vargus
NEUMO Ehrenberg Group

# V6

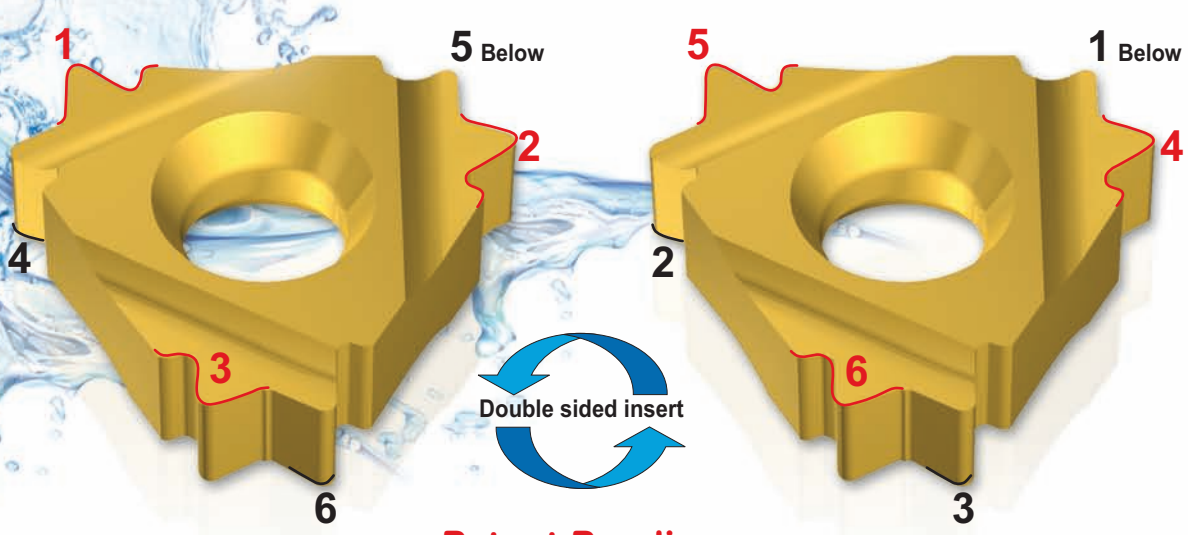
## 6 Cutting Corner Inserts



INCH

VARDEX
Advanced Threading Solutions

# A Revolutionary 6 Cutting Corner System




**Patent Pending**

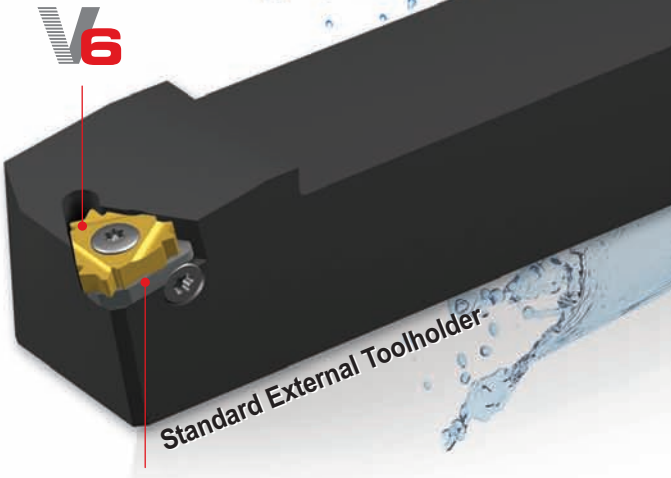
## Features:

- 6 Cutting corners
- Fits standard holders
- Economical insert for lower tooling costs
- Same application on all corners
- Doubles your tool life


Every box contains a V6 anvil

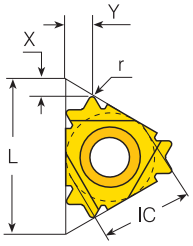

TT GEN software and updated versions can be downloaded from www.vargususa.com


V6 Internal Anvil

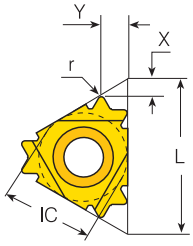



V6 External Anvil

# V6 Inserts

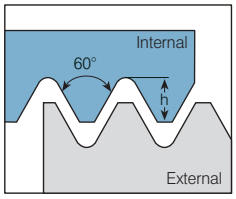



V6 External



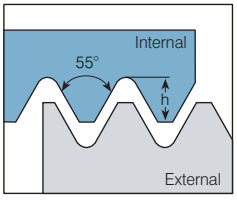

V6 Internal

## Partial 60°



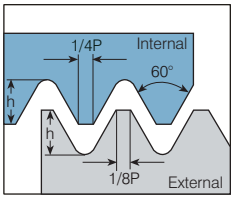

| | Insert Size | | Pitch | | Ordering Code | EDP No. | Dimensions [inch] | | | V6 Anvil | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | IC | L[inch] | mm | tpi | RH | VKX | r | X | Y | RH | Toolholder |
| **External** | 3/8" V6 | .63 | 0.5-2.0 | 48-13 | 3ERS60-6C… | 59528 | .002 | .08 | .12 | YE3-6C | AL..-3 |
| **Internal** | 3/8" V6 | .63 | 0.5-2.0 | 48-14 | 3IRS60-6C… | 59547 | .001 | .06 | .10 | YI3-6C | AVRC..-3<br>NVRC..-3V6 |

