

THREADING • THREADING INSERTS

ISO metric 60° threading inserts

Full-profile inserts for ISO 60° metric threads: crest and root formed by the insert, finished thread without deburring.



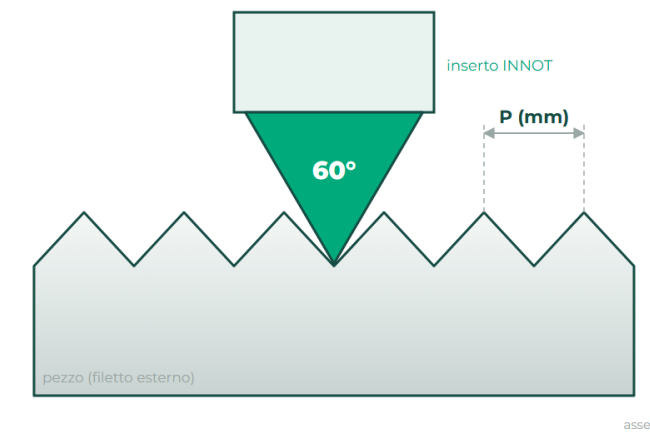
KEY DATA

Product type	Turning Inserts
ISO materials	P steel M stainless S superalloys
Operation	Special
INNOT grades	IT5125 · IT5225 ★ ★ recommended
Online page	innot-it.com/en/prodotto/filettatura-iso-metrica-60

Profile

Inserti filettatura ISO metrica 60°

Profilo completo per filetti metrici M



60°

passo 0,5 – 6 mm

esterni e interni

destri e sinistri

INNOT

Range

Profile	60°
Pitch range	pitch 0.5 – 6 mm
Type	External (E) and internal (I), right-hand (R) and left-hand (L)

Insert size	Inscribed circle 6.35 (11), 9.525 (16) and 12.70 mm (22); 3.97 and 4.76 mm for small internal bores
Construction	Sintered with chipbreaker, or precision ground (P) for tight tolerances and finish
Typical application	General engineering: screws, pins, shafts and metric nuts.

Main dimensions

Type	IC mm (size)	Pitches	Thickness S mm
External	9,525 (16)	1.00 – 3.00 mm	3,52
External	12,70 (22)	3.50 – 6.00 mm	4,65
Internal	9,525 (16)	1.00 – 3.00 mm	3,52
Internal small bores (ground)	3,97 (06)	0.50 – 1.25 mm	1,91
Internal small bores (ground)	4,76 (08)	0.75 – 1.50 mm	2,38

Each pitch has its own full-profile insert. Tell us thread, diameter and external/internal: we give you the exact code.

Available INNOT grades

Grade	ISO	Coating	Composition	Application
IT5225 ★	P · M · S	PVD	Multilayer PVD	First-choice grade for threading: steels, stainless steels and superalloys, excellent resistance to profile wear.
IT5125	P · M · S	PVD	Multilayer PVD	Tough grade for threading in unstable conditions and interrupted cuts on steels, stainless steels and superalloys.

★ Recommended grade. On request also CVD grades for steels and cast irons, uncoated carbide for aluminium and cermet for finishing.

Consigli d'uso

- Decreasing depth of cut: lighter passes as you approach the thread root.
- Flank infeed (modified infeed at 3-5° on the flank) for better chip control and longer insert life.
- Scegliere lo spessorino in base all'angolo dell'elica del filetto: fianchi che non strisciano e profilo corretto.

INNOT · CUTTING TOOLS FOR CNC MACHINE SHOPS

Quote within 30 minutes

Send us the code or the drawing: we reply with price and availability. Free test inserts on request, 24/48h shipping.

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Scan to open the online page

Cutting data are indicative starting values: adjust them to machine, clamping, tool overhang and workpiece material. Data and images may change without notice.