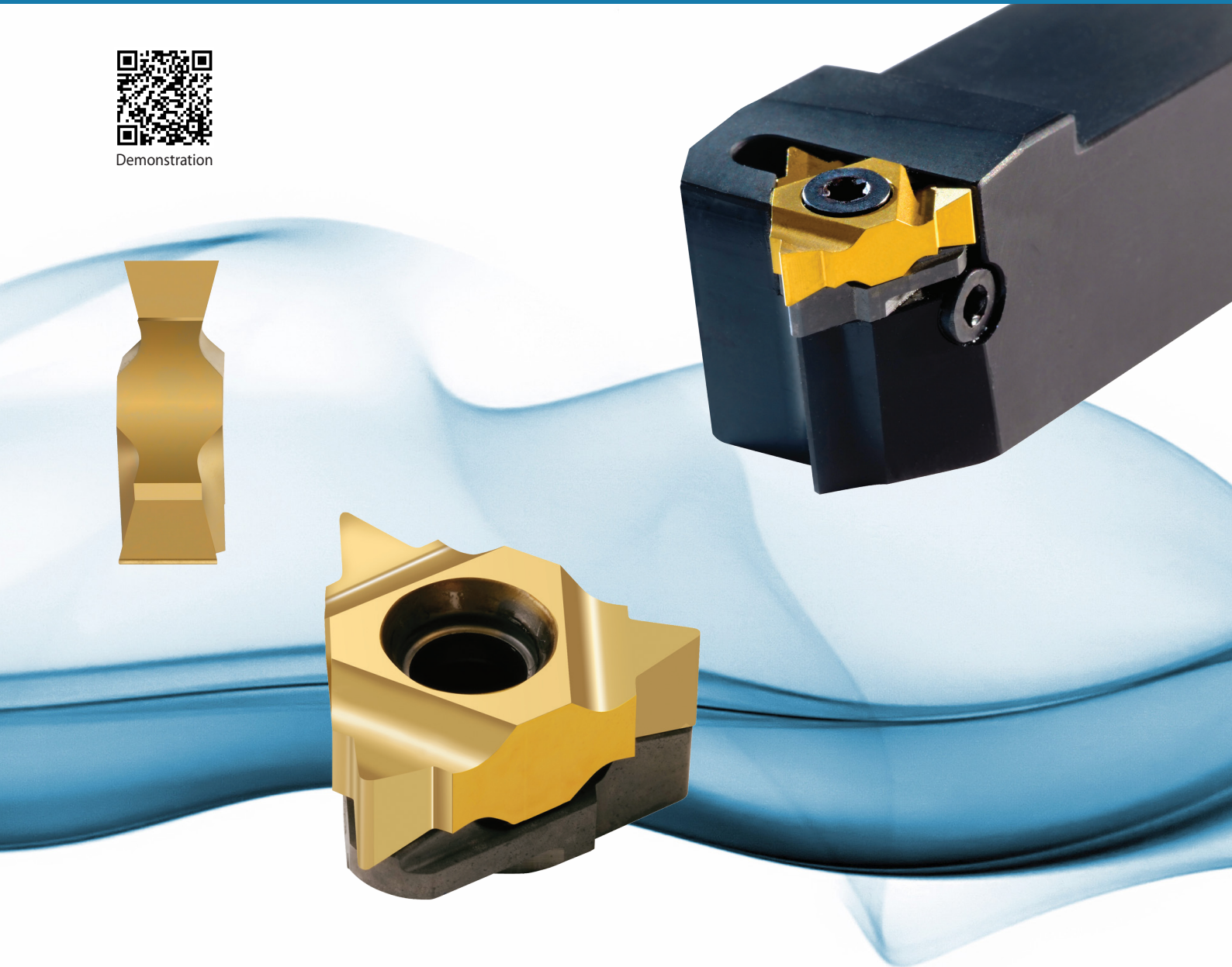




Demonstration



**A unique line of 2 sided inserts including 6 cutting edges, a cost saving tool.**

## Advantages of DSI-Thread Turning Inserts

- Increased productivity thanks to the six cutting edges.
- U-Style inserts for a wide range of full or partial profile standard threads.
- Same insert for right hand or left hand thread.
- Saving on tooling costs.
- Unique anti-vibration anvil designed for clamping the insert and supporting the cutting edge.
- Simple insert's mounting and cutting edge indexing.
- Heavy duty toolholders designed specially for this line.

