



Octicut® Threading

Octicut®
Threading

Ranger™
Face Grooving

Chipmaker®
O.D. & I.D. Grooving

Separator®
Cutoff

MTC™
Cutoff & Grooving

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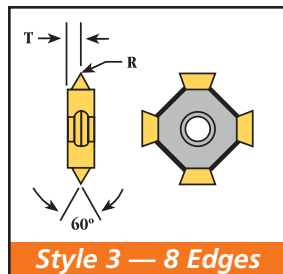
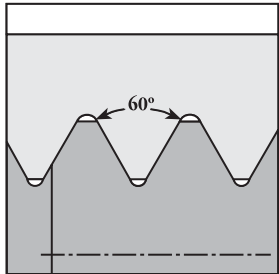
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OCTICUT® THREADING INSERTS

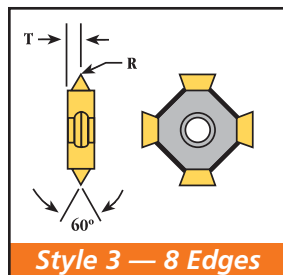
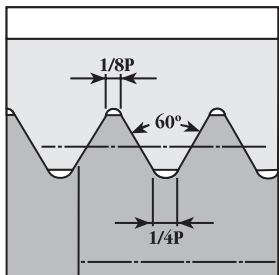


60° Partial Profile – External/Internal **INCH**

Pitch TPI	Pitch MM	MTC No.	IC	Dimensions		
				T	R	Style
32-8	.75-3 ISO	570-226	7/16	0.078	0.003	3
14-8	1.75-3 ISO	570-228	7/16	0.078	0.007	3

Octicut® Threading Inserts are available in TiN (M40), TiCN (M45), TiN (M50) and TiAlN (M93).

NOTE: Neutral shown. A separate operation is required to finish correct major/minor diameter.



60° UN – External Full Profile **INCH**

Left Hand MTC No.	Pitch TPI	IC	Dimensions			Right Hand MTC No.
			T	R	Style	
570-290	32	7/16	0.016	0.004	3	570-170
570-288	28	7/16	0.024	0.004	3	570-168
570-145	24	7/16	0.036	0.005	3	570-166
570-144	20	7/16	0.029	0.006	3	570-163
570-182	18	7/16	0.050	0.007	3	570-160
570-143	16	7/16	0.047	0.008	3	570-157
570-142	14	7/16	0.042	0.009	3	570-154
570-280	13	7/16	0.040	0.009	3	570-152

60° UN – External Full Profile – Neutral **INCH**

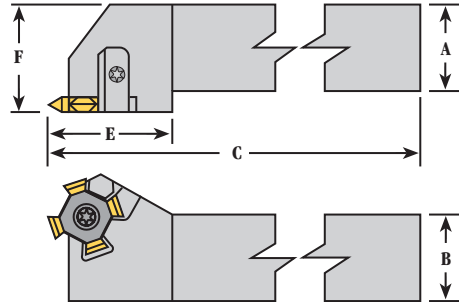
Pitch TPI	MTC No.	IC	Dimensions		
			T	R	Style
12	570-180	7/16	0.078	0.010	3

Octicut® Threading Inserts are available in TiN (M40), TiCN (M45), TiN (M50) and TiAlN (M93).

NOTE: Neutral insert shown.

EXTERNAL TOOLHOLDERS

Miniature Series External Threading Fixed Pocket With Clamp



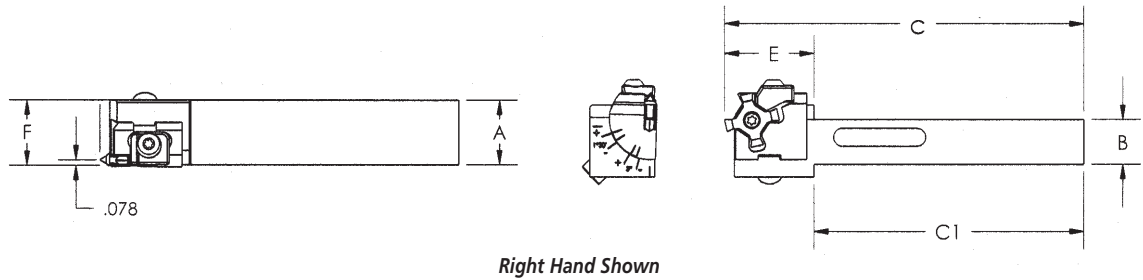
Right Hand Shown

Miniature Series External Threading Fixed Pocket with Clamp								INCH
Left Hand MTC No.	Helix Angle	A	B	Basic Dimensions		Insert Style	Right Hand MTC No.	
				C	E	F		
245-107	+2°	3/8	3/8	4.000	0.780	0.500	3	245-110
245-108	+2°	1/2	1/2	5.000	0.780	0.625	3	245-111
245-109	+2°	5/8	5/8	5.000	0.780	0.750	3	245-112

NOTE: Holder supplied complete with hardware, less insert.
See page E2 for inserts.

