

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

POSITHREAD

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CATALOGUE

POPULAR THREADFORM INSERTS • TOOLHOLDERS • SPARES

TOOLING FOR OIL & GAS • AUTOMOTIVE
AEROSPACE • GENERAL ENGINEERING

2020



POSITHREAD UK 4-5 BRIDGEWATER ROAD HERTBURN INDUSTRIAL ESTATE WASHINGTON TYNE & WEAR NE37 2SG ENGLAND
t: +44 (0)191 417 8178 f: +44 (0)191 415 3120 info@posithread.co.uk www.posithread.eu

POSITHREAD

VEGA
INTERNATIONAL
TOOLS

Posithread was established 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 base.

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



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GRADES

PTX
<ul style="list-style-type: none">• AlTiN coating• Very good all round grade• Increased tool life over PTC2 by up to 50%• Heat resistance
DBC
<ul style="list-style-type: none">• 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

RADIAL <ul style="list-style-type: none">• Equal wear on leading & trailing edges.• Use on work hardening materials.• Use on short chipping materials.	FLANK <ul style="list-style-type: none">• Reduced cutting pressure on larger pitches.• Directs chips away from cutting edge.• Displaced in-feed angle improves surface finish.	ALTERNATE FLANK <ul style="list-style-type: none">• Recommended for long chipping materials.• Method divides the work between both flanks.• Less cutting pressure.