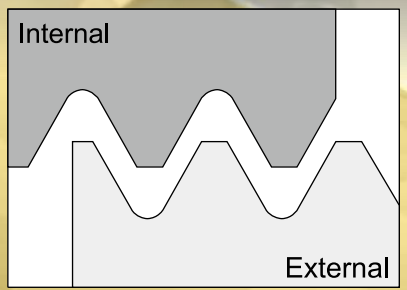
INDEX

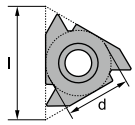
- *Positive chipbreaker design provides excellent chip control.*
- *Sharp edge and low cutting forces reduce burr and vibration.*
- *CX1555 and CX1560 grade are available.*
- *Welcome to order other thread types.*



Designations For Threading Insert

16	I	R	A	60
①	②	③	④	⑤

① Insert Size



l (mm)	d (inch)
11	1/4
16	3/8

② Application

E	External
I	Internal

③ Hand of Tool

R	Right Hand
L	Left Hand

④ Thread Pitch or TPI

Partial Profile

	TP (mm)	TPI
A	0.5 ~ 1.5	48 ~ 16
AG	0.5 ~ 3.0	48 ~ 8
G	1.75 ~ 3.0	14 ~ 8

Full Profile

Value by number

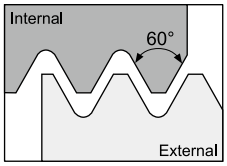
TP (mm)	TPI
0.75	34
⋮	⋮
3.00	8

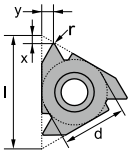
⑤ Thread Standard

Partial Profile	
55°	Partial Profile 55°
60°	Partial Profile 60°

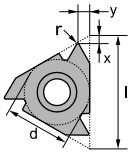
Full Profile	
ISO	ISO Metric 60°
UN	American UN 60°
W	Whitworth 55°

External





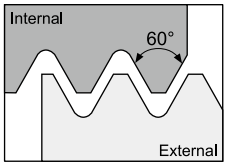
Right hand

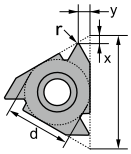


Left hand

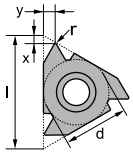
Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I11ERA601555	11ERA60-CX1555	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I11ELA601555	11ELA60-CX1555	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I16ERA601555	16ERA60-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ERA601560	16ERA60-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●	○	●	●
I16ELA601555	16ELA60-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ELA601560	16ELA60-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●	○	●	●
I16ERAG601555	16ERAG60-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ELAG601555	16ELAG60-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ERG601555	16ERG60-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16ELG601555	16ELG60-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16ELG601560	16ELG60-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●	○	●	●

Internal





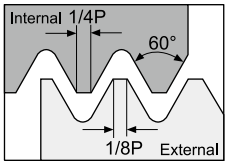
Right hand



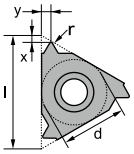
Left hand

Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I11IRA601555	11IRA60-CX1555	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I11ILA601555	11ILA60-CX1555	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I16IRA601555	16IRA60-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16IRA601560	16IRA60-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●	○	●	●
I16ILA601555	16ILA60-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ILA601560	16ILA60-CX1560	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●	○	●	●
I16IRAG601555	16IRAG60-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16IRAG601560	16IRAG60-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●	○	●	●
I16ILAG601555	16ILAG60-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ILAG601560	16ILAG60-CX1560	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●	○	●	●
I16IRG601555	16IRG60-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○
I16IRG601560	16IRG60-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●	○	●	●
I16ILG601555	16ILG60-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○
I16ILG601560	16ILG60-CX1560	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●	○	●	●

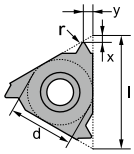
External



Tolerance Class : 6g/6H



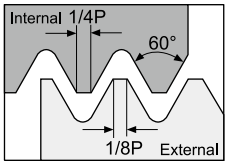
Right hand



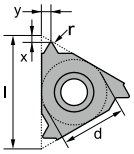
Left hand

Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TP (mm)	d	l	r	x	y	P	M	K	N	S	H
I11ER035ISO1555	11ER0.35ISO-CX1555	0.35	1/4"	11	0.04	0.8	0.4	●	●	●		○	○
I11EL035ISO1555	11EL0.35ISO-CX1555	0.35	1/4"	11	0.04	0.8	0.4	●	●	●		○	○
I11ER040ISO1555	11ER0.40ISO-CX1555	0.40	1/4"	11	0.04	0.7	0.4	●	●	●		○	○
I11ER045ISO1555	11ER0.45ISO-CX1555	0.45	1/4"	11	0.05	0.7	0.4	●	●	●		○	○
I11ER050ISO1555	11ER0.50ISO-CX1555	0.50	1/4"	11	0.05	0.6	0.6	●	●	●		○	○
I11EL050ISO1555	11EL0.50ISO-CX1555	0.50	1/4"	11	0.05	0.6	0.6	●	●	●		○	○
I11ER060ISO1555	11ER0.60ISO-CX1555	0.60	1/4"	11	0.07	0.6	0.6	●	●	●		○	○
I11ER070ISO1555	11ER0.70ISO-CX1555	0.70	1/4"	11	0.07	0.6	0.6	●	●	●		○	○
I11ER075ISO1555	11ER0.75ISO-CX1555	0.75	1/4"	11	0.08	0.6	0.6	●	●	●		○	○
I11EL075ISO1555	11EL0.75ISO-CX1555	0.75	1/4"	11	0.08	0.6	0.6	●	●	●		○	○
I11ER080ISO1555	11ER0.80ISO-CX1555	0.80	1/4"	11	0.09	0.6	0.6	●	●	●		○	○
I11ER100ISO1555	11ER1.00ISO-CX1555	1.00	1/4"	11	0.12	0.7	0.7	●	●	●		○	○
I11EL100ISO1555	11EL1.00ISO-CX1555	1.00	1/4"	11	0.12	0.7	0.7	●	●	●		○	○
I11ER125ISO1555	11ER1.25ISO-CX1555	1.25	1/4"	11	0.15	0.8	0.9	●	●	●		○	○
I11ER150ISO1555	11ER1.50ISO-CX1555	1.50	1/4"	11	0.18	0.8	1.0	●	●	●		○	○
I11EL150ISO1555	11EL1.50ISO-CX1555	1.50	1/4"	11	0.18	0.8	1.0	●	●	●		○	○
I16ER075ISO1555	16ER0.75ISO-CX1555	0.75	3/8"	16	0.08	0.6	0.6	●	●	●		○	○
I16ER075ISO1560	16ER0.75ISO-CX1560	0.75	3/8"	16	0.08	0.6	0.6	●	●	●	○	●	●
I16EL075ISO1555	16EL0.75ISO-CX1555	0.75	3/8"	16	0.08	0.6	0.6	●	●	●		○	○
I16EL075ISO1560	16EL0.75ISO-CX1560	0.75	3/8"	16	0.08	0.6	0.6	●	●	●	○	●	●
I16ER080ISO1555	16ER0.80ISO-CX1555	0.80	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16ER080ISO1560	16ER0.80ISO-CX1560	0.80	3/8"	16	0.09	0.6	0.6	●	●	●	○	●	●
I16EL080ISO1555	16EL0.80ISO-CX1555	0.80	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16EL080ISO1560	16EL0.80ISO-CX1560	0.80	3/8"	16	0.09	0.6	0.6	●	●	●	○	●	●
I16ER100ISO1555	16ER1.00ISO-CX1555	1.00	3/8"	16	0.12	0.7	0.7	●	●	●		○	○
I16ER100ISO1560	16ER1.00ISO-CX1560	1.00	3/8"	16	0.12	0.7	0.7	●	●	●	○	●	●
I16EL100ISO1555	16EL1.00ISO-CX1555	1.00	3/8"	16	0.12	0.7	0.7	●	●	●		○	○
I16EL100ISO1560	16EL1.00ISO-CX1560	1.00	3/8"	16	0.12	0.7	0.7	●	●	●	○	●	●

