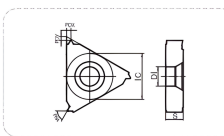


## Edgetec Threading Inserts

Industry	Diagram	Thread Type	Thread	Shape	Pitch	Tooth number
General Industry		ISO Metric Thread	ISO Metric 60 Thread		1-6	4-25
General Industry		Universal Thread	55 Universal Pitch Thread		0,5-5	5-51
			60 Universal Pitch Thread			
General Industry		Whitworth Thread	W			8-28
Aerospace Industry Equipment		UN Thread	UN			5-28
Pipe thread for gas, heating and tap water faucets		BSPT	BSPT			11-28
For pipeline connected with gas and tap water faucets		NPT	NPT			8-27

### ISO metric 60° thread

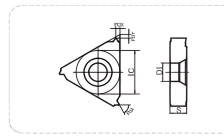


Working condition: ● Stable ● Average ■ Tough

Workpiece material	P	M	K	N	S
Steel	●	●	●	●	●
Stainless steel	●	●	●	●	●
Cast iron	●	●	●	●	●
Non-ferrous metal	●	●	●	●	●
Heat resistant super alloys Titanium alloy	●	●	●	●	●

Processing	Insert shape	Type	Pitch/number of teeth	Dimension (mm)						CVD					PVD			
				IC	PDX	PDY	S	DI	PNA	HS5225	HS5123	HS5133	HS5615	HS7125	HS7225	HS5125	HS5225	
External threading		16ER100ISO	1.00	9,525	0,7	0,7	3,52	4,0	60°								★	★
		16ER125ISO	1.25	9,525	0,9	0,8	3,52	4,0	60°								★	★
		16ER150ISO	1.50	9,525	1,0	0,8	3,52	4,0	60°								★	★
		16ER175ISO	1.75	9,525	1,2	0,9	3,52	4,0	60°								★	★
		16ER200ISO	2.00	9,525	1,3	1,0	3,52	4,0	60°								★	★
		16ER250ISO	2.50	9,525	1,5	1,2	3,52	4,0	60°								★	★
		16ER300ISO	3.00	9,525	1,6	1,3	3,52	4,0	60°								★	★
		22ER350ISO	3.50	12,700	2,3	1,6	4,65	5,0	60°								★	★
		22ER400ISO	4.00	12,700	2,3	1,6	4,65	5,0	60°								★	★
		22ER450ISO	4.50	12,700	2,4	1,7	4,65	5,0	60°								★	★
		22ER500ISO	5.00	12,700	2,4	1,7	4,65	5,0	60°								★	★
		22ER550ISO	5.50	12,700	2,5	1,6	4,65	5,0	60°								★	★
		22ER600ISO	6.00	12,700	2,7	1,7	4,65	5,0	60°								★	★

### ISO metric 60° thread



Working condition: ● Stable ● Average ■ Tough

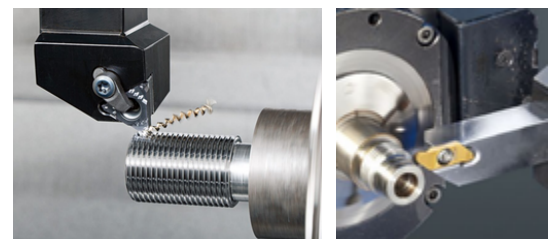
Workpiece material	P	M	K	N	S
Steel	●	●	●	●	●
Stainless steel	●	●	●	●	●
Cast iron	●	●	●	●	●
Non-ferrous metal	●	●	●	●	●
Heat resistant super alloys Titanium alloy	●	●	●	●	●

