API	3676	1678	2522	1466	5124	5126
MTENL-16-4 API	3676	1678	2522	1466	5124	5126
MTENL-20-4 API	3676	1678	2522	1466	5124	5126

INSERT SIZE	INSERT	OPTIONAL PARTS USED WITH PIN-LOCK INSERTS			OPTIONAL PARTS USED WITH CLAMP STYLE INSERTS	
		SHIM SEAT	INSERT	C'BKR	SHIM SEAT	INSERT
43	22ER 8RD-U 22ER 10RD-U	STN-43	TNMG TNMA	-	STN-43	TNU

# SER

NEGATIVE RAKE

## Characteristics:

Threading toolholder for negative lay down inserts.

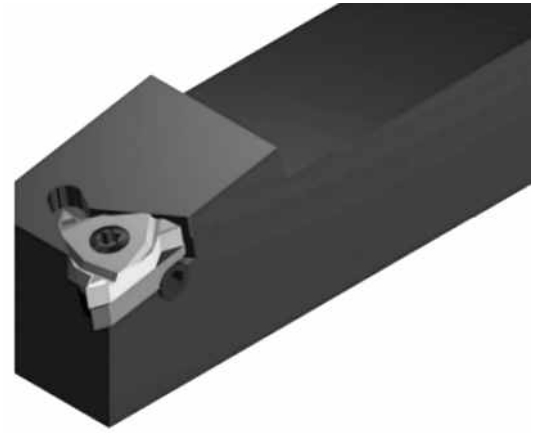
The screw clamping ensures a good and clean fixation.

The insert is positioned with a  $-10^\circ$  cutting angle, and a  $-1^\circ$  clearance angle.

Toolholder supplied with all the spare parts except the insert.

## Uses:

Multipurpose threading toolholders.



External toolholder		REF.	A (IC)	A=B	C	F
		SER/L 0310 H11	0,250	0,310	4,00	0,430
		SER/L 0375 H11	0,250	0,380	4,00	0,430
		SER/L 0375 D16	0,375	0,380	2,50	0,630
		SER/L 0500 F16	0,375	0,500	3,25	0,630
		SER/L 0625 H16	0,375	0,630	4,00	0,630
		SER/L 0750 K16	0,375	0,750	5,00	0,750
		SER/L 1000 M16	0,375	1,000	6,00	1,000
		SER/L 1250 P16	0,375	1,250	7,00	1,250
		SER/L 1000 M22	0,500	1,000	6,00	1,000
		SER/L 1250 P22	0,500	1,250	7,00	1,250
		SER/L 1500 R22	0,500	1,500	8,00	1,500
		SER/L 1000 M27	0,625	1,000	6,00	1,250
		SER/L 1250 P27	0,625	1,250	7,00	1,250
		SER/L 1500 R27	0,625	1,500	8,00	1,500

REF.					
SER/L 0310 H11	1225	5507	-	-	-
SER/L 0375 H11	1225	5507	-	-	-
SER/L 0375 D16	1235	5515	-	-	-
SER/L 0500 F16	1235	5515	-	-	-
SER/L 0625 H16	SA3	5510	YE3	YI3	SY3
SER/L 0750 K16	SA3	5510	YE3	YI3	SY3
SER/L 1000 M16	SA3	5510	YE3	YI3	SY3
SER/L 1250 P16	SA3	5510	YE3	YI3	SY3
SER/L 1000 M22	SA4	5520	YE4	YI4	SY4
SER/L 1250 P22	SA4	5520	YE4	YI4	SY4
SER/L 1500 R22	SA4	5520	YE4	YI4	SY4
SER/L 1000 M27	SA5	5525	YE5	YI5	SY5
SER/L 1250 P27	SA5	5525	YE5	YI5	SY5
SER/L 1500 R27	SA5	5525	YE5	YI5	SY5

INSERT SIZE	N R/L	N R/L TD
11	11 NR/L- ...	11 NR/L-.. TD
16	16 NR/L- ...	16 NR/L-.. TD
22	22 NR/L- ...	22 NR/L-.. TD
27	27 NR/L- ...	27 NR/L-.. TD

# STCN

POSITIVE RAKE

## Characteristics:

Vertical on edge threading toolholder.

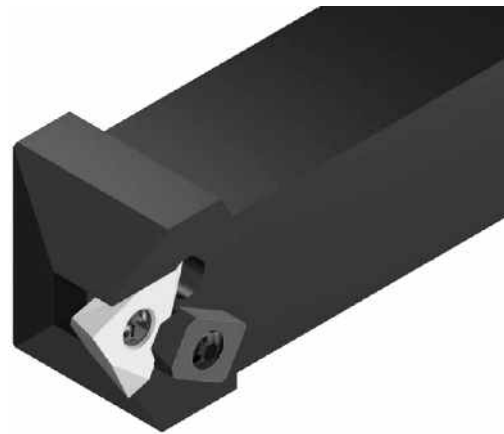
The double clamping by means of screw and clamp ensures a maximal fixing which gives an optimal safety when the tool is working.