## Partial 55°




| | Insert Size | | Pitch | | Ordering Code | EDP No. | Dimensions [inch] | | | V6 Anvil | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | IC | L[inch] | mm | tpi | RH | VKX | r | X | Y | RH | Toolholder |
| **External** | 3/8" V6 | .63 | - | 48-14 | 3ERS55-6C… | 59529 | .002 | .07 | .11 | YE3-6C | AL..-3 |
| **Internal** | 3/8" V6 | .63 | - | 48-16 | 3IRS55-6C… | 59546 | .002 | .06 | .10 | YI3-6C | AVRC..-3<br>NVRC..-3V6 |

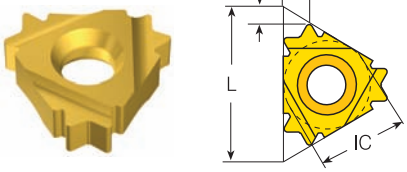
## ISO



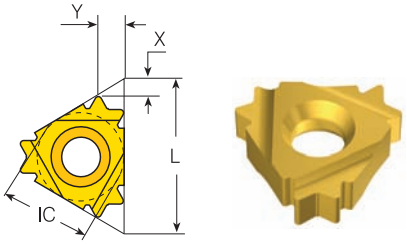

Defined by: R262 (DIN 13)
Tolerance class: 6g/6H

| | Insert Size | | Pitch | Ordering Code | EDP No. | Dimensions [inch] | | | V6 Anvil | |
|---|---|---|---|---|---|---|---|---|---|---|
| | IC | L[inch] | mm | RH | VKX | h min | X | Y | RH | Toolholder |
| **External** | 3/8" V6 | .63 | 0.5 | 3ER0.5ISO-6C… | 59522 | .012 | .09 | .07 | YE3-6C | AL..-3 |
| | | | 0.75 | 3ER0.75ISO-6C… | 59523 | .018 | .08 | .07 | | |
| | | | 0.8 | 3ER0.8ISO-6C… | 59524 | .019 | .08 | .08 | | |
| | | | 1.0 | 3ER1.0ISO-6C… | 59520 | .024 | .08 | .09 | | |
| | | | 1.25 | 3ER1.25ISO-6C… | 59525 | .030 | .07 | .09 | | |
| | | | 1.5 | 3ER1.5ISO-6C… | 59521 | .036 | .07 | .10 | | |
| | | | 1.75 | 3ER1.75ISO-6C… | 59526 | .042 | .07 | .10 | | |
| | | | 2.0 | 3ER2.0ISO-6C… | 59527 | .060 | .07 | .11 | | |
| **Internal** | 3/8" V6 | .63 | 0.5 | 3IR0.5ISO-6C… | 59564 | .011 | .08 | .07 | YI3-6C | AVRC..-3<br>NVRC..-3V6 |
| | | | 0.75 | 3IR0.75ISO-6C… | 59565 | .017 | .08 | .07 | | |
| | | | 0.8 | 3IR0.8ISO-6C… | 59566 | .018 | .07 | .07 | | |
| | | | 1.0 | 3IR1.0ISO-6C… | 59570 | .023 | .08 | .08 | | |
| | | | 1.25 | 3IR1.25ISO-6C… | 59567 | .028 | .07 | .07 | | |
| | | | 1.5 | 3IR1.5ISO-6C… | 59571 | .034 | .06 | .09 | | |
| | | | 1.75 | 3IR1.75ISO-6C… | 59568 | .040 | .06 | .09 | | |
| | | | 2.0 | 3IR2.0ISO-6C… | 59569 | .045 | .07 | .10 | | |

# V6 Inserts

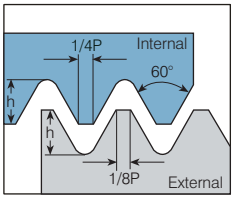



V6 External




V6 Internal

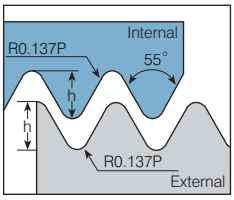
## UN




Defined by: ANSI B1.1.74
Tolerance class: 2A/2B

| | Insert Size | | Pitch | Ordering Code | EDP No. | Dimensions [inch] | | | V6 Anvil | |
|---|---|---|---|---|---|---|---|---|---|---|
| | IC | L [inch] | tpi | RH | VKX | h min | X | Y | RH | Toolholder |
| **External** | 3/8" V6 | .63 | 32 | 3ER32UN-6C... | 59530 | .019 | .08 | .08 | YE3-6C | AL..-3 |
| | | | 28 | 3ER28UN-6C... | 59531 | .022 | .08 | .08 | | |
| | | | 24 | 3ER24UN-6C... | 59532 | .026 | .07 | .08 | | |
| | | | 20 | 3ER20UN-6C... | 59533 | .031 | .07 | .09 | | |
| | | | 18 | 3ER18UN-6C... | 59534 | .034 | .07 | .09 | | |
| | | | 16 | 3ER16UN-6C... | 59535 | .038 | .07 | .10 | | |
| | | | 14 | 3ER14UN-6C... | 59536 | .044 | .07 | .11 | | |
| | | | 13 | 3ER13UN-6C... | 59537 | .047 | .08 | .11 | | |
| | | | 12 | 3ER12UN-6C... | 59538 | .051 | .08 | .12 | | |
| **Internal** | 3/8" V6 | .63 | 32 | 3IR32UN-6C... | 59563 | .020 | .08 | .07 | YI3-6C | AVRC..-3<br>NVRC..-3V6 |
| | | | 28 | 3IR28UN-6C... | 59562 | .020 | .07 | .08 | | |
| | | | 24 | 3IR24UN-6C... | 59561 | .024 | .07 | .08 | | |
| | | | 20 | 3IR20UN-6C... | 59560 | .029 | .07 | .09 | | |
| | | | 18 | 3IR18UN-6C... | 59557 | .032 | .07 | .09 | | |
| | | | 16 | 3IR16UN-6C... | 59555 | .036 | .06 | .09 | | |
| | | | 14 | 3IR14UN-6C... | 59553 | .041 | .07 | .10 | | |
| | | | 13 | 3IR13UN-6C... | 59550 | .044 | .07 | .11 | | |
| | | | 12 | 3IR12UN-6C... | 59548 | .048 | .06 | .10 | | |