### Contents:

### Page:

Product Identification  
Partial Profile 60°  
Partial Profile 55°  
ISO  
UN

2  
3  
3  
4  
4

### Contents:

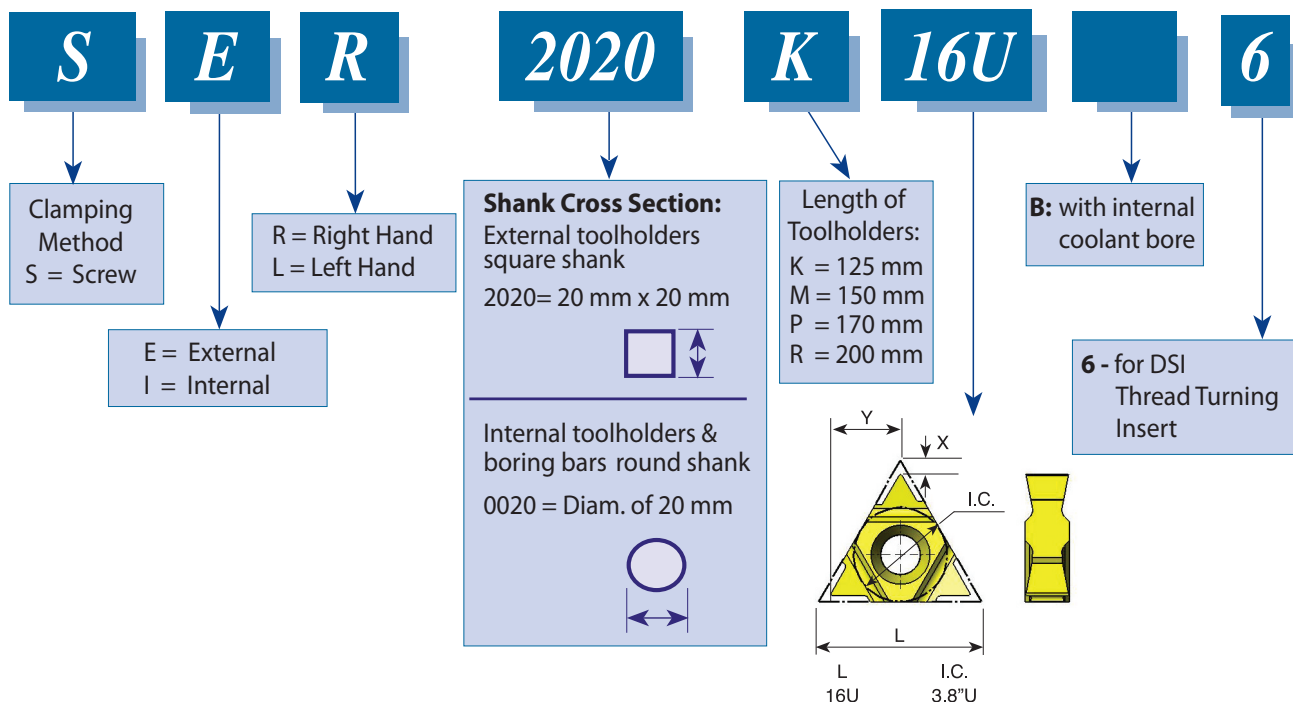
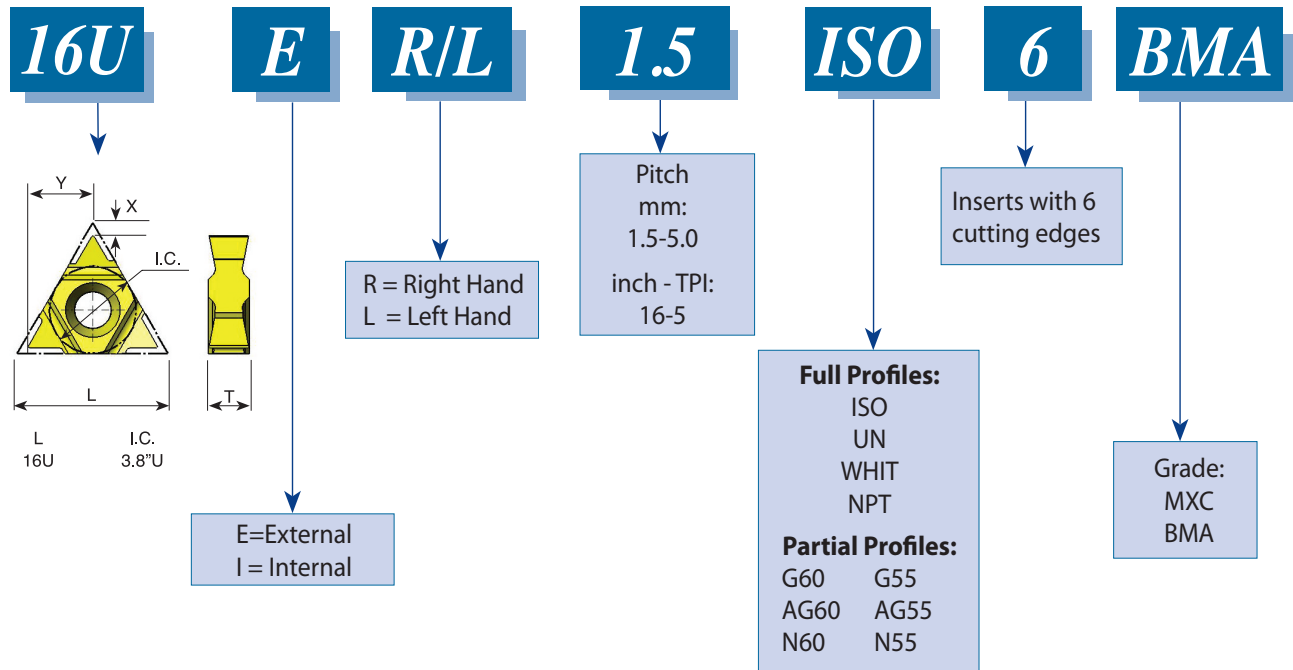
### Page:

