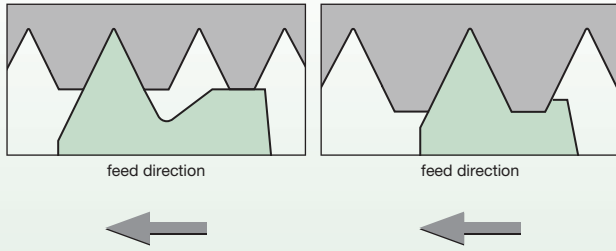


60° V-Thread Crest Turning Application Data



NTC crest turning insert for ( $P \leq 2\text{mm}$ ) and finer.

NTC crest turning insert for ( $P \geq 3\text{mm}$ ) and coarser.

NOTE: NTC inserts automatically control root to crest dimensions. Therefore, in setting up threading operations with NTC inserts, check the O.D. or I.D. at the thread crest for correct dimensions.

60° V-Thread Crest Turning Application Data

insert catalogue number	nose radius on insert (mm)	thread radius per MIL-S-8879A (mm)
NJ-3014R/L12	0,317/0,342	0,317/0,381
NJK-3008R/L20	0,190/0,215	0,190/0,0228

“J” thread note for catalogue

The controlled root radius thread form (SAE8879C) is defined for the external thread only. To machine the corresponding internal thread, choose any insert that will cut a unified class 2B thread, then bore the minor diameter to size. Refer to SAE8879C and MIL-S-8879C and SAEAS8879D for the correct “J” thread minor diameter values.

60° V-Thread Application Data

insert description	insert	D (mm)	E (mm)	recommended TPI*		recommended TP*	
				external	internal	external	internal
<p>NT-NTP-</p>	NT-1	1,90	1,11	-	24-12	-	1,00-2,00
	NT-2	28,70	1,90	36-8	20-7	0,70-3,00	1,25-3,50
	NT-2-K	28,70	1,90	36-8	20-7	0,70-3,00	1,25-3,50
	NTF-2	15,75	1,01	44-14	24-12	0,60-1,75	1,00-2,00
	NTK-2	15,75	1,01	44-14	24-12	0,60-1,75	1,00-2,00
	NTP-2	28,70	1,90	36-8	20-7	0,70-3,0	1,25-3,50
	NT-3	37,59	2,46	20-6	12-5	1,25-4,00	2,00-5,00
	NT-3-K	37,59	2,46	20-6	12-5	1,25-4,00	2,00-5,00
	NT-3-C	37,59	2,46	11-6	6 (only)	2,50-4,00	4,00 (only)
	NT-3-CK	37,59	2,46	11-6	6 (only)	2,50-4,00	4,00 (only)
<p>NTF-NTK-</p>	NTF-3	21,08	1,37	44-10	24-9	0,60-2,50	1,00-2,50
	NTK-3	21,08	1,37	44-10	24-9	0,60-2,50	1,00-2,50
	NTP-3	37,59	2,46	20-6	12-5	1,25-4,00	2,00-5,00
	NT-4	49,78	3,22	20-4	12-4	1,25-6,25	2,00-6,25
	NT-4-K	49,78	3,22	20-4	12-4	1,25-6,25	2,00-6,25
	NT-4-C	49,78	3,22	11-4 1/2	6-4 1/2	2,50-5,50	4,00-5,50
	NT-4-CK	49,78	3,22	11-4 1/2	6-4 1/2	2,50-5,50	4,00-5,50
	NTF-4	21,08	1,37	44-10	24-9	0,60-2,50	1,00-2,50
	NTK-4	21,08	1,37	44-10	24-9	0,60-2,50	1,00-2,50
	NTP-4	49,78	3,22	20-4	12-4	1,25-6,25	2,00-6,25

\*Based on maximum insert radius size and class 2A and 2B thread specifications.