Replacement Hardware				INCH
Insert Screw	Clamp	Clamp Screw	Wrench	
644-107	444-103	644-101	644-110	

ADJUSTABLE HELIX THREADING SYSTEM



Right Hand Shown

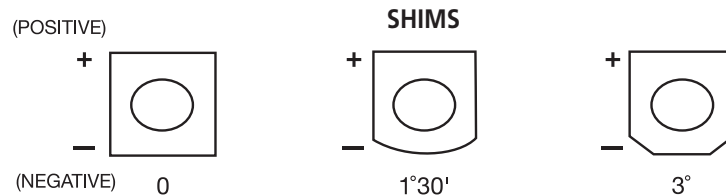
Square Shank							INCH
Left Hand Part No.	A	B	C	C1	E	F	Right Hand Part No.
248-104	0.90	0.75	5	3.74	1.26	0.91	248-103
248-106	0.99	1	6	—	1.26	1	248-105

Square Shank							METRIC
Left Hand Part No.	A	B	C	C1	E	F	Right Hand Part No.
248-204	22.8	20	125	92.9	32	23	248-203
248-206	23.8	25	150	—	32	24	248-205

Cartridges are supplied with shims to lock in the helix setting required. Shim #615-139. See page E2 for inserts.

Adjustable Helix Cartridge		INCH / METRIC
Left Hand Part No.	Insert Style	Right Hand Part No.
345-151	3	345-150

Cartridges can be used with inch or metric holders and inch or metric inserts. Cartridges are supplied with shims to lock in the helix setting required. Shim #615-139. See page F8 for Helix Angle Chart and Technical Recommendations.



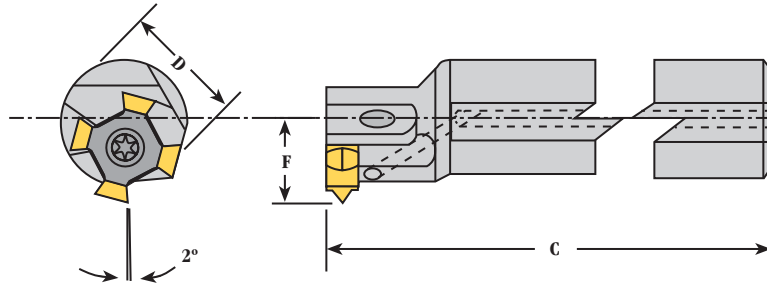
Replacement Hardware

INCH / METRIC

LH Clamp	Cartridge Screw	Clamp Screw	Insert Screw	RH Clamp
444-105	606-250	644-101	644-107	444-104

INTERNAL BARS

Internal Threading Fixed Pocket With Clamp



Left Hand Shown

Internal Threading Fixed Pocket with Clamp							INCH
Left Hand MTC No.	Helix Angle	D	Basic Dimensions			Insert Style	Right Hand MTC No.
			C	F	Min. Bore		
244-104	1.5°	0.750	7	0.510	0.950	3	244-106
244-105	1.5°	1.000	8	0.650	1.150	3	244-107

NOTE: Left Hand shown. Coolant port standard feature. Bar furnished complete, less insert. See page E2 for inserts.

Replacement Hardware

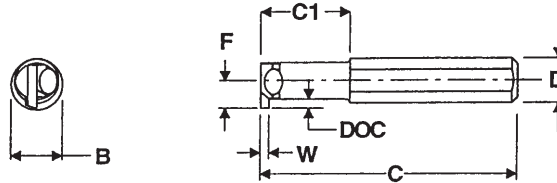
INCH

Insert Screw	Clamp	Clamp Screw	Wrench
644-107	444-103	644-101	644-110

I.D. THREADING

S-LOC™ Toolholders

S-LOC™ Inserts



Left Hand Shown

S-LOC™ Toolholders

INCH

Counter Clockwise Left Hand	Min. Enter Diameter B	C	C ₁	Bar Diameter D	F	Clockwise Right Hand
218-119	.560	6.0	1.0	.500	.312	218-119
218-121	.560	6.0	1.5	.625	.312	218-121
218-122	.780	6.0	0	.625	.419	218-123
218-124	.940	8.0	0	.750	.510	218-124

Replacement Hardware

INCH

Locking Clamp Screws

606-190

S-LOC™ Toolholders

METRIC

Counter Clockwise Left Hand	DOC (Max)*	Min. Enter Diameter B	C	C ₁	Bar Diameter D	F	Clockwise Right Hand
218-134	2.4	14.2	150	25	12	8	218-134
218-142	2.4	14.2	150	38	16	8	218-142
218-143	2.4	24.0	200	—	20	13	218-143

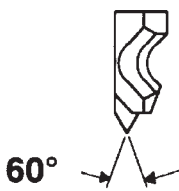
*Refer to insert table for specific DOC.

Replacement Hardware

METRIC

Locking Clamp Screws

606-193



Left Hand Shown



S-LOC™ Threading Inserts

INCH

Left Hand Insert	Description	Right Hand Insert
510-103*	Threading	510-106*

S-LOC™ Inserts are available in Uncoated (C2 & C5), TiN+TiC+TiN (GC) & TiN (M40).

* Minimum 10 threads per inch.