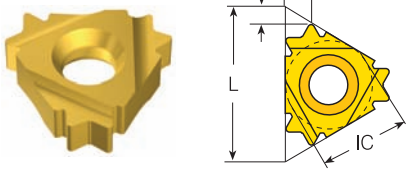
## BSW



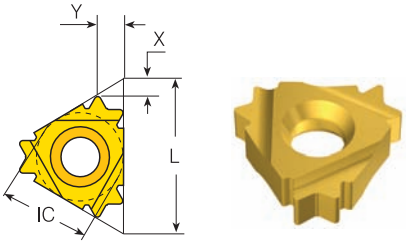

Defined by: B.S.84:1956,
DIN 259, ISO228/1:1982
Tolerance class: Medium class A

| | Insert Size | | Pitch | Ordering Code | EDP No. | Dimensions [inch] | | | V6 Anvil | |
|---|---|---|---|---|---|---|---|---|---|---|
| | IC | L [inch] | tpi | RH | VKX | h | X | Y | RH | Toolholder |
| **External** | 3/8" V6 | .63 | 19 | 3ER19W-6C... | 59539 | .034 | .07 | .09 | YE3-6C | AL..-3 |
| | | | 16 | 3ER16W-6C... | 59540 | .040 | .06 | .09 | | |
| | | | 14 | 3ER14W-6C... | 59541 | .046 | .07 | .11 | | |
| | | | 12 | 3ER12W-6C... | 59542 | .054 | .08 | .12 | | |
| **Internal** | 3/8" V6 | .63 | 19 | 3IR19W-6C... | 59559 | .034 | .07 | .09 | YI3-6C | AVRC..-3<br>NVRC..-3V6 |
| | | | 16 | 3IR16W-6C... | 59556 | .040 | .06 | .09 | | |
| | | | 14 | 3IR14W-6C... | 59554 | .046 | .07 | .10 | | |
| | | | 12 | 3IR12W-6C... | 59549 | .054 | .07 | .10 | | |

# V6 Inserts

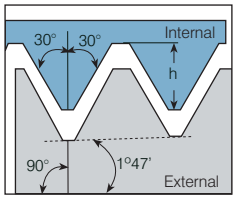



V6 External




V6 Internal

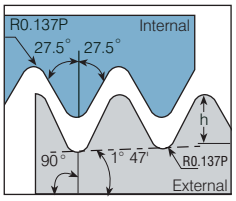
## NPT




| | Insert Size | | Pitch | Ordering Code | EDP No. | Dimensions [inch] | | | V6 Anvil | |
|---|---|---|---|---|---|---|---|---|---|---|
| | IC | L [inch] | tpi | RH | VKX | h | X | Y | RH | Toolholder |
| **External** | 3/8" V6 | .63 | 14 | 3ER14NPT-6C... | 59543 | .052 | .08 | .12 | YE3-6C | AL..-3 |
| **Internal** | 3/8" V6 | .63 | 14 | 3IR14NPT-6C... | 59551 | .052 | .08 | .11 | YI3-6C | AVRC..-3<br>NVRC..-3V6 |

Defined by: USAS B2.1:1968
Tolerance class: Standard NPT

## BSPT

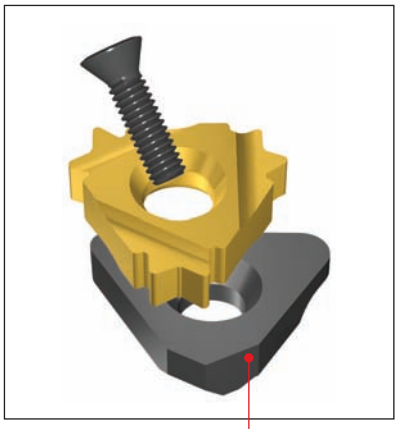



| | Insert Size | | Pitch | Ordering Code | EDP No. | Dimensions [inch] | | | V6 Anvil | |
|---|---|---|---|---|---|---|---|---|---|---|
| | IC | L [inch] | tpi | RH | VKX | h | X | Y | RH | Toolholder |
| **External** | 3/8" V6 | .63 | 19 | 3ER19BSPT-6C... | 59544 | .034 | .07 | .09 | YE3-6C | AL..-3 |
| | | | 14 | 3ER14BSPT-6C... | 59545 | .046 | .07 | .11 | | |
| **Internal** | 3/8" V6 | .63 | 19 | 3IR19BSPT-6C... | 59558 | .034 | .07 | .09 | YI3-6C | AVRC..-3 |
| | | | 14 | 3IR14BSPT-6C... | 59552 | .046 | .08 | .11 | | NVRC..-3V6 |