Whitworth 55°  
NPT  
Heavy Duty Thread Turning Toolholders - External  
Heavy Duty Thread Turning Toolholders - Internal

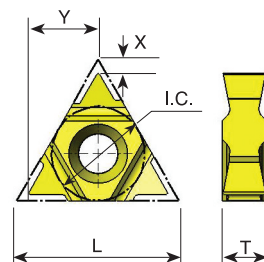
5  
5  
6  
6

## Product Identification

### DSI Ordering Code



## Partial Profile 60°

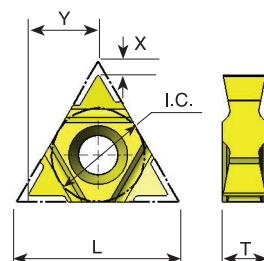


| Pitch Range mm | Pitch Range TPI | L   | I.C. in | <b>EXTERNAL</b><br>Ordering Code | <b>INTERNAL</b><br>Ordering Code | X   | Y   | T   |
|----------------|-----------------|-----|---------|----------------------------------|----------------------------------|-----|-----|-----|
| 1.75 - 3.0     | 14-8            | 16U | 3/8U    | <b>16U ER/L G60-6</b>            | <b>16U IR/L G60-6</b>            | 1.4 | 7.1 | 4.5 |
| 0.5 - 3.0      | 48-8            | 16U | 3/8U    | <b>16U ER/L AG60-6</b>           | <b>16U IR/L AG60-6</b>           | 1.4 | 7.1 | 4.5 |
| 3.5 - 5.0      | 7-5             | 16U | 3/8U    | <b>16U ER/L N60-6</b>            | <b>16U IR/L N60-6</b>            | 1.2 | 7.3 | 4.5 |

Available grades: BMA or MXC

Order example: 16U ER/L G60-6 BMA

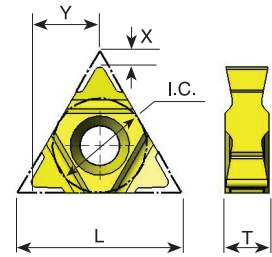
## Partial Profile 55°



| Pitch Range mm | Pitch Range TPI | L   | I.C. in | <b>EXTERNAL</b><br>Ordering Code | <b>INTERNAL</b><br>Ordering Code | X   | Y   | T   |
|----------------|-----------------|-----|---------|----------------------------------|----------------------------------|-----|-----|-----|
| 1.75 - 3.0     | 14-8            | 16U | 3/8U    | <b>16U ER/L G55-6</b>            | <b>16U IR/L G55-6</b>            | 1.4 | 7.1 | 4.5 |
| 0.5 - 3.0      | 48-8            | 16U | 3/8U    | <b>16U ER/L AG55-6</b>           | <b>16U IR/L AG55-6</b>           | 1.4 | 7.1 | 4.5 |
| 3.5 - 5.0      | 7-5             | 16U | 3/8U    | <b>16U ER/L N55-6</b>            | <b>16U IR/L N55-6</b>            | 1.2 | 7.3 | 4.5 |

Available grades: BMA or MXC

## ISO

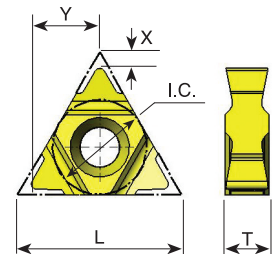


| Pitch<br>mm | L   | I.C.<br>in | <b>EXTERNAL</b><br>Ordering Code | <b>INTERNAL</b><br>Ordering Code | X   | Y   | T   |
|-------------|-----|------------|----------------------------------|----------------------------------|-----|-----|-----|
| 1.5         | 16U | 3/8U       | <b>16U ER/L 1.5 ISO-6</b>        | <b>16U IR/L 1.5 ISO-6</b>        | 1.6 | 6.9 | 4.5 |
| 1.75        | 16U | 3/8U       | <b>16U ER/L 1.75 ISO-6</b>       | <b>16U IR/L 1.75 ISO-6</b>       | 1.6 | 6.9 | 4.5 |
| 2.0         | 16U | 3/8U       | <b>16U ER/L 2.0 ISO-6</b>        | <b>16U IR/L 2.0 ISO-6</b>        | 1.6 | 6.9 | 4.5 |
| 2.5         | 16U | 3/8U       | <b>16U ER/L 2.5 ISO-6</b>        | <b>16U IR/L 2.5 ISO-6</b>        | 1.6 | 6.9 | 4.5 |
| 3.0         | 16U | 3/8U       | <b>16U ER/L 3.0 ISO-6</b>        | <b>16U IR/L 3.0 ISO-6</b>        | 1.6 | 6.9 | 4.5 |
| 3.5         | 16U | 3/8U       | <b>16U ER/L 3.5 ISO-6</b>        | <b>16U IR/L 3.5 ISO-6</b>        | 1.6 | 6.9 | 4.5 |
| 4.0         | 16U | 3/8U       | <b>16U ER/L 4.0 ISO-6</b>        | <b>16U IR/L 4.0 ISO-6</b>        | 1.6 | 6.9 | 4.5 |
| 4.5         | 16U | 3/8U       | <b>16U ER/L 4.5 ISO-6</b>        | <b>16U IR/L 4.5 ISO-6</b>        | 1.6 | 6.9 | 4.5 |
| 5.0         | 16U | 3/8U       | <b>16U ER/L 5.0 ISO-6</b>        | <b>16U IR/L 5.0 ISO-6</b>        | 1.6 | 6.9 | 4.5 |