The insert is positioned with a 0° cutting angle, and a 0° clearance angle.

Toolholder supplied with all the spare parts except the insert.

## Uses:

Multipurpose threading and grooving toolholder.



0° Lead Toolholder		REF.	A	B	C	D	F	H	V
	STCNR/L 12-43	0,75	0,75	6,00	1,25	1,00	0,23	0,906	
	STCNR/L 16-43	1,00	1,00	6,00	1,25	1,25	0,23	1,156	
	STCNR/L 20-43	1,25	1,25	6,00	1,25	1,50	0,23	1,406	
	STCNR/L 16-54	1,00	1,00	6,00	1,34	1,25	0,30	1,125	
	STCNR/L 20-54	1,25	1,25	7,00	1,34	1,50	0,30	1,375	
	STCNR/L 20-66	1,25	1,25	7,00	1,62	1,50	0,38	1,312	
	STCNR/L 24-66	1,50	1,50	8,00	1,62	2,00	0,38	1,812	

REF.					
STCNR/L 12-43	1936	5100	2101	1801	5103
STCNR/L 16-43	1936	5100	2101	1801	5103
STCNR/L 20-43	1936	5100	2101	1801	5103
STCNR/L 16-54	1937	5124	2101	1801	5103
STCNR/L 20-54	1937	5124	2101	1801	5103
STCNR/L 20-66	1938	5126	2101	1801	5103
STCNR/L 24-66	1938	5126	2101	1801	5103

INSERT SIZE	29° STUB ACME THREADING	GROOVING	29° ACME THREADING	60° VEE THREADING
43	TNEC-43NST-4P TNEC-43NST5P TNEC-43NST6P	TNMC-43NGR/L TPMC-43NGR/L	TNMC-43NT4P TNMC-43NT5P TNMC-43NT6P	TNMC-43NV
54	TNEC-54NST-3P	TNMC-54NGR/L TPMC-54NGR/L	TNMC-54NT3P	TNMC-54NV

# API-MTF

POSITIVE RAKE

**Characteristics:**

Multi-tooth threading holders.

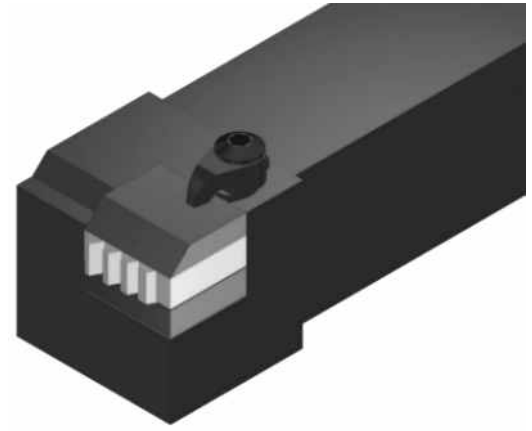
Toolholder with clamp fixing and chipbreaker to ensure a good chip control.

The insert is positioned with a 0° cutting angle, and a 0° clearance angle.

Toolholder supplied with all the spare parts except the insert and chipbreaker.

**Uses:**

Special applications.



Multi-tooth threading holder	REF.	A	B	C	D	F
	API-MTF-65809	1,00	1,00	6,00	1,25	0,550
	API-MTF-55075	1,25	1,25	7,00	1,25	0,550
	API-MTF-3066	1,50	1,50	8,00	1,25	0,800

REF.						
API-MTF-65809	3571	1271	2527	1488	5104	
API-MTF-55075	3571	1271	2527	1488	5104	
API-MTF-3066	3571	1271	2527	1488	5104	

THREAD FORM	CHIPBREAKER		INSERT
8 ROUND (4 TOOTH) 8 ROUND (3 TOOTH) 10 ROUND	API-CB-55073	API-CB-4676	55058-8RDE 2547-8RDE 2546-10RDE
5 TPI-3/4" BUTTRESS 5 TPI-1" BUTTRESS 8 TPI-3/4" IMP. BUTTRESS	API-CB-55175		55174-BUCA-755E 2298-BUCA-15E 2328-BU-758E

# CGXPN

POSITIVE RAKE

**Characteristics:**

Toolholder for positive grooving inserts.

Boring bar with clamp fixation that ensures a maximal fixing which gives an optimal safety when the tool is working.

The insert is positioned with a 0° cutting angle, and a 0° clearance angle.

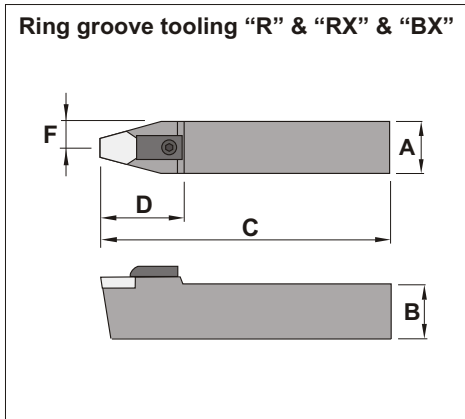
Toolholder supplied with all the spare parts except the insert and optional parts.