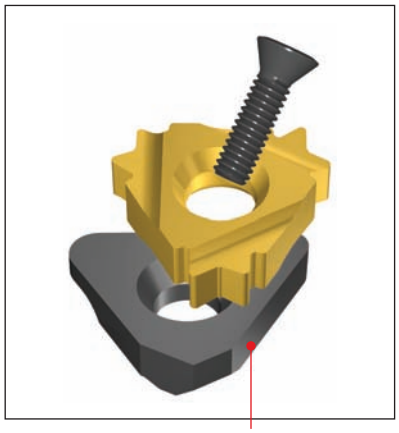
Defined by: B.S.21:1985
Tolerance class: Standard BSPT

## Important!

**Use a V6 anvil when using a V6 insert.**

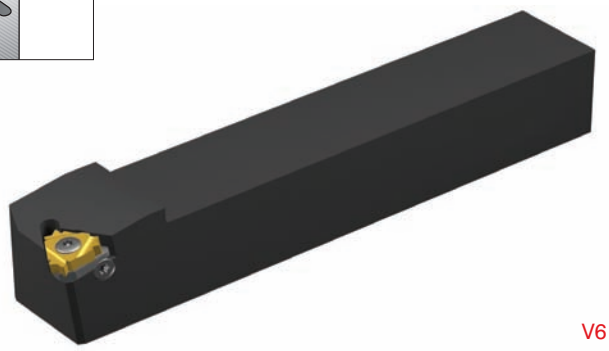


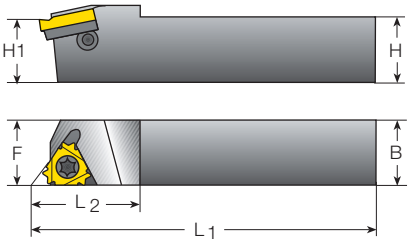
For External RH use YE3-6C anvil.



For Internal RH use YI3-6C anvil.

# External Toolholders (with anvil)






V6 inserts can be used on any External RH holder that uses an anvil.

## Standard

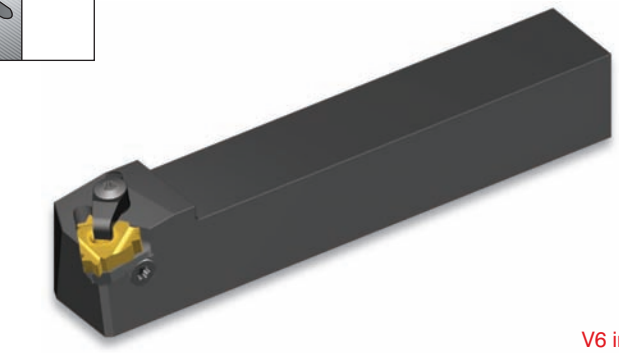
| Insert Size | Ordering Code | EDP No. | Dimensions [inch] | | | |
|---|---|---|---|---|---|---|
| IC | | | H=H1=B | F | L1 | L2 |
| 3/8" | AL3/8-3 | 66091 | .37 | .63 | 2.45 | .76 |
| | AL050-3 | 66000 | .50 | .63 | 3.27 | .87 |
| | AL0625-3 | 66005 | .63 | .63 | 5.00 | 1.02 |
| | AL075-3 | 66007 | .75 | .75 | 5.00 | 1.02 |
| | AL100-3 | 66016 | 1.00 | 1.00 | 6.00 | 1.20 |
| | AL125-3 | 66036 | 1.25 | 1.25 | 7.00 | 1.18 |

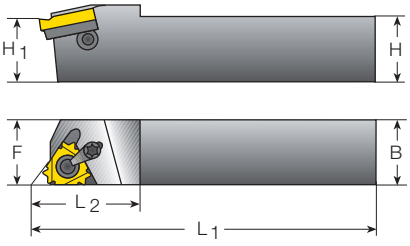
Spare Parts (Ordering code & EDP No.)

| Insert Screw | Anvil Screw | Torx Key | V6 Anvil RH * |
|---|---|---|---|
| SA3T (70028) | SY3T (70044) | K3T (70021) | **YE3-6C** (70249) |

* The holders are supplied with standard anvils. For V6, please use the V6 anvil indicated in the table above.

# External Toolholders (with anvil)






V6 inserts can be used on any External RH holder that uses an anvil.

## Standard with Clamp
(Dual System: Screw or Clamp)

| Insert Size | Ordering Code | EDP No. | Dimensions [inch] | | | |
|---|---|---|---|---|---|---|
| IC | | | H=H1=B | F | L1 | L2 |
| 3/8" | AL075-3C | 66008 | .75 | .75 | 5.00 | 1.20 |
| | AL100-3C | 66017 | 1.00 | 1.00 | 6.00 | 1.20 |
| | AL125-3C | 66031 | 1.25 | 1.25 | 7.00 | 1.20 |

Spare Parts (Ordering code & EDP No.)

