

Enco Introduction to Carbide Threading System Nomenclature

CHOOSING INSERTS

1. Inserts which have the number 16 listed in the model number can only be used with tool holders that have the number 16 at the end of the tool holder's model number.
2. If the insert model number contains the letters ER (external right hand) which is the thread cutting method, the tool holder model number must include those letters in order to accept the inserts. Example Threading inserts 16 ER A60 P25C can be used with any of the tool holders listed below. Threading tool holders: SER 0500 F16, SER 1000 M16, SER 0750 K16, SER 1250 P16

CHOOSING TOOL HOLDERS

Example
Tool Holder: SER 0500 F16
Based on the thread profile which the customer would determine, the insert would be a 16 ER + thread + grade (e.g. 16 ER + A60 + P25C = 16 ER A60 P25C). Spare parts for the tool holders are based on the last two numbers of the tool holder's model number. For tool holder SER 0500F16, spare parts ending with the number 16 will fit that holder. Examples: S16 - Screw, A16 - Anvil Screw, K16 - Wrench, AE16+4.5 - Anvil Screw

INSERT ORDERING CODE

16

06	5/32
08	3/16
11	1/4
16	3/8
22	1/2
27	5/8
22 U	1/2 U
27 U	5/8 U

E = External
I = Internal

R = Right hand
L = Left hand

E R

PARTIAL PROFILES			
TYPE	L	PITCH RANGE	
		(mm)	TPI
A	11	0.5 - 1.5	48 - 16
A	16	0.5 - 1.5	48 - 16
AG		0.5 - 3	48 - 8
G		1.75 - 3	14 - 8
N	22	3.5 - 5	7 - 5
U		5.5 - 8	4.5 - 3.25
Q	27	5.5 - 6	4.5 - 5
U		6.5 - 9	4 - 2.75
V		6 - 10	4 - 2.5

60 = 60° Profiles
55 = 55° Profiles

FULL PROFILES THREAD STANDARDS	
ISO (Metric)	
UN (American un)	
W (BSW British Std)	
NPT (American Pipe Thread)	
BSPT (British Pipe Thread)	
Acme and Stub Acme	
TR (Trapez To Din 103)	
UNJ (Aviation)	
AM - BUT (American Buttress)	
RND (Round to Din 405)	
API (Oil Threads)	
API Round	
API Buttress Casing	
VAM	
Extreme Line Casing	
H 90	

UN

CARBIDE GRADES	
PLAIN	COATED
P 10	P 25 C
P 15	
P 30	
K 20	
	M 2 CT
	T 20
	MICROGRAIN
M X	M X C

Multitooth
Style & No.
of Teeth
API Size
& Taper

12

FULL PROFILES PITCH RANGE			
mm		TPI	
0.35 - 12		72 - 2	

TOOLHOLDERS ORDERING CODE

S

CLAMPING METHOD

S = Screw

E

E = External
I = Internal

R

R = Right hand
L = Left hand

2020

CROSS SECTION	
EXTERNAL TOOLHOLDERS	
SQUARE SHANK:	
Metric: 2020 = 20 mm x 20 mm	
Inch: 2020 = 1.5 x 1.5"	
INTERNAL TOOLHOLDERS	
ROUND SHANK:	
Metric: 0025 = Diameter 25 mm	
Inch: 0750 = Diameter 0.75"	

K

LENGTH OF TOOLHOLDER	
mm	Inch
D = 60	2.5
F = 80	3.25
H = 100	4.0
K = 125	5.0
L = 140	5.5
M = 150	6.0
P = 170	7.0
R = 200	8.0
S = 250	10.0
T = 300	12.0
U = 350	14.0
V = 400	16.0

16

POCKET SIZE	
L (mm)	IC (INCH)
11	1/4
16	3/8
22	1/2
27	5/8
22 U	1/2 U
27 U	5/8 U

B

B = Bore For Coolant

C = Carbide Shank

O = Offset Style

A = API (OIL)

E = On Edge (Vertical)

SPARE PARTS ORDERING CODE

INSERT SIZE	INSERT SCREW	ANVIL SCREW	TORX KEY	ANVIL	
				RH	LH
11 (1/4)	S 11		K 11		
16 (3/8)	S16	A16	K16	AE16	AI16
	I16	A16	K16	AI16	AE16
22 (1/2)	S22	A22	K22	AE22	A122
	I22	A22	K22	AI22	AE22
22 U	S22	A22	K22	AE22U	AI22U
	I22	A22	K22	AI22U	AE22U
27 (5/8)	S27	A27	K27	AE27	AI27
	I27	A27	K27	AI27	AE27
27 U	S27	A27	K27	AE27U	AI27U
	I27	A27	K27	AI27U	AE27U