**Uses:**


Ring groove toolholder.



REF.	R & RX RING GASKET INSERTS	A	B	C	D	F
CGXPN-16-47	GPG-47-3-198-2	1.00	1.00	6.00	1.38	0.500
CGXPN-85-47	GPG-47-3-198-2	1.00	1.25	7.00	1.38	0.500
CGXPN-86-47	GPG-47-3-198-2	1.00	1.50	8.00	1.38	0.500
CGXPN-16-57	GPG-57-3-198-2	1.00	1.00	6.00	1.70	0.500
CGXPN-16-57-151	GPG-57-3-280-2	1.00	1.00	6.00	1.70	0.500
CGXPN-16-57-152	GPG-57-3-299-2	1.00	1.00	6.00	1.70	0.500
CGXPN-16-57-153	GPG-57-3-328-2	1.00	1.00	6.00	1.70	0.500
CGXPN-85-57	GPG-57-3-198-2	1.00	1.25	7.00	1.70	0.500
CGXPN-85-57-151	GPG-57-3-280-2	1.00	1.25	7.00	1.70	0.500
CGXPN-85-57-152	GPG-57-3-299-2	1.00	1.25	7.00	1.70	0.500
CGXPN-85-57-153	GPG-57-3-328-2	1.00	1.25	7.00	1.70	0.500
CGXPN-86-57	GPG-57-3-198-2	1.00	1.50	8.00	1.70	0.500
CGXPN-86-57-151	GPG-57-3-280-2	1.00	1.50	8.00	1.70	0.500
CGXPN-86-57-152	GPG-57-3-299-2	1.00	1.50	8.00	1.70	0.500
CGXPN-86-57-153	GPG-57-3-328-2	1.00	1.50	8.00	1.70	0.500



REF.			
CGXPN-16-47	2102	1802	5104
CGXPN-85-47	2102	1802	5104
CGXPN-86-47	2102	1802	5104
CGXPN-16-57	2105	1805	5105
CGXPN-16-57-151	2105	1805	5105
CGXPN-16-57-152	2105	1805	5105
CGXPN-16-57-153	2105	1805	5105
CGXPN-85-57	2105	1805	5105
CGXPN-85-57-151	2105	1805	5105
CGXPN-85-57-152	2105	1805	5105
CGXPN-85-57-153	2105	1805	5105
CGXPN-86-57	2105	1805	5105
CGXPN-86-57-151	2105	1805	5105
CGXPN-86-57-152	2105	1805	5105
CGXPN-86-57-153	2105	1805	5105

INSERT	
	
	GPG-47-3-198-2
	GPG-57-3-198-2 GPG-57-3-280-2 GPG-57-3-299-2 GPG-57-3-328-2

# CLE

POSITIVE RAKE

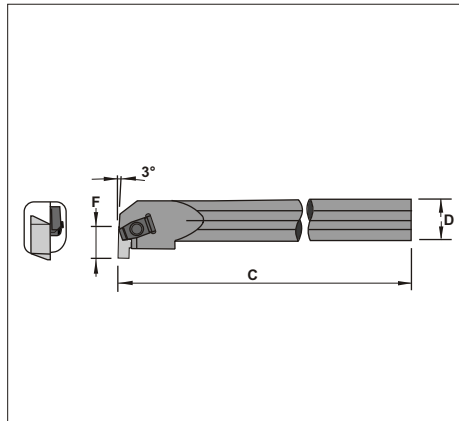
## Characteristics:

Internal toolholder for positive inserts.





The simplicity of the tool design does not require shim selection for thread helix angles. A very rigid insert clamping design assures best tool life, Surface finish and workpiece quality.

## Applications:

An excellent choice for heavy-duty applications like machining of Acme, buttress and round threads. To reduce inventory, you can use the same toolholders and boring bars with either threading and grooving inserts.



REF.	Min. Bore	D	C	F
A16T-CLE R/L -3	1,375	1,000	12,00	0,688
A20U-CLE R/L -3	1,750	1,250	14,00	0,875
A28U-CLE R/L -3	2,250	1,750	14,00	1,125
A32V-CLE R/L -3	2,500	2,000	16,00	1,250
A28U-CLE R/L -4	2,250	1,750	14,00	1,250
A32V-CLE R/L -4	2,750	2,000	16,00	1,375
A32V-CLE R/L -5	2,812	2,000	16,00	1,406
A32V-CLE R/L -6	2,750	2,000	16,00	1,375

REF.			 R	 L
A16T-CLE R/L -3	5104	1297	TF73	TF72
A20U-CLE R/L -3	5104	1297	TF73	TF72
A28U-CLE R/L -3	5104	1297	TF73	TF72
A32V-CLE R/L -3	5104	1297	TF73	TF72
A28U-CLE R/L -4	5104	1297	TF73	TF72
A32V-CLE R/L -4	5104	1297	TF73	TF72
A32V-CLE R/L -5	5104	1297	TF73	TF72
A32V-CLE R/L -6	5104	1297	TF73	TF72

INSERT SIZE	NT
	
3	NT-3
4	NT-4
5	NT-5
6	NT-6

# MXFNR

NEGATIVE RAKE

## Characteristics:

Boring bar for negative lay down inserts.