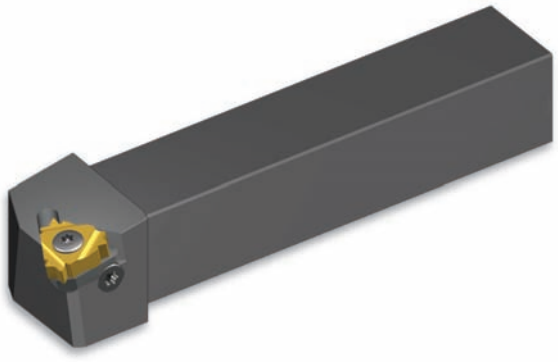
| Insert Screw | Anvil Screw | Clamp | Torx Key | V6 Anvil RH * |
|---|---|---|---|---|
| SA3T (70028) | SY3T (70044) | C3 (70017) | K3CT (70244) | **YE3-6C** (70249) |

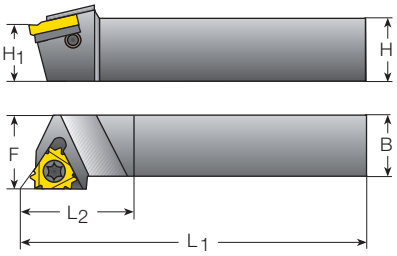
* The holders are supplied with standard anvils. For V6, please use the V6 anvil indicated in the table above.



The above toolholders have a 1.5° helix angle. For other helix angles, see page 10.

# External Toolholders (with anvil)






V6 inserts can be used on any External RH holder that uses an anvil.

## Off-Set Qualified (FQ)

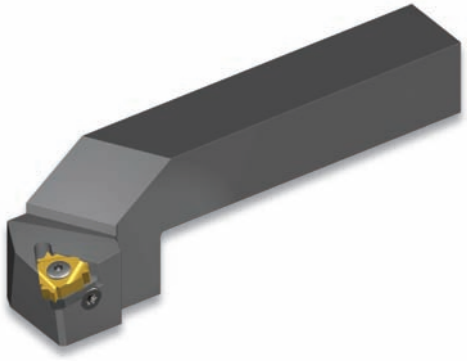
| Insert Size | Ordering Code | EDP No. | Dimensions [inch] | | | |
|---|---|---|---|---|---|---|
| IC | | | H=H1=B | F | L1 | L2 |
| 3/8" | AL075-3FQ | 66011 | .75 | .75 | 6.00 | 1.00 |
| | AL100-3FQ | 66020 | 1.00 | 1.00 | 6.00 | 1.00 |
| | AL125-3FQ | 66039 | 1.25 | 1.25 | 6.00 | 1.20 |

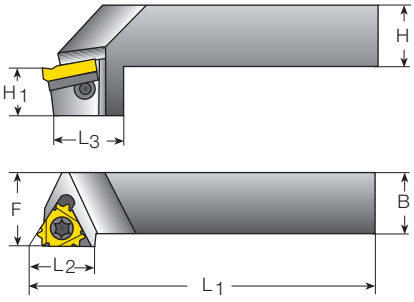
Spare Parts (Ordering code & EDP No.)

|  Insert Screw |  Anvil Screw |  Torx Key |  * V6 Anvil RH |
|---|---|---|---|
| SA3T (70028) | SY3T (70044) | K3T (70021) | YE3-6C (70249) |

* The holders are supplied with standard anvils. For V6, please use the V6 anvil indicated in the table above.

# External Toolholders (with anvil)






V6 inserts can be used on any External RH holder that uses an anvil.

## Drop Head-Qualified (CQ)

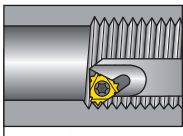
| Insert Size | Ordering Code | EDP No. | Dimensions [inch] | | | | | |
|---|---|---|---|---|---|---|---|---|
| IC | | | H=B | F | L1 | L2 | L3 | H1 |
| 3/8" | AL075-3CQ | 66009 | .75 | 1.00 | 5.00 | .88 | 1.50 | .69 |
| | AL100-3CQ | 66018 | 1.00 | 1.25 | 6.00 | .88 | 1.50 | .87 |
| | AL125-3CQ | 66037 | 1.25 | 1.5 | 7.00 | .88 | 1.50 | .87 |

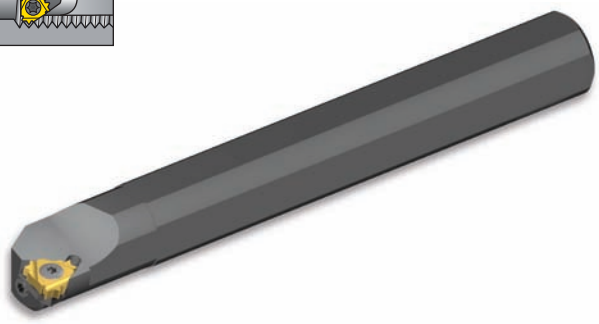
Spare Parts (Ordering code & EDP No.)

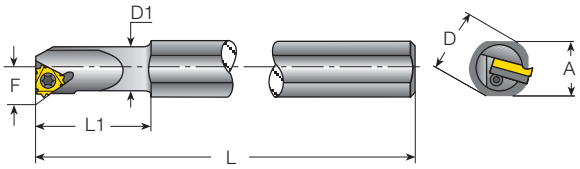
|  Insert Screw |  Anvil Screw |  Torx Key |  * V6 Anvil RH |
|---|---|---|---|
| SA3T (70028) | SY3T (70044) | K3T (70021) | YE3-6C (70249) |

* The holders are supplied with standard anvils. For V6, please use the V6 anvil indicated in the table above.

# Internal Toolholders (with anvil)








V6 inserts can be used on any Internal RH holder that uses an anvil.