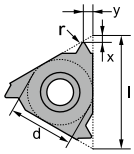
External



Tolerance Class : 6g/6H



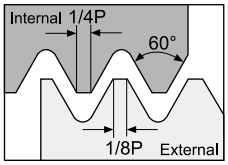
Right hand



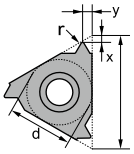
Left hand

Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TP (mm)	d	l	r	x	y	P	M	K	N	S	H
I16ER125ISO1555	16ER1.25ISO-CX1555	1.25	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16EL125ISO1555	16EL1.25ISO-CX1555	1.25	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16EL125ISO1560	16EL1.25ISO-CX1560	1.25	3/8"	16	0.15	0.8	0.9	●	●	●	○	●	●
I16ER150ISO1555	16ER1.50ISO-CX1555	1.50	3/8"	16	0.18	0.8	1.0	●	●	●		○	○
I16ER150ISO1560	16ER1.50ISO-CX1560	1.50	3/8"	16	0.18	0.8	1.0	●	●	●	○	●	●
I16EL150ISO1555	16EL1.50ISO-CX1555	1.50	3/8"	16	0.18	0.8	1.0	●	●	●		○	○
I16EL150ISO1560	16EL1.50ISO-CX1560	1.50	3/8"	16	0.18	0.8	1.0	●	●	●	○	●	●
I16ER175ISO1555	16ER1.75ISO-CX1555	1.75	3/8"	16	0.21	0.9	1.2	●	●	●		○	○
I16ER175ISO1560	16ER1.75ISO-CX1560	1.75	3/8"	16	0.21	0.9	1.2	●	●	●	○	●	●
I16EL175ISO1555	16EL1.75ISO-CX1555	1.75	3/8"	16	0.21	0.9	1.2	●	●	●		○	○
I16EL175ISO1560	16EL1.75ISO-CX1560	1.75	3/8"	16	0.21	0.9	1.2	●	●	●	○	●	●
I16ER200ISO1555	16ER2.00ISO-CX1555	2.00	3/8"	16	0.25	1.0	1.3	●	●	●		○	○
I16EL200ISO1555	16EL2.00ISO-CX1555	2.00	3/8"	16	0.25	1.0	1.3	●	●	●		○	○
I16EL200ISO1560	16EL2.00ISO-CX1560	2.00	3/8"	16	0.25	1.0	1.3	●	●	●	○	●	●
I16ER250ISO1555	16ER2.50ISO-CX1555	2.50	3/8"	16	0.31	1.1	1.5	●	●	●		○	○
I16ER250ISO1560	16ER2.50ISO-CX1560	2.50	3/8"	16	0.31	1.1	1.5	●	●	●	○	●	●
I16EL250ISO1555	16EL2.50ISO-CX1555	2.50	3/8"	16	0.31	1.1	1.5	●	●	●		○	○
I16EL250ISO1560	16EL2.50ISO-CX1560	2.50	3/8"	16	0.31	1.1	1.5	●	●	●	○	●	●
I16ER300ISO1555	16ER3.00ISO-CX1555	3.00	3/8"	16	0.38	1.2	1.6	●	●	●		○	○
I16EL300ISO1555	16EL3.00ISO-CX1555	3.00	3/8"	16	0.38	1.2	1.6	●	●	●		○	○
I16EL300ISO1560	16EL3.00ISO-CX1560	3.00	3/8"	16	0.38	1.2	1.6	●	●	●	○	●	●