The double clamping by means of central pin and clamp ensures a maximal fixing which gives an optimal safety when the tool is working.

The insert is positioned with a  $-9^\circ$  cutting angle, and a  $0^\circ$  clearance angle.

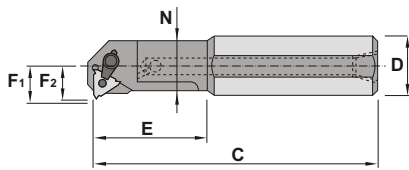
Boring bar supplied with all the spare parts except the insert and optional parts.

## Uses:

For tapered and parallel threads.



### Laydown-style Threading bars



REF.	D	F1	F2	C	E	N
A24U-MXFNR-4	1,50	0,891	0,812	14,00	3,00	1,34
A28V-MXFNR-4	1,75	1,079	1,000	16,00	4,00	1,50
A32V-MXFNR-4	2,00	1,329	1,250	16,00	4,00	1,75
A40V-MXFNR-4	2,50	1,579	1,500	16,00	4,00	2,12
A24U-MXFNR-5	1,50	1,208	1,125	14,00	3,00	1,52
A28V-MXFNR-5	1,75	1,208	1,125	16,00	4,00	1,50
A32V-MXFNR-5	2,00	1,333	1,250	16,00	4,00	1,75
A40V-MXFNR-5	2,50	1,583	1,500	16,00	4,00	2,12

REF.						
A24U-MXFNR-4	1676	2522	1466	5124	5126	5126
A28V-MXFNR-4	1676	2522	1466	5124	5126	5126
A32V-MXFNR-4	1676	2522	1466	5124	5126	5126
A40V-MXFNR-4	1676	2522	1466	5124	5126	5126
A24U-MXFNR-5	1677	2527	1488	5103	5104	5104
A28V-MXFNR-5	1677	2527	1488	5103	5104	5104
A32V-MXFNR-5	1677	2527	1488	5103	5104	5104
A40V-MXFNR-5	1677	2527	1488	5103	5104	5104

INSERT SIZE	API-V0	API-PAC	API-ROUND	API-CASING	API-BUTTRES	API-VAM	API-HUGHES
22	22NR 4API 386 22NR 4API 384 22NR 5API 404 22NR 6API 558		22NR 8RD API 22NR 10RD API	22NR 6ELC 22NR 5ELC	22NR 5API 2.5 22NR 5API 2.6	22NR 8VAM 22NR 6VAM 22NR 5VAM	
27	27NR 4API 386 27NR 4API 384 27NR 5API 506 27NR 6API 656	27NR 4PAC					27NR 3 1/2 H90-2 27NR 3 1/2 H90-3 27NR 3 SL H90

# MXFNR-C

NEGATIVE RAKE

**Characteristics:**

Threading Boring bar for negative lay down inserts.

The double clamping by means of central pin and clamp ensures a maximal fixing which gives an optimal safety when the tool is working.

The insert is positioned with a  $-8^\circ$  cutting angle, and a  $0^\circ$  clearance angle.

Boring bar supplied with all the spare parts except the insert.

**Uses:**

For tapered threads only.



Laydown-style Threading bars	REF.	D	F	L
		A28V-MXFNR-5C A32V-MXFNR-5C	1,75 2,00	0,950 0,950

REF.					
A28V-MXFNR-5C A32V-MXFNR-5C	1677 1677	2527 2527	1466 1466	5103 5103	5104 5104

INSERT SIZE	API-V0	API-PAC	API-HUGHES
27	27NR 4API 386 27NR 4API 384 27NR 5API 506 27NR 6API 656	27NR 4PAC	27NR 3½ H90-2 27NR 3½ H90-3 27NR 3 SL H90

# STCNR

POSITIVE RAKE

## Characteristics:

Vertical on edge threading boring bar..

The double clamping by means of screw and clamp ensures a maximal fixing which gives an optimal safety when the tool is working.

The insert is positioned with a 0° cutting angle, and a 0° clearance angle.

Boring bar supplied with all the spare parts except the insert.

## Uses:

Multipurpose threading and grooving boring bar.