## Standard

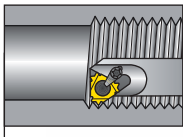
| Insert Size | Ordering Code | EDP No. | Dimensions [inch] | | | | | | Min. Bore dia. |
|---|---|---|---|---|---|---|---|---|---|
| IC | | | A | L | L1 | D | D1 | F | inch |
| 3/8" | AVRC075-3 | 66098 | .67 | 7.0 | 1.50 | .75 | .75 | .51 | .90 |
| | AVRC100-3 | 66100 | 1.12 | 10.0 | 2.50 | 1.25 | 1.00 | .65 | 1.20 |
| | AVRC100D-3 | 66104 | .90 | 8.0 | 1.75 | 1.00 | 1.00 | .65 | 1.20 |
| | AVRC125-3 | 66108 | 1.12 | 10.0 | 2.50 | 1.25 | 1.25 | .77 | 1.45 |
| | AVRC150-3 | 66114 | 1.34 | 12.0 | 2.50 | 1.50 | 1.50 | .90 | 1.65 |

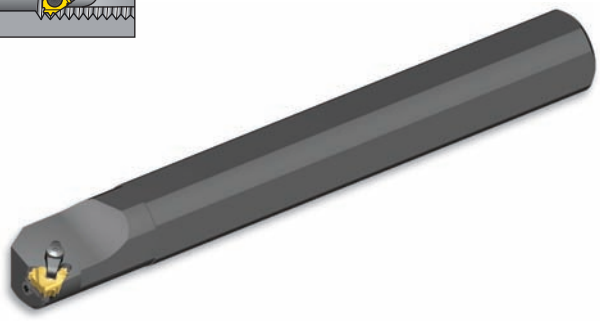
Spare Parts (Ordering code & EDP No.)

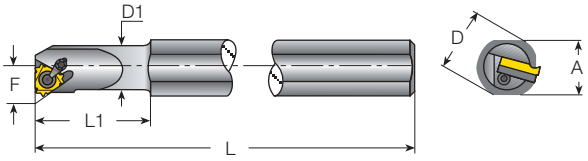
| Insert Screw | Anvil Screw | Torx Key | V6 Anvil RH* |
|---|---|---|---|
| SA3T (70028) | SY3T (70044) | K3T (70021) | YI3-6C (70256) |

* The holders are supplied with standard anvils. For V6, please use the V6 anvil indicated in the table above.

# Internal Toolholders (with anvil)








V6 inserts can be used on any Internal RH holder that uses an anvil.

## Standard with Clamp
(Dual System: Screw or Clamp)

| Insert Size | Ordering Code | EDP No. | Dimensions [inch] | | | | | | Min. bore dia. |
|---|---|---|---|---|---|---|---|---|---|
| IC | | | A | L | L1 | D | D1 | F | inch |
| 3/8" | AVRC075-3C | 66032 | .67 | 7.0 | 2.00 | .75 | .75 | .51 | .90 |
| | AVRC100-3C | 66040 | 1.12 | 10.0 | 2.50 | 1.25 | 1.00 | .65 | 1.20 |
| | AVRC100D-3C | 66056 | .90 | 8.0 | 1.75 | 1.00 | 1.00 | .65 | 1.20 |
| | AVRC125-3C | 66093 | 1.12 | 10.0 | 2.50 | 1.25 | 1.25 | .77 | 1.45 |
| | AVRC150-3C | 66096 | 1.34 | 12.0 | 2.50 | 1.50 | 1.50 | .90 | 1.65 |

Spare Parts (Ordering code & EDP No.)

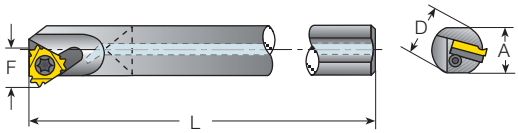
| Insert Screw | Anvil Screw | Clamp | Torx Key | V6 Anvil RH* |
|---|---|---|---|---|
| SA3T (70028) | SY3T (70044) | C3 (70017) | K3CT (70244) | YI3-6C (70256) |

* The holders are supplied with standard anvils. For V6, please use the V6 anvil indicated in the table above.



The above toolholders have a 1.5° helix angle. For other helix angles, see page 10.

# Internal Toolholders (with anvil)




V6 inserts can be used on any Internal RH holder that uses an anvil.

## Standard with Carbide Shank

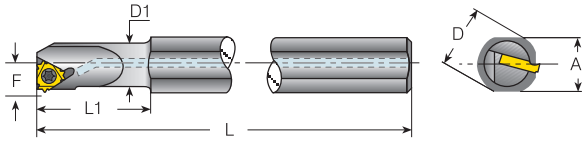
| Insert Size | Ordering Code | EDP No. | Dimensions [inch] | | | | Min. bore dia. |
|---|---|---|---|---|---|---|---|
| IC | | | D | A | F | L | inch |
| 3/8" | CAVRC075-3 | 66194 | .75 | .727 | .509 | 10.00 | .90 |

Spare Parts (Ordering code & EDP No.)

| Insert Screw | Anvil Screw | Torx Key | V6 Anvil RH * |
|---|---|---|---|
| SA3T (70028) | SY3T (70044) | K3T (70021) | YI3-6C (70256) |

* The holders are supplied with standard anvils. For V6, please use the V6 anvil indicated in the table above.

