

## Enco Introduction to Carbide Threading System Nomenclature

### CHOOSING INSERTS

1. Inserts which have the number 16 listed in the model number can only be used with tool holders that have the number 16 at the end of the tool holder's model number.
2. If the insert model number contains the letters ER (external right hand) which is the thread cutting method, the tool holder model number must include those letters in order to accept the inserts. Example Threading inserts 16 ER A60 P25C can be used with any of the tool holders listed below. Threading tool holders: SER 0500 F16, SER 1000 M16, SER 0750 K16, SER 1250 P16

### CHOOSING TOOL HOLDERS

Example  
Tool Holder: SER 0500 F1  
Based on the thread profile which the customer would determine, the insert would be a 16 ER + thread + grade (e.g. 16 ER + A60 + P25C = 16 ER A60 P25C) Spare parts for the tool holders are based on the last two numbers of the tool holder's model number. For tool holder SER 0500F16, spare parts ending with the number 16 will fit that holder. Examples: S16 - Screw, A16 - Anvil Screw, K16 - Wrench, AE16+4.5 - Anvil Screw

## INSERT ORDERING CODE

**16**

06	5/32
08	3/16
11	1/4
16	3/8
22	1/2
27	5/8
22 U	1/2 U
27 U	5/8 U

E = External  
I = Internal

R = Right hand  
L = Left hand

**E**

**R**

**12**

PARTIAL PROFILES			
TYPE	L	PITCH RANGE	
		(mm)	TPI
A	11	0.5 - 1.5	48 - 16
A	16	0.5 - 1.5	48 - 16
AG		0.5 - 3	48 - 8
G		1.75 - 3	14 - 8
N	22	3.5 - 5	7 - 5
U		5.5 - 8	4.5 - 3.25
Q	27	5.5 - 6	4.5 - 5
U		6.5 - 9	4 - 2.75
V		6 - 10	4 - 2.5

FULL PROFILES PITCH RANGE	
mm	TPI
0.35 - 12	72 - 2

**UN**

60 = 60° Profiles  
55 = 55° Profiles

**FULL PROFILES THREAD STANDARDS**

ISO (Metric)  
UN American un  
W (BSW British Std)  
NPT (American Pipe Thread)  
BSPT (British Pipe Thread)  
Acme and Stub Acme  
TR (Trapez To Din 103)  
UNJ (Aviation)  
AM - BUT (American Buttress)  
RND (Round to Din 405)  
API (Oil Threads)  
API Round  
API Buttress Casing  
VAM  
Extreme Line Casing  
H 90

**P 30**

Multitooth  
Style & No.  
of Teeth  
API Size  
& Taper

CARBIDE GRADES	
PLAIN	COATED
P 10 P 15 P 30 K 20	P 25 C  M 2 CT T 20 MICROGRAIN
M X	M X C

## TOOLHOLDERS ORDERING CODE

**S**

**CLAMPING METHOD**

S = Screw

E = External  
I = Internal

R = Right hand  
L = Left hand

**E**

**R**

**2020**

**CROSS SECTION**

**EXTERNAL TOOLHOLDERS**  
SQUARE SHANK:  
Metric: 2020 = 20 mm x 20 mm  
Inch: 2020 = 1.5 x 1.5"

**INTERNAL TOOLHOLDERS**  
ROUND SHANK:  
Metric: 0025 = Diameter 25 mm  
Inch: 0750 = Diameter 0.75"

**K**

**LENGTH OF TOOLHOLDER**

	mm	Inch
D =	60	2.5
F =	80	3.25
H =	100	4.0
K =	125	5.0
L =	140	5.5
M =	150	6.0
P =	170	7.0
R =	200	8.0
S =	250	10.0
T =	300	12.0
U =	350	14.0
V =	400	16.0

**16**

**POCKET SIZE**

L	IC
(mm)	(INCH)
11	1/4
16	3/8
22	1/2
27	5/8
22 U	1/2 U
27 U	5/8 U

**Bore For Coolant**

C = Carbide Shank  
O = Offset Style  
A = API (OIL)  
E = On Edge (Vertical)

## SPARE PARTS ORDERING CODE

INSERT SIZE	INSERT SCREW	ANVIL SCREW	TORX KEY	ANVIL	
				RH	LH
11 (1/4)	S 11		K 11		
16 (3/8)	S16 S16	A16 A16	K16 K16	AE16 AI16	AI16 AE16
22 (1/2)	S22 S22	A22 A22	K22 K22	AE22 AI22	A122 AE22
22 U	S22 S22	A22 A22	K22 K22	AE22U AI22U	AI22U AE22U
27 (5/8)	S27 S27	A27 A27	K27 K27	AE27 AI27	AI27 AE27
27 U	S27 S27	A27 A27	K27 K27	AE27U AI27U	AI27U AE27U
27 U	S27 S27	A27 A27	K27 K27	AI27U AI27U	AE27U AE27U