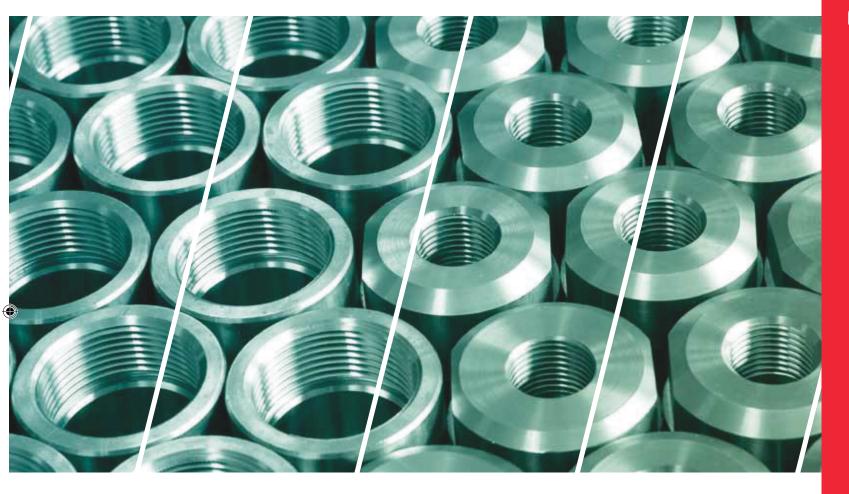
VEGA INTERNATIONAL TOOLS s.r.l.

Via Asti, 9 10026 Santena (TO) Tel. +39 011 94 97 911 Fax +39 011 94 56 380 www.vegaonline.net info@vegaonline.net







CATALOGUE

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POPULAR THREADFORM INSERTS • TOOLHOLDERS • SPARES





TOOLING FOR OIL & GAS · AUTOMOTIVE

AEROSPACE · GENERAL ENGINEERING





Posithread was estabilished in 1986 on the North East Coast of England. We have the capacity to mass produce standard and bespoke threading inserts within fine tolerances on very short lead times, whether it be large or small quantities.

Our threading knowledge encompasses over 30 years of application and production experience. This expertise, along side our first class products and Global Sales team, has allowed Posithread to develop a worldwide customer

We are the "Specials Specialists" and will be glad to take on the challenge of solving yout threading application problems with optimal solutions.



CONTENT	
THREADING AND TOOLHOLDERS	
Threading Nomenclature	1
X-Series	2-3
Partial Profile Thread Forming	4
Mechanical Thread Forms	5-7
Aerospace Thread Forms	8
Transmission Thread Forms	9-10
Miscellaneous Threading	10-11
Pipe Thread Forms	12
Buttress Thread Forms	13
Oilfield Thread Forms	14
Multi-Tooth Inserts	15
External Toolholders Laydown Style	16
Internal Toolholders Laydown Style	17-18
Anvil Selection for Laydown Style	19
Technical Information Helix Angle	20
Tooling Positions	21
Speeds & Feeds	22

sales@posithread.co.uk • www.posithread.eu

TECHNICAL

GRADES

- AlTiN coating
- Very good all round grade
- Increased tool life over PTC2 by up to 50%
- Heat resistance

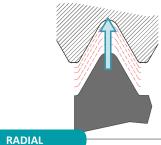
- TiSiN coating
- Developed for hard materials, high chrome steels and exotic materials.
- Heat resistance and oxidation resistance at cutting temperatures of over 1000°C

SPEEDS & FEEDS

	PTX	DBC
MATERIAL SPECIFICATION	METRES PER MINUTE	
1018 LOW CARBON STEEL	145/165 •	130/140
4140 (18-20 HRC) L80 EN19 EN24 EN34	145/155 ●	120/130
9% - 13% CHROME	115/125 ●	110/120
4140 (30-32 HRC)	90/110 •	90/105
4145 (36 HRC)	90/110 ●	85/102
T316-17-4PH	105/135 ●	85/115
410 STAINLESS	135/150 ●	115/128
25% CHROME	60/75	58/70 ●
SUPER 13% 95KSI	105/115	95/105 ●
INCONEL 625	35/40	32/38 ●
INCONEL 925	28/32	26/30 ●
INCONEL 718	29/33	28/32 ●
K MONEL	30/36	26/30 ●

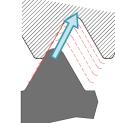
FIRST CHOICE FOR CHOSEN MATERIAL

INFEEDS





- Equal wear on leading & trailing edges.
- Use on work hardening materials.
- Use on short chipping materials.





- Reduced cutting pressure on larger pitches.
- Directs chips away from cutting edge.

FLANK

• Displaced in-feed angle improves surface





ALTERNATE FLANK

- Recommended for long chippng materials.
- Method divides the work between both
 - Less cutting pressure.