# Internal Toolholders for V6 (without anvil)*




Specially designed for V6 inserts

## V6 Style

| Insert Size | Ordering Code | EDP No. | Dimensions [inch] | | | | | | Min. bore dia |
|---|---|---|---|---|---|---|---|---|---|
| IC | | | A | L | L1 | D | D1 | F | inch |
| 3/8" V6 | NVRC050-3V6 | 66231 | .67 | 7.0 | 1.25 | .75 | .50 | .40 | .67 |
| | NVRC0625-3V6 | 66232 | .67 | 7.0 | 1.50 | .75 | .62 | .46 | .80 |
| | NVRC0625D-3V6 | 66233 | .58 | 6.0 | 1.25 | .62 | .62 | .46 | .80 |

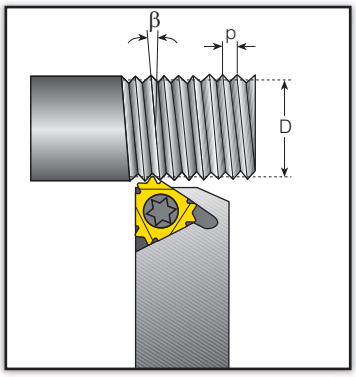
Spare Parts (Ordering code & EDP No.)

| Insert Screw | Torx Key |
|---|---|
| SN3TM (70236) | K3T (70021) |
| SN3T (70038) | |

The above toolholders have a 1.5° helix angle.

* V6 inserts cannot be used on standard internal toolholders without anvil. For this purpose you must use one of these special V6 toolholders.

# Calculating the Helix Angle β



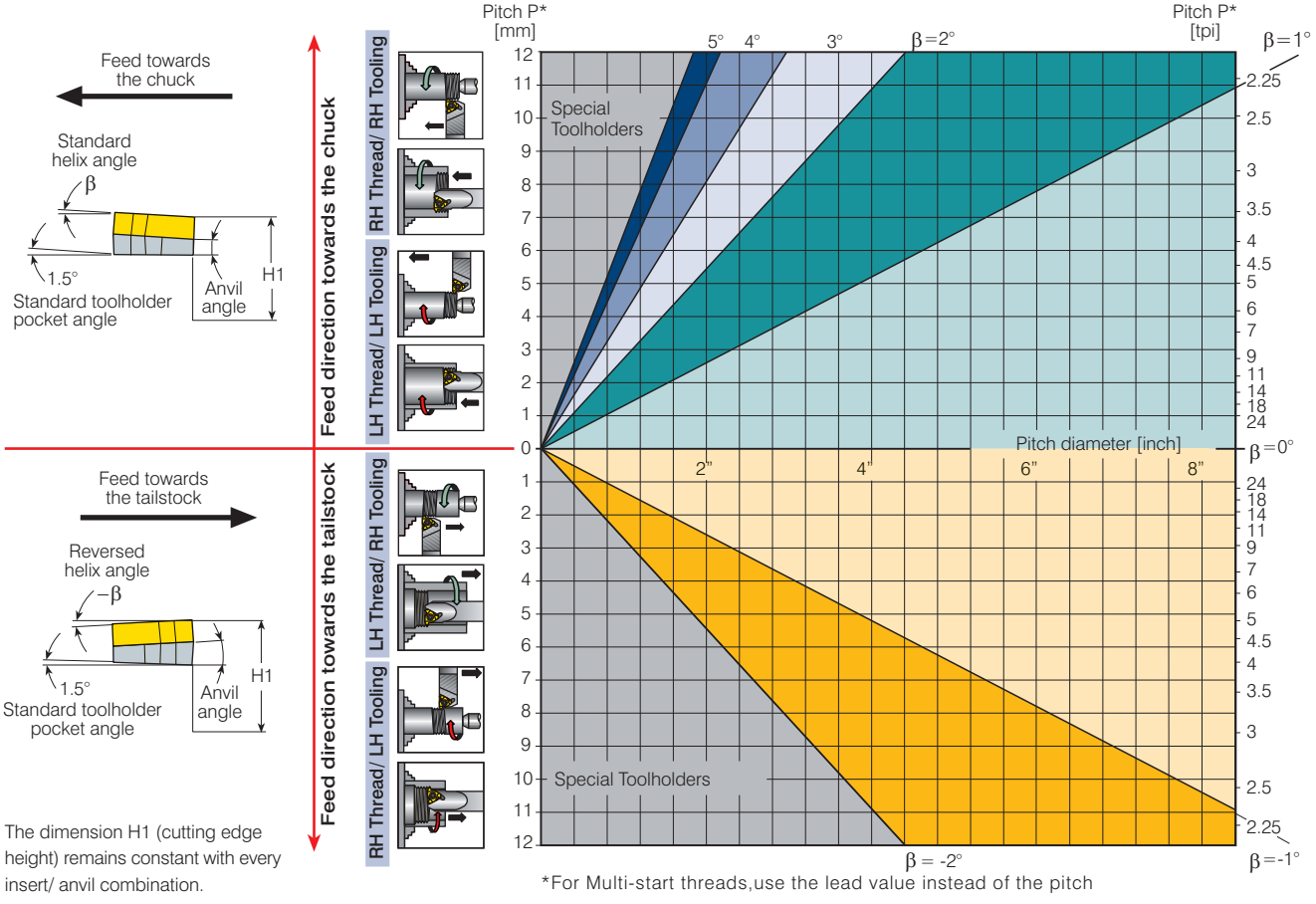

The helix angle is calculated by the following formula:

$$\beta = \arctan\frac{P \times N}{\pi \times D}$$

β - Helix angle [ ° ]
P - Pitch [Inch]
N - No. of starts
D - Pitch diameter [Inch]
Lead = P x N

The helix angle can also be determined from the diagram below.

## Helix Angle Diagram

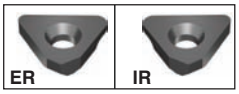



The dimension H1 (cutting edge height) remains constant with every insert/ anvil combination.