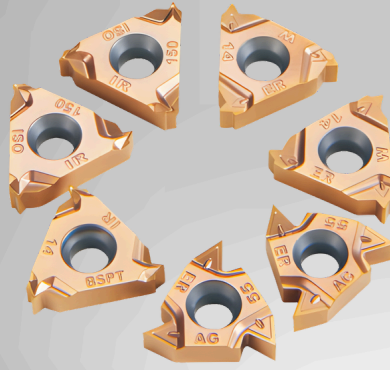
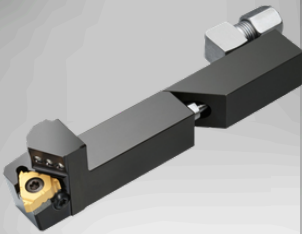
Processing	Insert shape	Type	Pitch/number of teeth	Dimension (mm)						CVD					PVD			
				IC	PDX	PDY	S	DI	PNA	HS5225	HS5123	HS5133	HS5615	HS7125	HS7225	HS5125	HS5225	
Internal threading		11IR100ISO	1.00	6,35	0,7	0,7	3,05	3,2	60°								★	★
		11IR125ISO	1.25	6,35	0,9	0,8	3,05	3,2	60°								★	★
		11IR150ISO	1.50	6,35	1,0	0,8	3,05	3,2	60°								★	★
		16R100ISO	1.00	9,525	0,7	0,7	3,52	4,0	60°								★	★
		16R125ISO	1.25	9,525	0,9	0,8	3,52	4,0	60°								★	★
		16R150ISO	1.50	9,525	1,0	0,8	3,52	4,0	60°								★	★
		16R175ISO	1.75	9,525	1,2	0,9	3,52	4,0	60°								★	★
		16R200ISO	2.00	9,525	1,3	1,0	3,52	4,0	60°								★	★
		16R250ISO	2.50	9,525	1,5	1,1	3,52	4,0	60°								★	★
		16R300ISO	3.00	9,525	1,5	1,1	3,52	4,0	60°								★	★
		22R350ISO	3.50	12,700	2,3	1,6	4,65	5,0	60°								★	★
		22R400ISO	4.00	12,700	2,3	1,6	4,65	5,0	60°								★	★
		22R450ISO	4.50	12,700	2,4	1,6	4,65	5,0	60°								★	★
		22R500ISO	5.00	12,700	2,4	1,6	4,65	5,0	60°								★	★
22R550ISO	5.50	12,700	2,5	1,6	4,65	5,0	60°								★	★		
22R600ISO	6.00	12,700	2,5	1,8	4,65	5,0	60°								★	★		

★ Recommended grade ☆ Available grade

### Grade of Thread Inserts

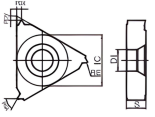
Grade	Coating	characteristic	Recommendation
HS5125	PVD	Special mixing ratios of ingredients have effectively improved the overall performance of the matrix, enhancing its flexural strength and resistance to heat-induced cracks.	Preferred grade for thread processing.
HS5225	PVD	Unique matrix with excellent tool tip and cutting edge processing technology; With the latest nano coating containing Si, the insert is guaranteed to have high hardness, high wear resistance and sharp properties.	Special grades for stainless steel processing.





## Edgetec Threading Inserts

### Universal thread



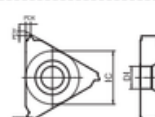
Working condition: ● Stable ● Average □ Tough

Workpiece material	P	M	K	N	S
Steel	●	●	●	●	●
Stainless steel	●	●	●	●	●
Cast iron	●	●	●	●	●
Non-ferrous metal	●	●	●	●	●
Heat resistant super alloys	●	●	●	●	●
Titanium alloy	●	●	●	●	●