Available grades: BMA or MXC

Order example: 16U ER/L 1.75 ISO-6 BMA

## UN - Unified **UNC, UNF, UNEF, UNS**

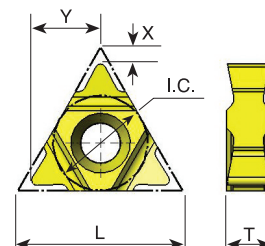


| Pitch<br>TPI | L   | I.C.<br>in | <b>EXTERNAL</b><br>Ordering Code | <b>INTERNAL</b><br>Ordering Code | X   | Y   | T   |
|--------------|-----|------------|----------------------------------|----------------------------------|-----|-----|-----|
| 16           | 16U | 3/8U       | <b>16U ER/L 16 UN-6</b>          | <b>16U IR/L 16 UN-6</b>          | 1.6 | 6.9 | 4.5 |
| 14           | 16U | 3/8U       | <b>16U ER/L 14 UN-6</b>          | <b>16U IR/L 14 UN-6</b>          | 1.6 | 6.9 | 4.5 |
| 13           | 16U | 3/8U       | <b>16U ER/L 13 UN-6</b>          | <b>16U IR/L 13 UN-6</b>          | 1.6 | 6.9 | 4.5 |
| 12           | 16U | 3/8U       | <b>16U ER/L 12 UN-6</b>          | <b>16U IR/L 12 UN-6</b>          | 1.6 | 6.9 | 4.5 |
| 11.5         | 16U | 3/8U       | <b>16U ER/L 11.5 UN-6</b>        | <b>16U IR/L 11.5 UN-6</b>        | 1.6 | 6.9 | 4.5 |
| 11           | 16U | 3/8U       | <b>16U ER/L 11 UN-6</b>          | <b>16U IR/L 11 UN-6</b>          | 1.6 | 6.9 | 4.5 |
| 10           | 16U | 3/8U       | <b>16U ER/L 10 UN-6</b>          | <b>16U IR/L 10 UN-6</b>          | 1.6 | 6.9 | 4.5 |
| 9            | 16U | 3/8U       | <b>16U ER/L 9 UN-6</b>           | <b>16U IR/L 9 UN-6</b>           | 1.6 | 6.9 | 4.5 |
| 8            | 16U | 3/8U       | <b>16U ER/L 8 UN-6</b>           | <b>16U IR/L 8 UN-6</b>           | 1.6 | 6.9 | 4.5 |
| 7            | 16U | 3/8U       | <b>16U ER/L 7 UN-6</b>           | <b>16U IR/L 7 UN-6</b>           | 1.6 | 6.9 | 4.5 |
| 6            | 16U | 3/8U       | <b>16U ER/L 6 UN-6</b>           | <b>16U IR/L 6 UN-6</b>           | 1.6 | 6.9 | 4.5 |
| 5            | 16U | 3/8U       | <b>16U ER/L 5 UN-6</b>           | <b>16U IR/L 5 UN-6</b>           | 1.6 | 6.9 | 4.5 |