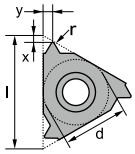
Internal



Tolerance Class : 6g/6H



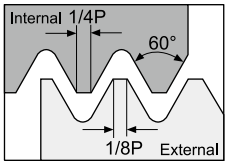
Right hand



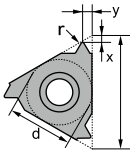
Left hand

Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TP (mm)	d	l	r	x	y	P	M	K	N	S	H
I11IR035ISO1555	11IR0.35ISO-CX1555	0.35	1/4"	11	0.02	0.8	0.3	●	●	●		○	○
I11IL035ISO1555	11IL0.35ISO-CX1555	0.35	1/4"	11	0.02	0.8	0.3	●	●	●		○	○
I11IR040ISO1555	11IR0.40ISO-CX1555	0.40	1/4"	11	0.02	0.8	0.4	●	●	●		○	○
I11IR050ISO1555	11IR0.50ISO-CX1555	0.50	1/4"	11	0.03	0.6	0.6	●	●	●		○	○
I11IL050ISO1555	11IL0.50ISO-CX1555	0.50	1/4"	11	0.03	0.6	0.6	●	●	●		○	○
I11IR070ISO1555	11IR0.70ISO-CX1555	0.70	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11IR075ISO1555	11IR0.75ISO-CX1555	0.75	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11IL075ISO1555	11IL0.75ISO-CX1555	0.75	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11IR080ISO1555	11IR0.80ISO-CX1555	0.80	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11IR100ISO1555	11IR1.00ISO-CX1555	1.00	1/4"	11	0.05	0.6	0.7	●	●	●		○	○
I11IL100ISO1555	11IL1.00ISO-CX1555	1.00	1/4"	11	0.05	0.6	0.7	●	●	●		○	○
I11IR125ISO1555	11IR1.25ISO-CX1555	1.25	1/4"	11	0.07	0.8	0.8	●	●	●		○	○
I11IL125ISO1555	11IL1.25ISO-CX1555	1.25	1/4"	11	0.07	0.8	0.8	●	●	●		○	○
I11IR150ISO1555	11IR1.50ISO-CX1555	1.50	1/4"	11	0.08	0.8	1.0	●	●	●		○	○
I11IL150ISO1555	11IL1.50ISO-CX1555	1.50	1/4"	11	0.08	0.8	1.0	●	●	●		○	○
I16IR075ISO1555	16IR0.75ISO-CX1555	0.75	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IR075ISO1560	16IR0.75ISO-CX1560	0.75	3/8"	16	0.04	0.6	0.6	●	●	●	○	●	●
I16IL075ISO1555	16IL0.75ISO-CX1555	0.75	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IL075ISO1560	16IL0.75ISO-CX1560	0.75	3/8"	16	0.04	0.6	0.6	●	●	●	○	●	●
I16IR080ISO1555	16IR0.80ISO-CX1555	0.80	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IR080ISO1560	16IR0.80ISO-CX1560	0.80	3/8"	16	0.04	0.6	0.6	●	●	●	○	●	●
I16IL080ISO1555	16IL0.80ISO-CX1555	0.80	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IL080ISO1560	16IL0.80ISO-CX1560	0.80	3/8"	16	0.04	0.6	0.6	●	●	●	○	●	●
I16IR100ISO1555	16IR1.00ISO-CX1555	1.00	3/8"	16	0.05	0.6	0.7	●	●	●		○	○
I16IR100ISO1560	16IR1.00ISO-CX1560	1.00	3/8"	16	0.05	0.6	0.7	●	●	●	○	●	●
I16IL100ISO1555	16IL1.00ISO-CX1555	1.00	3/8"	16	0.05	0.6	0.7	●	●	●		○	○
I16IL100ISO1560	16IL1.00ISO-CX1560	1.00	3/8"	16	0.05	0.6	0.7	●	●	●	○	●	●

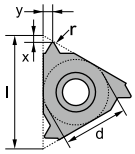
Internal



Tolerance Class : 6g/6H



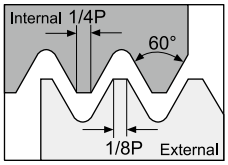
Right hand



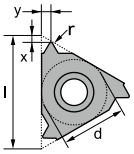
Left hand

Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TP (mm)	d	l	r	x	y	P	M	K	N	S	H
I16IR125ISO1555	16IR1.25ISO-CX1555	1.25	3/8"	16	0.07	0.8	0.9	●	●	●		○	○
I16IR125ISO1560	16IR1.25ISO-CX1560	1.25	3/8"	16	0.07	0.8	0.9	●	●	●	○	●	●
I16IL125ISO1555	16IL1.25ISO-CX1555	1.25	3/8"	16	0.07	0.8	0.9	●	●	●		○	○
I16IL125ISO1560	16IL1.25ISO-CX1560	1.25	3/8"	16	0.07	0.8	0.9	●	●	●	○	●	●
I16IR150ISO1555	16IR1.50ISO-CX1555	1.50	3/8"	16	0.10	0.8	1.0	●	●	●		○	○
I16IR150ISO1560	16IR1.50ISO-CX1560	1.50	3/8"	16	0.10	0.8	1.0	●	●	●	○	●	●
I16IL150ISO1555	16IL1.50ISO-CX1555	1.50	3/8"	16	0.10	0.8	1.0	●	●	●		○	○
I16IL150ISO1560	16IL1.50ISO-CX1560	1.50	3/8"	16	0.10	0.8	1.0	●	●	●	○	●	●
I16IR175ISO1555	16IR1.75ISO-CX1555	1.75	3/8"	16	0.12	0.9	1.2	●	●	●		○	○
I16IR175ISO1560	16IR1.75ISO-CX1560	1.75	3/8"	16	0.12	0.9	1.2	●	●	●	○	●	●
I16IL175ISO1555	16IL1.75ISO-CX1555	1.75	3/8"	16	0.12	0.9	1.2	●	●	●		○	○
I16IL175ISO1560	16IL1.75ISO-CX1560	1.75	3/8"	16	0.12	0.9	1.2	●	●	●	○	●	●
I16IR200ISO1555	16IR2.00ISO-CX1555	2.00	3/8"	16	0.13	1.0	1.3	●	●	●		○	○
I16IR200ISO1560	16IR2.00ISO-CX1560	2.00	3/8"	16	0.13	1.0	1.3	●	●	●	○	●	●
I16IL200ISO1555	16IL2.00ISO-CX1555	2.00	3/8"	16	0.13	1.0	1.3	●	●	●		○	○
I16IL200ISO1560	16IL2.00ISO-CX1560	2.00	3/8"	16	0.13	1.0	1.3	●	●	●	○	●	●
I16IR250ISO1555	16IR2.50ISO-CX1555	2.50	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16IR250ISO1560	16IR2.50ISO-CX1560	2.50	3/8"	16	0.15	1.1	1.5	●	●	●	○	●	●
I16IL250ISO1555	16IL2.50ISO-CX1555	2.50	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16IL250ISO1560	16IL2.50ISO-CX1560	2.50	3/8"	16	0.15	1.1	1.5	●	●	●	○	●	●
I16IR300ISO1555	16IR3.00ISO-CX1555	3.00	3/8"	16	0.18	1.1	1.5	●	●	●		○	○
I16IR300ISO1560	16IR3.00ISO-CX1560	3.00	3/8"	16	0.18	1.1	1.5	●	●	●	○	●	●
I16IL300ISO1555	16IL3.00ISO-CX1555	3.00	3/8"	16	0.18	1.1	1.5	●	●	●		○	○
I16IL300ISO1560	16IL3.00ISO-CX1560	3.00	3/8"	16	0.18	1.1	1.5	●	●	●	○	●	●