Threading & grooving bars		REF.	D	B	F	L1	L2
	A24U-STCNR-4	1,50	1,734	0,984	14,00	1,12	
	A28V-STCNR-4	1,75	2,063	1,188	16,00	1,12	
	A32V-STCNR-4	2,00	2,260	1,260	16,00	1,12	
	A40V-STCNR-4	2,50	2,750	1,500	16,00	1,12	
	A28V-STCNR-5	1,75	2,375	1,500	16,00	1,88	
	A32V-STCNR-5	2,00	2,375	1,375	16,00	1,88	
	A40V-SCTNR-5	2,50	2,875	1,625	16,00	1,88	

REF.					
A24U-STCNR-4	1936	5100	2101	1801	5103
A28V-STCNR-4	1936	5100	2101	1801	5103
A32V-STCNR-4	1936	5100	2101	1801	5103
A40V-STCNR-4	1936	5100	2101	1801	5103
A28V-STCNR-5	1937	5124	2101	1801	5103
A32V-STCNR-5	1937	5124	2101	1801	5103
A40V-SCTNR-5	1937	5124	2101	1801	5103

INSERT SIZE	29° STUB ACME THREADING	GROOVING	29° ACME THREADING	60° VEE THREADING
43	TNEC-43NST-4P TNEC-43NST5P TNEC-43NST6P	TNMC-43NGR/L TPMC-43NGR/L	TNMC-43NT4P TNMC-43NT5P TNMC-43NT6P	TNMC-43NV
54	TNEC-54NST-3P	TNMC-54NGR/L TPMC-54NGR/L	TNMC-54NT3P	TNMC-54NV

# SIR

## NEGATIVE RAKE

### Characteristics:

Threading boring bar for negative lay down inserts.

The screw clamping ensures a good and clean fixation.

The insert is positioned with a  $-10^\circ$  cutting angle, and a  $-1^\circ$  clearance angle.

Boring bar supplied with all the spare parts except the insert.

### Uses:

Multipurpose threading boring bar.



Internal toolholders	INCH BORING BARS						
	D	h	L <sub>1</sub>	L <sub>2</sub>	F	A	
	SIR/L 0375 H11	0,380	0,380	4,00	1,000	0,290	0,470
	SIR/L 0375 K11	0,380	0,380	5,00	1,250	0,260	0,470
	SIR/L 0500 L11	0,620	0,500	5,50	1,250	0,320	0,630
	SIR/L 0500 M16	0,620	0,500	6,00	1,250	0,390	0,640
	SIR/L 0625 P16	0,750	0,620	7,00	1,500	0,450	0,750
	SIR/L 0750 P16	0,750	0,750	7,00	1,500	0,510	1,000
	SIR/L 1000 R16	1,000	1,000	8,00	1,500	0,650	1,200
	SIR/L 1250 S16	1,250	1,250	10,00	1,500	0,770	1,420
	SIR/L 1500 T16	1,500	1,500	12,00	1,500	0,090	1,650
	SIR/L 0750 P22	0,750	0,750	7,00	1,500	0,510	0,950
	SIR/L 1000 R22	1,000	1,000	8,00	1,500	0,710	1,200
	SIR/L 1250 S22	1,250	1,250	10,00	1,500	0,850	1,500
	SIR/L 1500 T22	1,500	1,500	12,00	1,500	0,098	1,750
	SIR/L 1250 S27	1,250	1,250	10,00	1,500	0,880	1,560
	SIR/L 1500 T27	1,500	1,500	12,00	1,500	1,000	1,800
	SIR/L 2000 U27	2,000	2,000	14,00	1,500	1,250	2,300
	SIR/L 2500 V27	2,500	2,500	16,00	1,500	1,500	2,700

REF.					
			R	L	
SIR/L 0375 H11	1225	5507	-	-	-
SIR/L 0375 K11	1225	5507	-	-	-
SIR/L 0500 L11	1225	5507	-	-	-
SIR/L 0500 M16	SA25	5510	-	-	-
SIR/L 0625 P16	SA25	5510	-	-	-
SIR/L 0750 P16	SA3	5510	YE3	YI3	SY3
SIR/L 1000 R16	SA3	5510	YE3	YI3	SY3
SIR/L 1250 S16	SA3	5510	YE3	YI3	SY3
SIR/L 1500 T16	SA3	5510	YE3	YI3	SY3
SIR/L 0750 P22	SA4	5520	YE4	YI4	SY4
SIR/L 1000 R22	SA4	5520	YE4	YI4	SY4
SIR/L 1250 S22	SA4	5520	YE4	YI4	SY4
SIR/L 1500 T22	SA4	5520	YE4	YI4	SY4
SIR/L 1250 S27	SA5	5525	YE5	YI5	SY5
SIR/L 1500 T27	SA5	5525	YE5	YI5	SY5
SIR/L 2000 U27	SA5	5525	YE5	YI5	SY5
SIR/L 2500 V27	SA5	5525	YE5	YI5	SY5

REF.	d	T	H	N R/L	N R/L TD
11 NR/L- ...	0,250	0,125	0,110		
16 NR/L- ...	0,375	0,125	0,173		
22 NR/L- ...	0,500	0,187	0,203		
27 NR/L- ...	0,625	0,250	0,250		

Metric toolholders available upon request.

# API-MTG

POSITIVE RAKE

## Characteristics:

Multi-tooth threading boring bar.

Boring bar with clamp fixing and chipbreaker to ensure a good chip control.