Processing	Insert shape	Type	Pitch/ number of teeth	Dimension (mm)							CVD				PVD		
				IC	PDX	PDY	S	RE	DI	PNA	H58225	H58123	H58133	H56115	H57125	H57225	H55125
External threading		16ERA55	0,5-1,5	9,525	0,9	0,8	3,52	0,05	4,0	55°						★	★
		16ERG55	1,75-3,0	9,525	1,7	1,2	3,52	0,23	4,0	55°						★	★
		16ERAG55	0,5-3,0	9,525	1,7	1,2	3,52	0,06	4,0	55°						★	★
		22ERN55	3,5-5,0	12,700	2,5	1,7	4,65	0,51	5,0	55°						★	★
		16ERA60	0,5-1,5	9,525	0,9	0,8	3,52	0,06	4,0	60°						★	★
		16ERG60	1,75-3,0	9,525	1,7	1,2	3,52	0,18	4,0	60°						★	★
		16ERAG60	0,5-3,0	9,525	1,7	1,2	3,52	0,07	4,0	60°						★	★
		22ERN60	3,5-5,0	12,700	2,5	1,7	4,65	0,51	5,0	60°						★	★

★ Recommended grade ☆ Available grade

### UN united thread



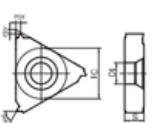
Working condition: ● Stable ● Average □ Tough

Workpiece material	P	M	K	N	S
Steel	●	●	●	●	●
Stainless steel	●	●	●	●	●
Cast iron	●	●	●	●	●
Non-ferrous metal	●	●	●	●	●
Heat resistant super alloys	●	●	●	●	●
Titanium alloy	●	●	●	●	●

Processing	Insert shape	Type	Pitch/ number of teeth	Dimension (mm)							CVD				PVD	
				IC	PDX	PDY	S	DI	PNA	H58225	H58123	H58133	H56115	H57125	H57225	H55125
External threading		16ER8UN	8	9,525	1,7	1,2	3,52	4,0	60°						★	★
		16ER12UN	12	9,525	1,4	1,1	3,52	4,0	60°						★	★
		16ER14UN	14	9,525	1,2	1,0	3,52	4,0	60°						★	★
		16ER16UN	16	9,525	1,1	0,9	3,52	4,0	60°						★	★
		16ER18UN	18	9,525	1,1	0,8	3,52	4,0	60°						★	★
		16ER20UN	20	9,525	1,1	0,8	3,52	4,0	60°						★	★

★ Recommended grade ☆ Available grade

### BSPT

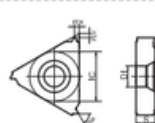


Working condition: ● Stable ● Average □ Tough

Workpiece material	P	M	K	N	S
Steel	●	●	●	●	●
Stainless steel	●	●	●	●	●
Cast iron	●	●	●	●	●
Non-ferrous metal	●	●	●	●	●
Heat resistant super alloys	●	●	●	●	●
Titanium alloy	●	●	●	●	●

Processing	Insert shape	Type	Pitch/ number of teeth	Dimension (mm)							CVD				PVD	
				IC	PDX	PDY	S	DI	PNA	H58225	H58123	H58133	H56115	H57125	H57225	H55125
External threading		16ER11BSPT	11	9,525	1,5	1,1	3,52	4,0	55°						★	★
		16ER14BSPT	14	9,525	1,2	1,0	3,52	4,0	55°						★	★
		16ER19BSPT	19	9,525	0,9	0,8	3,52	4,0	55°						★	★

★ Recommended grade ☆ Available grade



Working condition: ● Stable ● Average □ Tough

Workpiece material	P	M	K	N	S
Steel	●	●	●	●	●
Stainless steel	●	●	●	●	●
Cast iron	●	●	●	●	●
Non-ferrous metal	●	●	●	●	●
Heat resistant super alloys	●	●	●	●	●
Titanium alloy	●	●	●	●	●

Processing	Insert shape	Type	Pitch/ number of teeth	Dimension (mm)							CVD				PVD	
				IC	PDX	PDY	S	DI	PNA	H58225	H58123	H58133	H56115	H57125	H57225	H55125
Internal threading		16R11BSPT	11	9,525	1,5	1,1	3,52	4,0	55°						★	★
		16R14BSPT	14	9,525	1,2	1,0	3,52	4,0	55°						★	★
		16R19BSPT	19	9,525	0,9	0,8	3,52	4,0	55°						★	★

★ Recommended grade ☆ Available grade