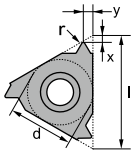
External



Tolerance Class : 2A/2B



Right hand

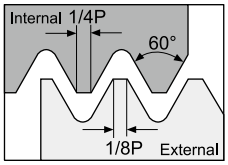


Left hand

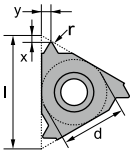
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I11ER32UN1555	11ER32UN-CX1555	32	1/4"	11	0.09	0.6	0.6	●	●	●		○	○
I11ER28UN1555	11ER28UN-CX1555	28	1/4"	11	0.10	0.6	0.7	●	●	●		○	○
I11EL28UN1555	11EL28UN-CX1555	28	1/4"	11	0.10	0.6	0.7	●	●	●		○	○
I11ER18UN1555	11ER18UN-CX1555	18	1/4"	11	0.17	0.8	1.0	●	●	●		○	○
I11ER16UN1555	11ER16UN-CX1555	16	1/4"	11	0.18	0.9	1.1	●	●	●		○	○
I16ER40UN1555	16ER40UN-CX1555	40	3/8"	16	0.06	0.6	0.6	●	●	●		○	○
I16EL40UN1555	16EL40UN-CX1555	40	3/8"	16	0.06	0.6	0.6	●	●	●		○	○
I16ER36UN1555	16ER36UN-CX1555	36	3/8"	16	0.07	0.6	0.6	●	●	●		○	○
I16EL36UN1555	16EL36UN-CX1555	36	3/8"	16	0.07	0.6	0.6	●	●	●		○	○
I16ER32UN1555	16ER32UN-CX1555	32	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16EL32UN1555	16EL32UN-CX1555	32	3/8"	16	0.09	0.6	0.6	●	●	●		○	○
I16ER28UN1555	16ER28UN-CX1555	28	3/8"	16	0.10	0.6	0.7	●	●	●		○	○
I16EL28UN1555	16EL28UN-CX1555	28	3/8"	16	0.10	0.6	0.7	●	●	●		○	○
I16ER26UN1555	16ER26UN-CX1555	26	3/8"	16	0.11	0.7	0.8	●	●	●		○	○
I16EL26UN1555	16EL26UN-CX1555	26	3/8"	16	0.11	0.7	0.8	●	●	●		○	○
I16ER24UN1555	16ER24UN-CX1555	24	3/8"	16	0.12	0.7	0.8	●	●	●		○	○
I16EL24UN1555	16EL24UN-CX1555	24	3/8"	16	0.12	0.7	0.8	●	●	●		○	○
I16ER20UN1555	16ER20UN-CX1555	20	3/8"	16	0.15	0.8	0.9	●	●	●		○	○
I16EL20UN1555	16EL20UN-CX1555	20	3/8"	16	0.15	0.8	0.9	●	●	●		○	○

Threading Inserts - American UN 60°

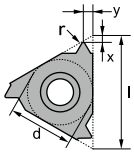
External



Tolerance Class : 2A/2B



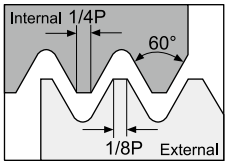
Right hand



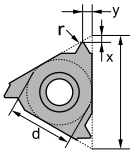
Left hand

Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I16ER18UN1555	16ER18UN-CX1555	18	3/8"	16	0.17	0.8	1.0	●	●	●		○	○
I16EL18UN1555	16EL18UN-CX1555	18	3/8"	16	0.17	0.8	1.0	●	●	●		○	○
I16ER16UN1555	16ER16UN-CX1555	16	3/8"	16	0.18	0.9	1.1	●	●	●		○	○
I16EL16UN1555	16EL16UN-CX1555	16	3/8"	16	0.18	0.9	1.1	●	●	●		○	○
I16ER14UN1555	16ER14UN-CX1555	14	3/8"	16	0.22	1.0	1.2	●	●	●		○	○
I16EL14UN1555	16EL14UN-CX1555	14	3/8"	16	0.22	1.0	1.2	●	●	●		○	○
I16ER13UN1555	16ER13UN-CX1555	13	3/8"	16	0.24	1.0	1.3	●	●	●		○	○
I16EL13UN1555	16EL13UN-CX1555	13	3/8"	16	0.24	1.0	1.3	●	●	●		○	○
I16ER12UN1555	16ER12UN-CX1555	12	3/8"	16	0.26	1.1	1.4	●	●	●		○	○
I16EL12UN1555	16EL12UN-CX1555	12	3/8"	16	0.26	1.1	1.4	●	●	●		○	○
I16ER115UN1555	16ER11.5UN-CX1555	11.5	3/8"	16	0.27	1.1	1.5	●	●	●		○	○
I16EL115UN1555	16EL11.5UN-CX1555	11.5	3/8"	16	0.27	1.1	1.5	●	●	●		○	○
I16ER11UN1555	16ER11UN-CX1555	11	3/8"	16	0.28	1.1	1.5	●	●	●		○	○
I16EL11UN1555	16EL11UN-CX1555	11	3/8"	16	0.28	1.1	1.5	●	●	●		○	○
I16ER10UN1555	16ER10UN-CX1555	10	3/8"	16	0.32	1.1	1.5	●	●	●		○	○
I16EL10UN1555	16EL10UN-CX1555	10	3/8"	16	0.32	1.1	1.5	●	●	●		○	○
I16ER9UN1555	16ER9UN-CX1555	9	3/8"	16	0.36	1.2	1.7	●	●	●		○	○
I16EL9UN1555	16EL9UN-CX1555	9	3/8"	16	0.36	1.2	1.7	●	●	●		○	○
I16ER8UN1555	16ER8UN-CX1555	8	3/8"	16	0.41	1.2	1.6	●	●	●		○	○
I16EL8UN1555	16EL8UN-CX1555	8	3/8"	16	0.41	1.2	1.6	●	●	●		○	○