The insert is positioned with a 0° cutting angle, and a 0° clearance angle.

Boring bar supplied with all the spare parts except the insert and chipbreaker.

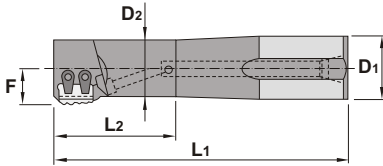
## Uses:







Special applications.





REF.	D1	D2	L1	L2	F
API-MTG-54715	2,00	1,75	12,00	4,00	1,125
API-MTG-54932	3,00	3,00	16,00	9,00	1,812

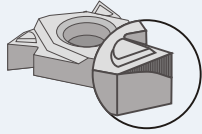
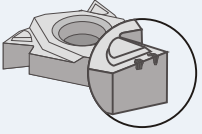
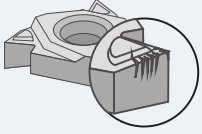
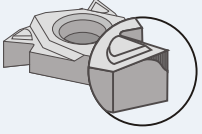
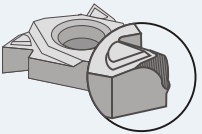
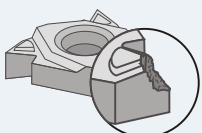
Multi-tooth threading bar with coolant hole



REF.						
API-MTG-54715	3572	1271	-	2522	1466	5126
API-MTG-54932	3572	1271	-	2522	1466	5126

	THREAD FORM	CHIPBREAKER	INSERT
			
	8 ROUND (4 TOOTH) 8 ROUND (3 TOOTH) 10 ROUND	-	55058-8RDE 2547-8RDE 2546-10RDE
	5 TPI-3/4" BUTTRESS 5 TPI-1" BUTTRESS 8 TPI-3/4" IMP. BUTTRESS	-	55174-BUCA-755E 2298-BUCA-15E 2328-BU-758E

# Threading insert wear and tool life

	<b>Problem</b>	<b>Cause and Remedy</b>
	<ul style="list-style-type: none"> <li>★ Cutting speed too high.</li> <li>★ Lack of coolant. Infeed per pass too small - too many passes</li> <li>★ Incorrect grade.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Reduce the cutting speed.</li> <li>☆ Increase the coolant supply.</li> <li>☆ Increase the depth of infeed for the smallest infeed depths - reduce the number of passes.</li> <li>☆ Select a more wear resistant grade.</li> </ul>
	<ul style="list-style-type: none"> <li>★ Instability of workholding and/or tool set-up.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Check rigidity of operation.</li> <li>☆ Select a tougher grade.</li> </ul>
	<ul style="list-style-type: none"> <li>★ Intermittent coolant supply.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Position coolant flow and/or increase coolant supply.</li> </ul>
	<ul style="list-style-type: none"> <li>★ Incorrect method of infeed.</li> <li>★ Incorrect angle of inclination.</li> </ul>	<ul style="list-style-type: none"> <li>☆ In case of flank infeed use modified flank infeed. Decrease infeed angle 3-5°.</li> <li>☆ Correct the angle on inclination according to the diagram.</li> </ul>
	<ul style="list-style-type: none"> <li>★ Infeed per pass too big - too few passes.</li> <li>★ Lack of coolant.</li> <li>★ Cutting speed too high.</li> <li>★ Incorrect grade.</li> <li>★ Excessive stock removal from crest.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Decrease the depth of infeed for the biggest depths. - Increase the number of passes.</li> <li>☆ Increase coolant supply.</li> <li>☆ Reduce the cutting speed.</li> <li>☆ Select a harder grade.</li> <li>☆ Check material stock above the crest.</li> </ul>
	<ul style="list-style-type: none"> <li>★ Instability.</li> <li>★ Lack of chip control.</li> <li>★ Excessive plastic deformation. Intermittent or inadequate coolant supply</li> <li>★ Incorrect grade.</li> <li>★ Excessive stock removal from crest.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Check rigidity of operation.</li> <li>☆ Select a tougher grade. Select modified flank infeed.</li> <li>☆ Machine with same infeed per pass.</li> <li>☆ Direct coolant flow and/or increase coolant supply.</li> <li>☆ Check dimension of blank.</li> </ul>
<p><b>Shallow thread profile</b></p>	<ul style="list-style-type: none"> <li>★ Wrong centre height.</li> <li>★ Insert not cresting.</li> <li>★ Excessive tool wear.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Adjust cutting edge height.</li> <li>☆ Check dimension of blank.</li> <li>☆ Change insert earlier.</li> </ul>
<p><b>Incorrect thread profile</b></p>	<ul style="list-style-type: none"> <li>★ Incorrect tool setting.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Correct tool setting.</li> </ul>
<p><b>Lack of chip control</b></p>	<ul style="list-style-type: none"> <li>★ Incorrect depth of infeed per pass</li> <li>★ Radial infeed.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Adjust cutting edge height.</li> <li>☆ Check dimension of blank.</li> <li>☆ Change insert earlier.</li> </ul>
<p><b>Bad surface finish</b></p>	<ul style="list-style-type: none"> <li>★ Cutting speed too low. Incorrect angle of inclination.</li> <li>★ Flank infeed.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Increase the cutting speed.</li> <li>☆ Correct the angle of inclination according to diagram.</li> <li>☆ Use modified flank infeed or radial infeed.</li> </ul>