*For Multi-start threads,use the lead value instead of the pitch

## V6 Anvil

V6 is indicated on the backside




| Resultant Helix Angle | | | 4.5° | 3.5° | 2.5° | 1.5° | 0.5° | 0° | -0.5° | -1.5° |
|---|---|---|---|---|---|---|---|---|---|---|
| IC | L inch | Holder | Ordering Code(EDP No.) | | | | | | | |
| 3/8" V6 | .63 | ER | YE3-6C-3P (70246) | YE3-6C-2P (70247) | YE3-6C-1P (70248) | YE3-6C (70249) | YE3-6C-1N (70250) | YE3-6C-1.5N (70258) | YE3-6C-2N (70251) | YE3-6C-3N (70252) |
| | | IR | YI3-6C-3P (70253) | YI3-6C-2P (70254) | YI3-6C-1P (70255) | YI3-6C (70256) | YI3-6C-1N (70257) | YI3-6C-1.5N (70261) | YI3-6C-2N (70259) | YI3-6C-3N (70260) |

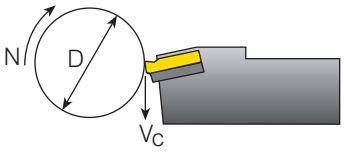
# Recommended Grades and Cutting Speeds Vc [ft/min]

| Material Group | Vardex No. | Material | | Hardness Brinell HB | Vc [ft/min] Coated VKX |
|---|---|---|---|---|---|
| **P** Steel | 1 | Unalloyed steel | Low carbon (C=0.1-0.25%) | 125 | 377-623 |
| | 2 | | Medium carbon (C=0.25-0.55%) | 150 | 328-574 |
| | 3 | | High carbon (C=0.55-0.85%) | 170 | 295-541 |
| | 4 | Low alloy steel (alloying elements≤5%) | Non hardened | 180 | 328-590 |
| | 5 | | Hardened | 275 | 246-459 |
| | 6 | | Hardened | 350 | 230-443 |
| | 7 | High alloy steel (alloying elements>5%) | Annealed | 200 | 262-394 |
| | 8 | | Hardened | 325 | 164-328 |
| | 9 | Cast steel | Low alloy (alloying elements <5%) | 200 | 230-426 |
| | 10 | | High alloy (alloying elements >5%) | 225 | 197-394 |
| **M** Stainless Steel | 11 | Stainless steel Feritic | Non hardened | 200 | 230-426 |
| | 12 | | Hardened | 330 | 197-377 |
| | 13 | Stainless steel Austenitic | Austenitic | 180 | 295-459 |
| | 14 | | Super Austenitic | 200 | 131-361 |
| | 15 | Stainless steel Cast feritic | Non hardened | 200 | 295-394 |
| | 16 | | Hardened | 330 | 213-361 |
| | 17 | Stainless steel Cast austenitic | Austenitic | 200 | 279-361 |
| | 18 | | Hardened | 330 | 197-328 |
| **K** Cast Iron | 28 | Malleable Cast iron | Ferritic (short chips) | 130 | 197-230 |
| | 29 | | Pearlitic (long chips) | 230 | 197-476 |
| | 30 | Grey Cast iron | Low tensile strength | 180 | 230-426 |
| | 31 | | High tensile strength | 260 | 197-377 |
| | 32 | Nodular SG iron | Feritic | 160 | 410-525 |
| | 33 | | Pearlitic | 260 | 295-394 |
| **N(K)** Non-Ferrous Metals | 34 | Aluminium alloys Wrought | Non aging | 60 | 328-1197 |
| | 35 | | Aged | 100 | 262-722 |
| | 36 | Aluminium alloys | Cast | 75 | 656-1312 |
| | 37 | | Cast & aged | 90 | 656-918 |
| | 38 | Aluminium alloys | Cast Si 13-22% | 130 | 197-590 |
| | 39 | Copper and copper alloys | Brass | 90 | 262-738 |
| | 40 | | Bronze and non leaded copper | 100 | 262-836 |
| **S(M)** Heat Resistant Material | 19 | High temperature alloys | Annealed (Iron based) | 200 | 148-197 |
| | 20 | | Aged (Iron based) | 280 | 98-164 |
| | 21 | | Annealed (Nickel or Cobalt based) | 250 | 66-98 |
| | 22 | | Aged (Nickel or Cobalt based) | 350 | 49-82 |
| | 23 | Titanium alloys | Pure 99.5 Ti | 400Rm | 459-558 |
| | 24 | | α+β alloys | 1050Rm | 164-230 |
| **H(K)** Hardened Material | 25 | Extra hard steel | Hardened & tempered | 45-50HRc | 148-197 |
| | 26 | | | 51-55HRc | 131-164 |

## Calculation of N [RPM]

$$N = \frac{12 \times V_c}{\pi \times D}$$

$$V_c = \frac{N \times \pi \times D}{12}$$




N - Revolution Per Minute [RPM]
$V_c$ - Cutting Speed [ft/min]
D - Workpiece Diameter [Inch]

## VKX

Excellent grade for general use.

## Number of Passes

| Pitch | mm | 0.50 | 0.75 | 1.00 | 1.25 | 1.50 | 1.75 | 2.00 |
|---|---|---|---|---|---|---|---|---|
| | tpi | 48 | 32 | 24 | 20 | 16 | 14 | 12 |
| No. of passes | | 3-6 | 3-6 | 4-8 | 4-8 | 5-9 | 6-11 | 6-11 |

6 Cutting Corners

VARDEX

Advanced Threading Solutions

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