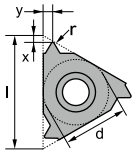
Internal



Tolerance Class : 2A/2B



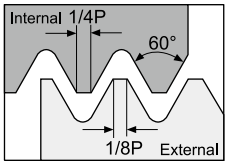
Right hand



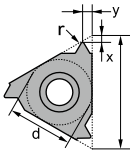
Left hand

Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I11IR32UN1555	11IR32UN-CX1555	32	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11IL32UN1555	11IL32UN-CX1555	32	1/4"	11	0.04	0.6	0.6	●	●	●		○	○
I11IR28UN1555	11IR28UN-CX1555	28	1/4"	11	0.04	0.6	0.7	●	●	●		○	○
I11IL28UN1555	11IL28UN-CX1555	28	1/4"	11	0.04	0.6	0.7	●	●	●		○	○
I11IR24UN1555	11IR24UN-CX1555	24	1/4"	11	0.05	0.7	0.8	●	●	●		○	○
I11IL24UN1555	11IL24UN-CX1555	24	1/4"	11	0.05	0.7	0.8	●	●	●		○	○
I11IR20UN1555	11IR20UN-CX1555	20	1/4"	11	0.06	0.8	0.9	●	●	●		○	○
I11IL20UN1555	11IL20UN-CX1555	20	1/4"	11	0.06	0.8	0.9	●	●	●		○	○
I11IR18UN1555	11IR18UN-CX1555	18	1/4"	11	0.07	0.8	1.0	●	●	●		○	○
I11IL18UN1555	11IL18UN-CX1555	18	1/4"	11	0.07	0.8	1.0	●	●	●		○	○
I11IR16UN1555	11IR16UN-CX1555	16	1/4"	11	0.09	0.9	1.1	●	●	●		○	○
I11IL16UN1555	11IL16UN-CX1555	16	1/4"	11	0.09	0.9	1.1	●	●	●		○	○
I16IR40UN1555	16IR40UN-CX1555	40	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16IL40UN1555	16IL40UN-CX1555	40	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16IR36UN1555	16IR36UN-CX1555	36	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16IL36UN1555	16IL36UN-CX1555	36	3/8"	16	0.03	0.6	0.6	●	●	●		○	○
I16IR32UN1555	16IR32UN-CX1555	32	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IL32UN1555	16IL32UN-CX1555	32	3/8"	16	0.04	0.6	0.6	●	●	●		○	○
I16IR28UN1555	16IR28UN-CX1555	28	3/8"	16	0.04	0.6	0.7	●	●	●		○	○
I16IL28UN1555	16IL28UN-CX1555	28	3/8"	16	0.04	0.6	0.7	●	●	●		○	○
I16IR26UN1555	16IR26UN-CX1555	26	3/8"	16	0.04	0.7	0.8	●	●	●		○	○
I16IL26UN1555	16IL26UN-CX1555	26	3/8"	16	0.04	0.7	0.8	●	●	●		○	○
I16IR24UN1555	16IR24UN-CX1555	24	3/8"	16	0.05	0.7	0.8	●	●	●		○	○
I16IL24UN1555	16IL24UN-CX1555	24	3/8"	16	0.05	0.7	0.8	●	●	●		○	○
I16IR20UN1555	16IR20UN-CX1555	20	3/8"	16	0.06	0.8	0.9	●	●	●		○	○
I16IL20UN1555	16IL20UN-CX1555	20	3/8"	16	0.06	0.8	0.9	●	●	●		○	○

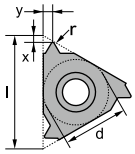
Internal



Tolerance Class : 2A/2B



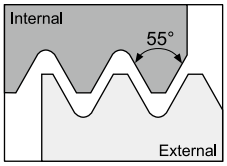
Right hand

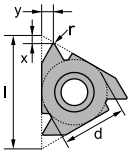


Left hand

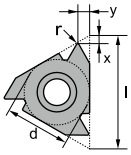
Order No.	Designation	Pitch	Dimensions (mm)					Working Material					
		TPI	d	l	r	x	y	P	M	K	N	S	H
I16IR18UN1555	16IR18UN-CX1555	18	3/8"	16	0.07	0.8	1.0	●	●	●		○	○
I16IL18UN1555	16IL18UN-CX1555	18	3/8"	16	0.07	0.8	1.0	●	●	●		○	○
I16IR16UN1555	16IR16UN-CX1555	16	3/8"	16	0.09	0.9	1.1	●	●	●		○	○
I16IL16UN1555	16IL16UN-CX1555	16	3/8"	16	0.09	0.9	1.1	●	●	●		○	○
I16IR14UN1555	16IR14UN-CX1555	14	3/8"	16	0.10	0.9	1.2	●	●	●		○	○
I16IL14UN1555	16IL14UN-CX1555	14	3/8"	16	0.10	0.9	1.2	●	●	●		○	○
I16IR13UN1555	16IR13UN-CX1555	13	3/8"	16	0.11	1.0	1.3	●	●	●		○	○
I16IL13UN1555	16IL13UN-CX1555	13	3/8"	16	0.11	1.0	1.3	●	●	●		○	○
I16IR12UN1555	16IR12UN-CX1555	12	3/8"	16	0.12	1.1	1.4	●	●	●		○	○
I16IL12UN1555	16IL12UN-CX1555	12	3/8"	16	0.12	1.1	1.4	●	●	●		○	○
I16IR115UN1555	16IR11.5UN-CX1555	11.5	3/8"	16	0.13	1.1	1.5	●	●	●		○	○
I16IL115UN1555	16IL11.5UN-CX1555	11.5	3/8"	16	0.13	1.1	1.5	●	●	●		○	○
I16IR11UN1555	16IR11UN-CX1555	11	3/8"	16	0.14	1.1	1.5	●	●	●		○	○
I16IL11UN1555	16IL11UN-CX1555	11	3/8"	16	0.14	1.1	1.5	●	●	●		○	○
I16IR10UN1555	16IR10UN-CX1555	10	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16IL10UN1555	16IL10UN-CX1555	10	3/8"	16	0.15	1.1	1.5	●	●	●		○	○
I16IR9UN1555	16IR9UN-CX1555	9	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16IL9UN1555	16IL9UN-CX1555	9	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16IR8UN1555	16IR8UN-CX1555	8	3/8"	16	0.19	1.1	1.5	●	●	●		○	○
I16IL8UN1555	16IL8UN-CX1555	8	3/8"	16	0.19	1.1	1.5	●	●	●		○	○

External





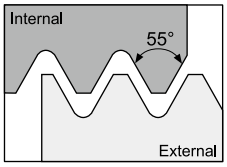
Right hand

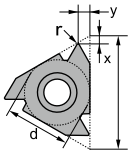


Left hand

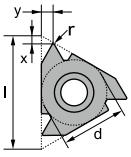
Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I11ERA551555	11ERA55-CX1555	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I11ELA551555	11ELA55-CX1555	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I16ERA551555	16ERA55-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ELA551555	16ELA55-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ERAG551555	16ERAG55-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ELAG551555	16ELAG55-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ERG551555	16ERG55-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○
I16ELG551555	16ELG55-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.17	1.2	1.7	●	●	●		○	○

Internal





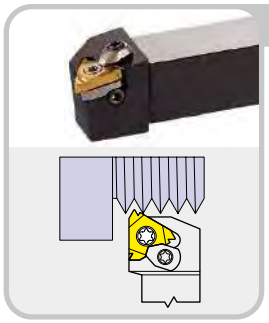
Right hand



Left hand

Order No.	Designation	Pitch		Dimensions (mm)					Working Material					
		TP (mm)	TPI	d	l	r	x	y	P	M	K	N	S	H
I11IRA551555	11IRA55-CX1555	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I11ILA551555	11ILA55-CX1555	0.5 ~ 1.5	48 ~ 16	1/4"	11	0.05	0.8	0.9	●	●	●		○	○
I16IRA551555	16IRA55-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16ILA551555	16ILA55-CX1555	0.5 ~ 1.5	48 ~ 16	3/8"	16	0.05	0.8	0.9	●	●	●		○	○
I16IRAG551555	16IRAG55-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16ILAG551555	16ILAG55-CX1555	0.5 ~ 3.0	48 ~ 8	3/8"	16	0.05	1.2	1.7	●	●	●		○	○
I16IRG551555	16IRG55-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○
I16ILG551555	16ILG55-CX1555	1.75 ~ 3.0	14 ~ 8	3/8"	16	0.12	1.2	1.7	●	●	●		○	○