## Cutting data

MATERIAL	Cutting speed m/min (Ft/min) / Tool grade		
	PM25	KM15	TIN25
Low and medium carbon steel	120-80 (390-260)		250-210 (820-690)
High carbon steel	110-70 (360-230)		210-150 (690-490)
Alloyed tool steel and heat-treatment steels	100-70 (360-230)		180-140 (590-460)
Stainless steels	100-70 (360-230)	90-70 (295-230)	140-110 (460-360)
Cast-iron HB 180-250		90-70 (295-230)	
Non-Ferrous metals		180-120 (590-390)	

P inch	N° of passes	
	TPI	N° of passes
0,020	48,0	4 - 6
0,030	32,0	4 - 7
0,039	24,0	4 - 8
0,049	20,0	5 - 9
0,059	16,0	6 - 10
0,069	14,0	7 - 12
0,078	12,0	7 - 12
0,098	10,0	8 - 14
0,118	8,0	10 - 18
0,138	7,0	11 - 18
0,157	6,0	11 - 18
0,177	5,5	11 - 19
0,197	5,0	12 - 20
0,217	4,5	12 - 20
0,236	4,0	12 - 20
0,315	3,0	15 - 24

### GENERAL RECOMMENDATIONS

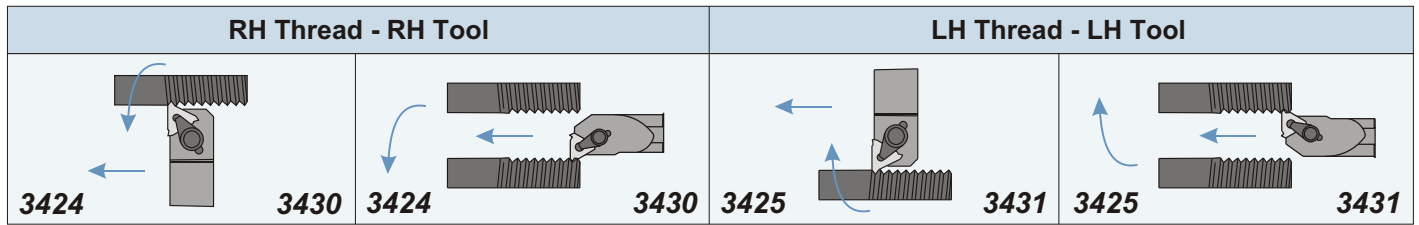
- Threading speeds should normally be a minimum of 80% to 90% of turning speeds being used to machine the same component. (Assuming grades are compatible)
- Check helix angle and number of passes shown in charts before starting.
- Ensure centre height is correct.
- When there is a problem consult the following recommendations and change only one variable at time. This will help to be sure of the original problem.
- Do not use flank infeed on work hardening materials.

## Component problems

Problem	Cause and Remedy
<b>Pitch error (on CNC machines)</b> <ul style="list-style-type: none"> <li>★ Starting too close to workpiece.</li> <li>★ Saddle speed towards chuck is excessive.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Start cycle further back from workpiece.</li> <li>☆ Reduce speed by 10% until correct.</li> </ul>
<b>Thread torn on one side only</b> <ul style="list-style-type: none"> <li>★ Incorrect helix angle in toolholder.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Check helix chart.</li> <li>☆ Reassemble with correct anvil</li> <li>☆ Check centre height.</li> </ul>
<b>Thread torn on both sides</b> <ul style="list-style-type: none"> <li>★ Running too slow.</li> <li>★ Built up edge.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Increase surface speed check centre height.</li> <li>☆ Check centre height</li> <li>☆ Use coated grade.</li> <li>☆ Compare thread speed with turning speed.</li> </ul>
<b>Long dangerous swarf</b> <ul style="list-style-type: none"> <li>★ Incorrect chipbreaker geometry.</li> <li>★ Incorrect method of infeed.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Use Canela (TD) chipbreaker.</li> <li>☆ Use different infeed method.</li> </ul>
<b>Vibration chatter marks on both flanks</b> <ul style="list-style-type: none"> <li>★ Poor stability.</li> <li>★ Excessive overhang.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Renew anvil to support insert.</li> <li>☆ Check tool clamping.</li> <li>☆ Reduce tool overhang</li> <li>☆ Check rigidity of setup.</li> </ul>
<b>Shallow threads Problem with gauging</b> <ul style="list-style-type: none"> <li>★ Insert not cresting.</li> <li>★ Incorrect effective diameter.</li> </ul>	<ul style="list-style-type: none"> <li>☆ Check machined diameters.</li> <li>☆ Excessive tool wear or chipped on nose see remedies above.</li> </ul>