Available grades: BMA or MXC

For carbide grade and cutting speed see page A04-2 and 3

## Whitworth 55° BSW, BSF, BSP, BSB

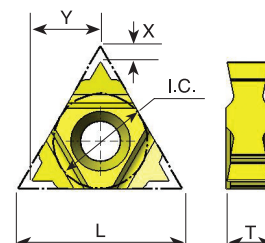


| Pitch<br>TPI | L   | I.C.<br>in | <b>EXTERNAL</b><br>Ordering Code | <b>INTERNAL</b><br>Ordering Code | X   | Y   | T   |
|--------------|-----|------------|----------------------------------|----------------------------------|-----|-----|-----|
| 16           | 16U | 3/8U       | 16U ER/L 16 W-6                  | 16U IR/L 16 W-6                  | 1.6 | 6.9 | 4.5 |
| 14           | 16U | 3/8U       | 16U ER/L 14 W-6                  | 16U IR/L 14 W-6                  | 1.6 | 6.9 | 4.5 |
| 12           | 16U | 3/8U       | 16U ER/L 12 W-6                  | 16U IR/L 12 W-6                  | 1.6 | 6.9 | 4.5 |
| 11           | 16U | 3/8U       | 16U ER/L 11 W-6                  | 16U IR/L 11 W-6                  | 1.6 | 6.9 | 4.5 |
| 10           | 16U | 3/8U       | 16U ER/L 10 W-6                  | 16U IR/L 10 W-6                  | 1.6 | 6.9 | 4.5 |
| 9            | 16U | 3/8U       | 16U ER/L 9 W-6                   | 16U IR/L 9 W-6                   | 1.6 | 6.9 | 4.5 |
| 8            | 16U | 3/8U       | 16U ER/L 8 W-6                   | 16U IR/L 8 W-6                   | 1.6 | 6.9 | 4.5 |
| 7            | 16U | 3/8U       | 16U ER/L 7 W-6                   | 16U IR/L 7 W-6                   | 1.6 | 6.9 | 4.5 |
| 6            | 16U | 3/8U       | 16U ER/L 6 W-6                   | 16U IR/L 6 W-6                   | 1.6 | 6.9 | 4.5 |
| 5            | 16U | 3/8U       | 16U ER/L 5 W-6                   | 16U IR/L 5 W-6                   | 1.4 | 7.2 | 4.5 |