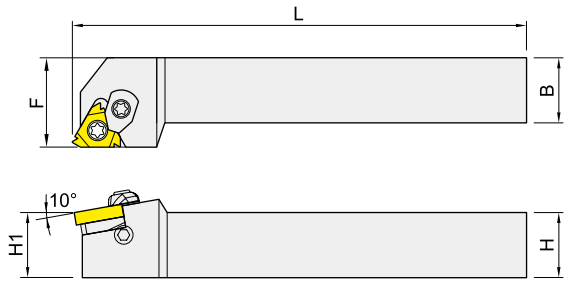
External Threading Tool Holders



SE..CL

SER1010K16HC
SER1212K16HC

SER1216K16HC
SER1616K16HC



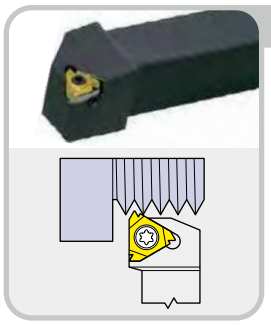
Right-hand shown

Order No.	Dimensions (mm)				Insert	Spare parts
	H(H1)	B	L	F		
ISE$^{R}/_{L}$1010K16HC	10	10	125	10	16ER or 16EL	①
ISE$^{R}/_{L}$1212K16HC	12	12	125	12		
ISE$^{R}/_{L}$1216K16HC	12	16	125	16		
ISE$^{R}/_{L}$1616K16HC	16	16	125	16		
ISE$^{R}/_{L}$1616K16CL	16	16	125	20		②
ISE$^{R}/_{L}$2020K16CL	20	20	125	25		
ISE$^{R}/_{L}$2525M16CL	25	25	150	32		
ISE$^{R}/_{L}$3232P16CL	32	32	170	40		

Spare parts	Screw	Shim	Screw	Wrench	Clamp	Wrench
①	IMS3509A	-	-	-	-	ITK15
②	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	IMC353V	ITK15

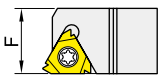
※ SER right hand tools shim is IGXE16, SEL left hand tools shim is IGXN16.

External Threading Tool Holders

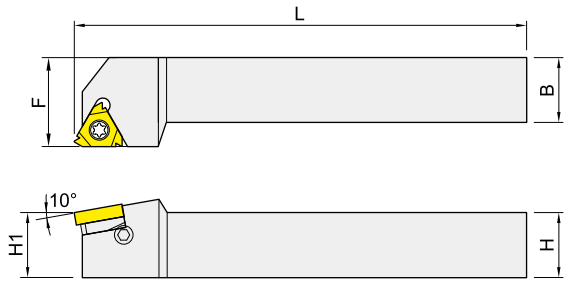


SE

SER1010K16
SER1212K16



SER1216K16
SER1616K16H



Right-hand shown

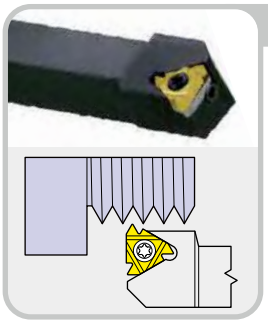
Order No.	Dimensions (mm)				Insert	Spare parts
	H(H1)	B	L	F		
ISE$^{R}/_{L}$1216K16	12	16	125	16	16ER or 16EL	①
ISE$^{R}/_{L}$1010K16H	10	10	125	10		
ISE$^{R}/_{L}$1212K16H	12	12	125	12		
ISE$^{R}/_{L}$1616K16H	16	16	125	16		
ISE$^{R}/_{L}$1616K16	16	16	125	20		②
ISE$^{R}/_{L}$2020K16	20	20	125	25		
ISE$^{R}/_{L}$2525M16	25	25	150	32		
ISE$^{R}/_{L}$3232P16	32	32	170	40		

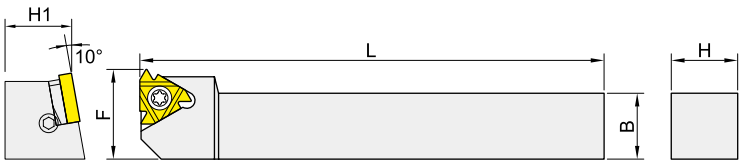
Spare parts	Screw	Shim	Screw	Wrench	Wrench
①	IMS3509A	-	-	-	ITK15
②	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	ITK15

※ SER right hand tools shim is IGXE16, SEL left hand tools shim is IGXN16.

External Threading Tool Holders

SKE





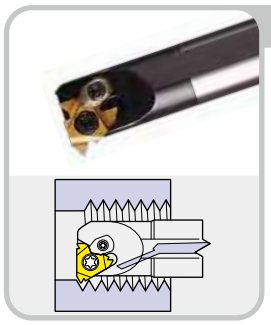
Right-hand shown

Order No.	Dimensions (mm)				Insert	Spare parts
	H(H1)	B	L	F		
ISKE$^{R}_{L}$1212K16	12	12	125	18	16ER or 16EL	①
ISKE$^{R}_{L}$1616K16	16	16	125	22		②
ISKE$^{R}_{L}$2020K16	20	20	125	27		
ISKE$^{R}_{L}$2525M16	25	25	150	34		

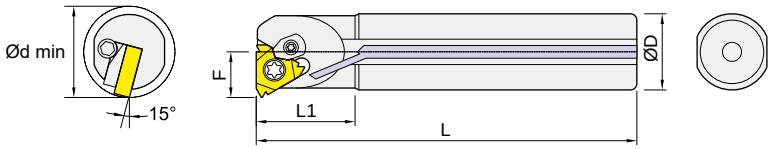
Spare parts	Screw	Shim	Screw	Wrench	Wrench
①	IMS3509A	-	-	-	ITK15
②	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	ITK15

※ SKER right hand tools shim is IGXE16, SKEL left hand tools shim is IGXN16.