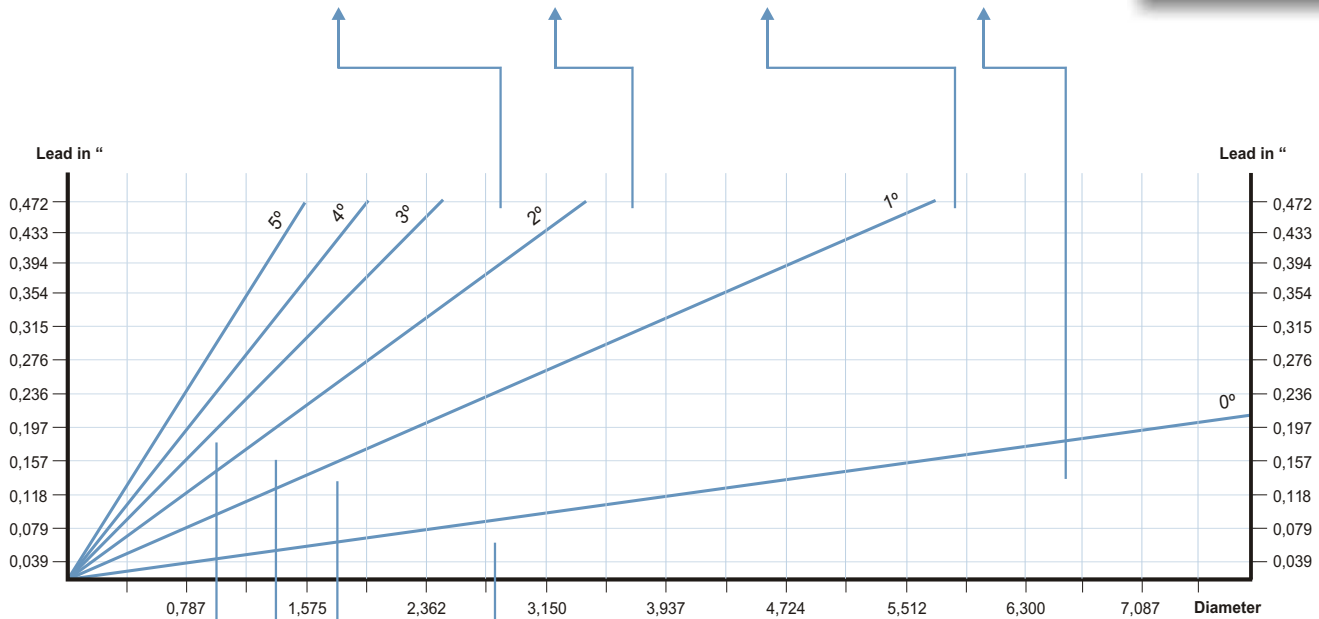
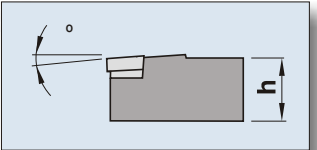
# Helix chart

## Feed direction towards the chuck



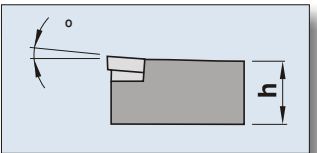
## Anvil to give correct helix

Insert size	+3°	+2°	+1°	+0°
16R	3424+3	3424+2	3424+1	3424
16L	3425+3	3425+2	3425+1	3425
22R	3430+3	3430+2	3430+1	3430
22L	3431+3	3431+2	3431+1	3431

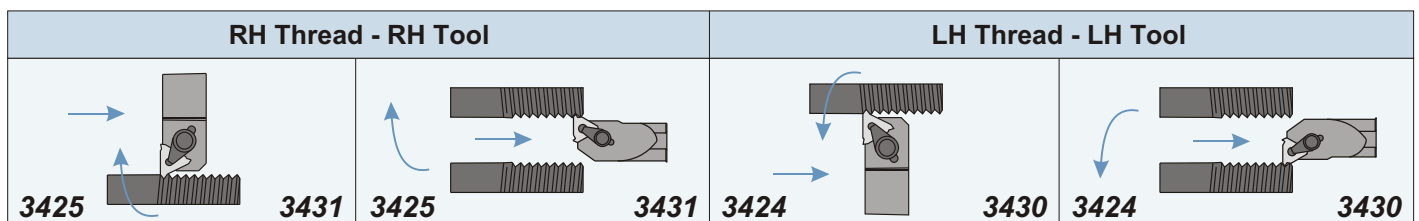


## Anvil to give correct helix

Insert size	-3°	-2°	-1°	0°
16R	3424-3	3424-2	3424-1	3424
16L	3425-3	3425-2	3425-1	3425
22R	3430-3	3430-2	3430-1	3430
22L	3431-3	3431-2	3431-1	3431



## Feed direction away from the chuck





A large rectangular area with a thin black border, containing 25 horizontal lines for writing notes.