Available grades: BMA or MXC

Order example: 16U ER/L 9 W-6 BMA

## NPT

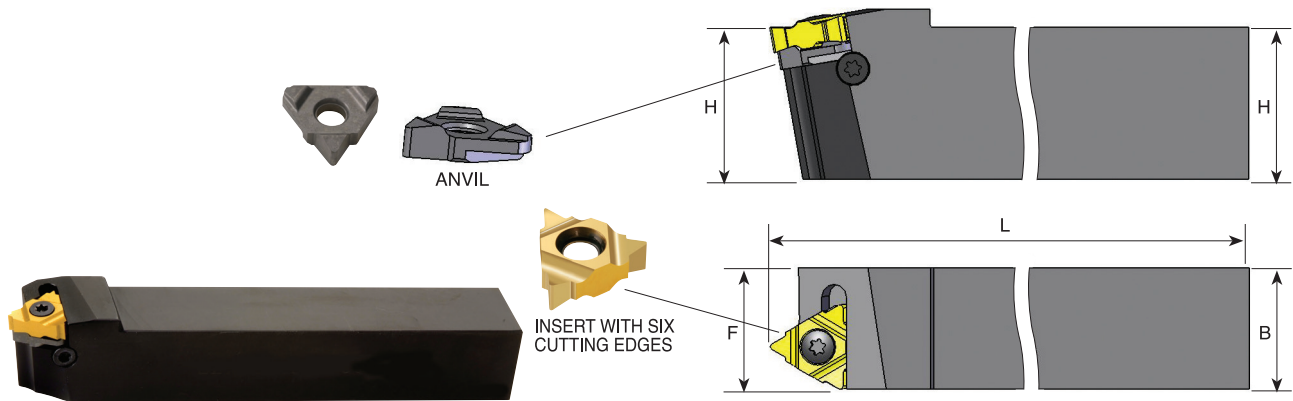


| Pitch<br>TPI | L   | I.C.<br>in | <b>EXTERNAL</b><br>Ordering Code | <b>INTERNAL</b><br>Ordering Code | X   | Y   | T   |
|--------------|-----|------------|----------------------------------|----------------------------------|-----|-----|-----|
| 14           | 16U | 3/8U       | 16U ER/L 14 NPT-6                | 16U IR/L 14 NPT-6                | 1.6 | 6.9 | 4.5 |
| 11.5         | 16U | 3/8U       | 16U ER/L 11.5 NPT-6              | 16U IR/L 11.5 NPT-6              | 1.6 | 6.9 | 4.5 |
| 8            | 16U | 3/8U       | 16U ER/L 8 NPT-6                 | 16U IR/L 8 NPT-6                 | 1.6 | 6.9 | 4.5 |

Available grades: BMA or MXC

## Heavy Duty Thread Turning Toolholders

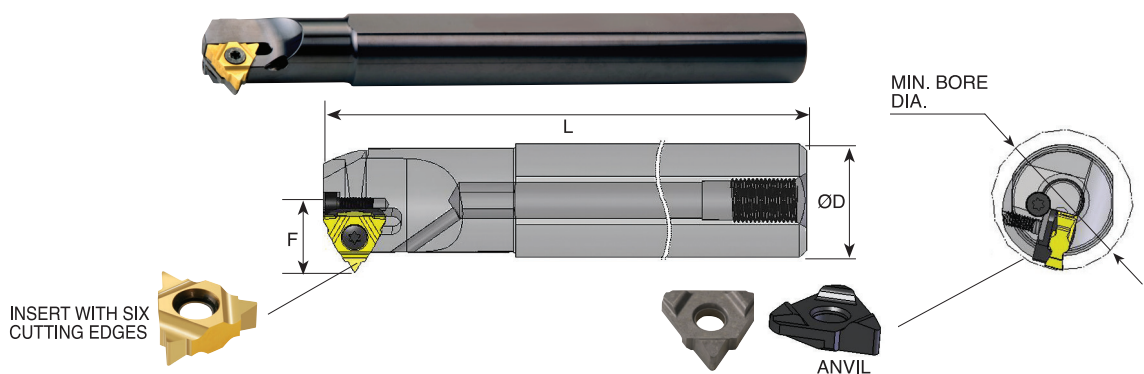
### External



| Ordering Code<br>Right Hand | H  | B  | L   | F  | Insert<br>Screw | Anvil<br>Screw | Torx<br>Key | RH<br>Anvil | LH<br>Anvil |
|-----------------------------|----|----|-----|----|-----------------|----------------|-------------|-------------|-------------|
| <b>SER 2020 K16U-6</b>      | 20 | 20 | 125 | 20 | S16             | A16            | K16         | AER 16U-6   | AEL 16U-6   |
| <b>SER 2520 M16U-6</b>      | 25 | 20 | 150 | 20 | S16             | A16            | K16         | AER 16U-6   | AEL 16U-6   |

For **LEFT HAND** toolholders specify **SEL** instead of **SER**

### Internal with coolant bore



| Ordering Code<br>Right Hand | ØD | Min.<br>bore dia. | L   | F    | Insert<br>Screw | Anvil<br>Screw | Torx<br>Key | RH<br>Anvil | LH<br>Anvil |
|-----------------------------|----|-------------------|-----|------|-----------------|----------------|-------------|-------------|-------------|
| <b>SIR 0020 P16UB-6</b>     | 20 | 24                | 170 | 14.9 | S16             | A16            | K16         | AIR 16U-6   | AIL 16U-6   |
| <b>SIR 0025 R16UB-6</b>     | 25 | 29                | 200 | 17.4 | S16             | A16            | K16         | AIR 16U-6   | AIL 16U-6   |

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**