Internal Threading Tool Holders



SN..CL



Right-hand shown

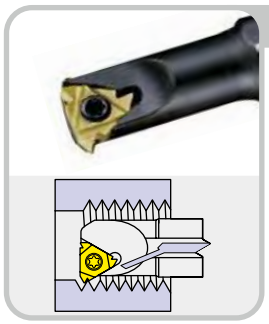
Order No.	Dimensions (mm)					Coolant	Insert	Spare parts
	D	L	L1	F	d min			
ISN$^{R}_{L}$0020R16CL	20	200	40	12	24		16IR or 16IL	①
ISN$^{R}_{L}$0025R16CL	25	200	45	14.5	29			
ISN$^{R}_{L}$0032S16CL	32	250	45	18.5	36			
ISN$^{R}_{L}$A0020R16CL	20	200	40	12	24	●		
ISN$^{R}_{L}$A0025R16CL	25	200	45	14.5	29	●		
ISN$^{R}_{L}$A0032S16CL	32	250	45	18.5	36	●		

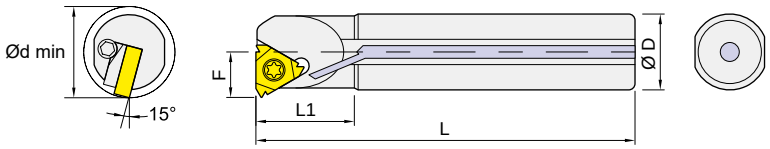
Spare parts	Screw	Shim	Screw	Wrench	Clamp	Wrench
①	IMS3512A	IGXN16 or IGXE16	IHTM309	IPL25	IMC353V	ITK15

※ SNR right hand tools shim is IGXN16, SNL left hand tools shim is IGXE16.

Internal Threading Tool Holders

SN





Right-hand shown

Order No.	Dimensions (mm)					Coolant	Insert	Spare parts
	D	L	L1	F	d min			
ISN$^{R}_{L}$0010K11S10	10	125	22	6.5	13		11IR or 11IL	①
ISN$^{R}_{L}$0012M11S12	12	150	26	8	16			
ISN$^{R}_{L}$A0010K11S10	10	125	22	6.5	13	●		
ISN$^{R}_{L}$A0012M11S12	12	150	26	8	16	●		
ISN$^{R}_{L}$0016Q16	16	180	36	10	19		16IR or 16IL	②
ISN$^{R}_{L}$0020R16	20	200	40	12	24			③
ISN$^{R}_{L}$0025R16	25	200	45	14.5	29			
ISN$^{R}_{L}$0032S16	32	250	45	18.5	36			
ISN$^{R}_{L}$A0016Q16	16	180	36	10	19	●		②
ISN$^{R}_{L}$A0020R16	20	200	40	12	24	●		③
ISN$^{R}_{L}$A0025R16	25	200	45	14.5	29	●		
ISN$^{R}_{L}$A0032S16	32	250	45	18.5	36	●		

Spare parts	Screw	Wrench	Shim	Screw	Wrench
①	IMS2507G	ITK08	-	-	-
②	IMS3509A	ITK15	-	-	-
③	IMS3512A	ITK15	IGXN16 or IGXE16	IHTM309	IPL25

※ SNR right hand tools shim is IGXN16, SNL left hand tools shim is IGXE16.

Recommended Cutting Conditions

Working Material	Vc (m/min)
Carbon Steel (HB85-225)	60 -100 -140
Stainless 300 Series	40 - 80 - 120
Cast Iron (HB140-220)	60 - 90 -120
High Temperature Alloy	25 - 45 - 65
Hardened Steel	20 - 40 -60

Depth of Cut And Number of Passes

ISO Metric 60° External

No. of Passes	Pitch (mm)															
	0.5	0.75	0.8	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0
	Radial infeed per pass (mm)															
1	0.102	0.178	0.178	0.178	0.178	0.229	0.229	0.254	0.279	0.279	0.330	0.330	0.381	0.406	0.432	0.457
2	0.102	0.152	0.152	0.178	0.178	0.203	0.203	0.229	0.254	0.254	0.305	0.330	0.330	0.381	0.406	0.432
3	0.076	0.102	0.127	0.127	0.152	0.178	0.152	0.178	0.203	0.203	0.254	0.254	0.279	0.330	0.330	0.356
4	0.076	0.076	0.076	0.102	0.127	0.152	0.152	0.152	0.178	0.178	0.203	0.229	0.229	0.279	0.279	0.305
5	**0.356**	**0.508**	**0.533**	0.076	0.102	0.127	0.127	0.152	0.152	0.152	0.178	0.178	0.229	0.229	0.229	0.279
6				**0.660**	0.076	0.076	0.102	0.127	0.127	0.152	0.178	0.178	0.203	0.229	0.229	0.229
7					**0.813**	**0.965**	0.102	0.102	0.127	0.127	0.152	0.152	0.178	0.203	0.203	0.229
8							0.076	0.076	0.102	0.127	0.152	0.152	0.178	0.178	0.178	0.203
9							**1.143**	**1.270**	0.102	0.127	0.152	0.152	0.152	0.178	0.178	0.203
10									0.076	0.102	0.127	0.127	0.152	0.178	0.178	0.178
11									**1.600**	0.102	0.102	0.127	0.152	0.152	0.152	0.178
12										0.076	0.076	0.127	0.127	0.152	0.152	0.152
13										**1.880**	**2.210**	0.102	0.127	0.127	0.127	0.152
14												0.076	0.102	0.102	0.127	0.152
15												**2.515**	**2.819**	**3.124**	0.127	0.127
16															0.102	0.102
															3.429	**3.734**

Last pass equals total depth of thread.

ISO Metric 60° Internal

No. of Passes	Pitch (mm)														
	0.5	0.75	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0
	Radial infeed per pass (mm)														
1	0.102	0.178	0.178	0.203	0.254	0.229	0.254	0.279	0.279	0.305	0.330	0.356	0.381	0.381	0.406
2	0.102	0.127	0.152	0.178	0.203	0.203	0.229	0.229	0.229	0.279	0.305	0.330	0.356	0.356	0.406
3	0.076	0.102	0.102	0.127	0.152	0.152	0.178	0.178	0.203	0.229	0.229	0.279	0.305	0.305	0.356
4	0.076	0.076	0.102	0.102	0.102	0.127	0.152	0.152	0.152	0.203	0.203	0.229	0.254	0.254	0.279
5	**0.356**	**0.483**	0.076	0.102	0.102	0.102	0.127	0.152	0.152	0.178	0.178	0.203	0.229	0.229	0.229
6			**0.610**	0.076	0.076	0.102	0.102	0.127	0.152	0.152	0.152	0.178	0.203	0.203	0.229
7				**0.787**	**0.889**	0.102	0.102	0.102	0.127	0.152	0.152	0.152	0.178	0.178	0.203
8						0.076	0.076	0.102	0.102	0.152	0.152	0.152	0.152	0.178	0.178
9						**1.092**	**1.219**	0.102	0.102	0.127	0.127	0.152	0.152	0.152	0.178
10								0.076	0.102	0.102	0.127	0.152	0.152	0.152	0.152
11								**1.499**	0.102	0.102	0.102	0.127	0.152	0.152	0.152
12									0.076	0.076	0.102	0.127	0.152	0.152	0.152
13									**1.778**	**2.057**	0.102	0.102	0.127	0.152	0.152
14											0.076	0.102	0.102	0.127	0.152
15											**2.337**	**2.642**	**2.896**	0.127	0.127
16														0.102	0.102
														3.200	**3.454**

Last pass equals total depth of thread.

Depth of Cut And Number of Passes

Unified(UN) 60° External

No. of Passes	TPI												
	32	28	24	20	18	16	14	13	12	11	10	9	8
	Radial infeed per pass (mm)												
1	0.178	0.178	0.178	0.203	0.229	0.229	0.229	0.254	0.279	0.279	0.279	0.279	0.305
2	0.152	0.152	0.178	0.178	0.203	0.203	0.229	0.229	0.229	0.254	0.229	0.229	0.254
3	0.127	0.127	0.152	0.152	0.152	0.152	0.178	0.178	0.203	0.203	0.203	0.203	0.229
4	0.076	0.102	0.127	0.127	0.152	0.152	0.152	0.152	0.152	0.178	0.178	0.178	0.178
5	**0.533**	0.076	0.076	0.102	0.127	0.127	0.127	0.152	0.152	0.152	0.152	0.152	0.178
6		**0.635**	**0.711**	0.076	0.076	0.102	0.102	0.127	0.152	0.152	0.152	0.152	0.152
7				**0.838**	**0.940**	0.076	0.102	0.102	0.127	0.127	0.152	0.152	0.152
8						**1.041**	0.076	0.076	0.076	0.102	0.127	0.127	0.152
9							**1.194**	**1.270**	**1.372**	0.076	0.102	0.127	0.127
10										**1.499**	0.076	0.102	0.127
11											**1.651**	0.076	0.102
12												**1.778**	0.076
13													**2.032**

Last pass equals total depth of thread.

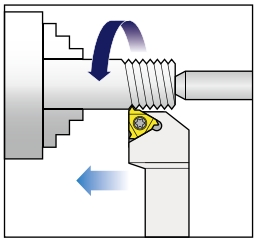
Unified(UN) 60° Internal

No. of Passes	TPI												
	32	28	24	20	18	16	14	13	12	11	10	9	8
	Radial infeed per pass (mm)												
1	0.178	0.178	0.178	0.203	0.229	0.229	0.229	0.254	0.279	0.279	0.279	0.279	0.305
2	0.152	0.152	0.152	0.178	0.178	0.178	0.203	0.229	0.229	0.229	0.229	0.229	0.279
3	0.102	0.102	0.152	0.127	0.152	0.152	0.152	0.152	0.178	0.178	0.152	0.178	0.203
4	0.076	0.102	0.102	0.102	0.127	0.127	0.152	0.152	0.152	0.152	0.152	0.152	0.178
5	**0.508**	0.076	0.076	0.102	0.102	0.102	0.102	0.127	0.127	0.152	0.152	0.152	0.152
6		**0.610**	**0.660**	0.076	0.076	0.102	0.102	0.102	0.102	0.127	0.127	0.152	0.152
7				**0.787**	**0.864**	0.076	0.102	0.102	0.102	0.102	0.102	0.127	0.127
8						**0.940**	0.076	0.076	0.076	0.102	0.102	0.102	0.102
9							**1.118**	**1.194**	**1.245**	0.076	0.102	0.102	0.102
10										**1.397**	0.076	0.102	0.102
11											**1.499**	0.076	0.102
12												**1.651**	0.076
13													**1.880**

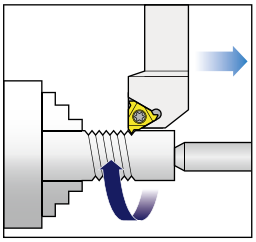
Last pass equals total depth of thread.

Thread Methods

External Right Hand Thread

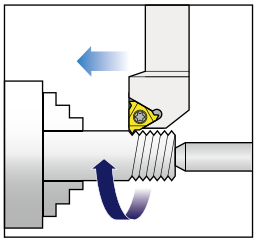


Spindle : Clockwise
Tool : right hand

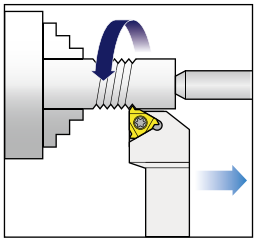


Spindle : Counterclockwise
Tool : left hand

External Left Hand Thread

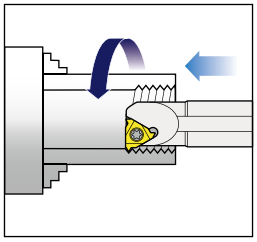


Spindle : Counterclockwise
Tool : left hand

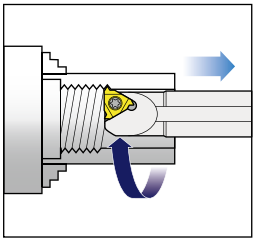


Spindle : Clockwise
Tool : right hand

Internal Right Hand Thread

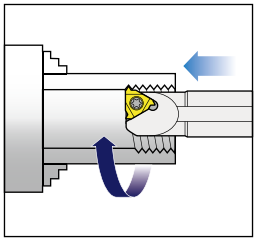


Spindle : Clockwise
Tool : right hand

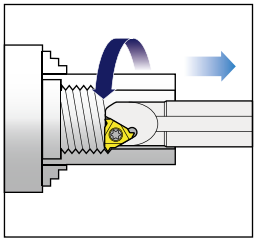


Spindle : Counterclockwise
Tool : left hand

Internal Left Hand Thread

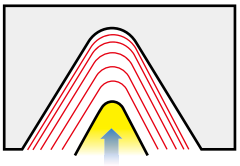
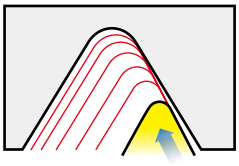
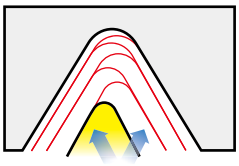


Spindle : Counterclockwise
Tool : left hand



Spindle : Clockwise
Tool : right hand

Infeed Methods

Infeed Methods	Features
 Radial Infeed	• For pitches of less than 1.5mm or 16 T.P.I. • Most commonly used method on manual lathes. • Equal wear on leading and trailing edge. • Good surface finish on trailing edge. • Use on work hardening materials. • Use on short chipping materials.
 Modified Flank Infeed	• For threads greater than 1.5mm or 16 T.P.I. • Reduced cutting pressure on larger pitches. • Reduced chatter. • Directs chip away from the cutting edge. • Displaced in-feed angle improves surface finish. • First choice for internal threading.
 Alternating Flank Infeed	• Recommended for large pitches. • Recommended for long chipping materials. • Method divides the work between both flanks. • Results in equal wear. • Less cutting pressure. • Not available on all lathes.