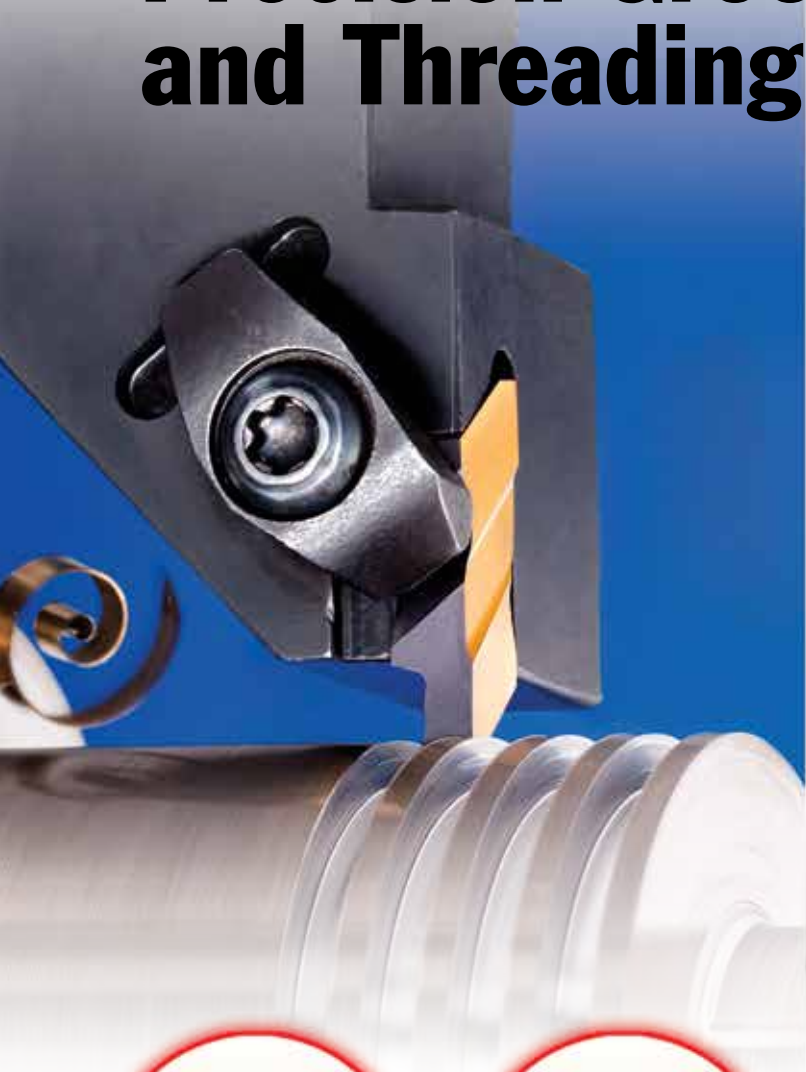


Imperial  
and Metric  
Measurements  
for metric data see page 26

**NOTCH-GRIP**  
GROOVE-TURN LINE

Engineered for  
**MAXIMUM**  
Precision Grooving  
and Threading



## Imperial Measurements

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## Metric Measurements

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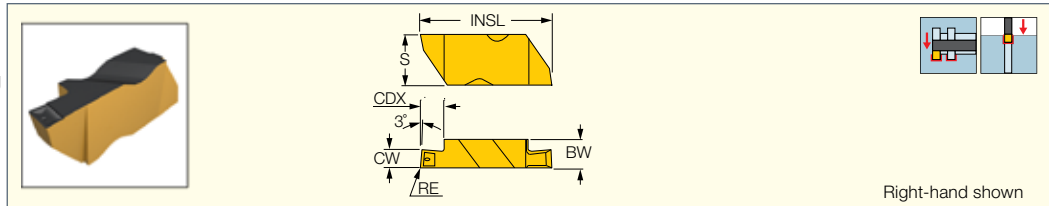
<b>User Guide .....</b>	<b>46-47</b>
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# GROOVING INSERTS

**NOTCH GRIP**  
GROOVE-TURN LINE

**ING-RCB/LCB**

Precision Double-Ended Grooving Inserts with a Chipformer



Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL		f groove (IPR)
ING3031LCB	.031	.0010	.0035	.0012	.050	.195	.344	.890	●	.0011-.0020
ING3031RCB	.031	.0010	.0035	.0025	.050	.195	.344	.890	●	.0011-.0020
ING2M100R/LCB	.039	.0010	.0075	.0025	.050	.150	.219	.510	●	.0016-.0024
ING3M100R/LCB	.039	.0010	.0075	.0025	.075	.195	.344	.890	●	.0015-.0024
ING3M120R/LCB	.047	.0010	.0075	.0025	.075	.195	.344	.890	●	.0015-.0024
ING3047R/LCB	.047	.0010	.0075	.0025	.075	.195	.344	.890	●	.0015-.0024
ING2M150R/LCB	.059	.0010	.0075	.0025	.110	.150	.219	.510	●	.0020-.0031
ING3M150R/LCB	.059	.0010	.0075	.0025	.120	.195	.344	.890	●	.0019-.0031
ING2062R/LCB	.062	.0010	.0075	.0025	.110	.150	.219	.514	●	.0019-.0031
ING3062R/LCB	.062	.0010	.0075	.0025	.120	.195	.344	.890	●	.0019-.0031
ING3M175R/LCB	.069	.0010	.0075	.0025	.120	.195	.344	.890	●	.0019-.0035
ING3072R/LCB	.072	.0010	.0075	.0025	.120	.195	.344	.890	●	.0019-.0035
ING3078R/LCB	.078	.0010	.0075	.0025	.120	.195	.344	.890	●	.0019-.0039
ING2M200R/LCB	.079	.0010	.0075	.0025	.110	.150	.219	.510	●	.0020-.0039
ING3M200R/LCB	.079	.0010	.0075	.0025	.120	.195	.344	.890	●	.0019-.0039
ING2094R/LCB	.094	.0010	.0075	.0025	.110	.150	.219	.514	●	.0023-.0039
ING3094R/LCB	.094	.0010	.0075	.0025	.180	.195	.344	.890	●	.0023-.0039
ING3M250R/LCB	.098	.0010	.0075	.0025	.180	.195	.344	.890	●	.0023-.0039
ING3M300R/LCB	.118	.0010	.0075	.0025	.180	.195	.344	.890	●	.0035-.0055
ING2125R/LCB	.125	.0010	.0075	.0025	.110	.150	.219	.514	●	.0035-.0055
ING3125R/LCB	.125	.0010	.0075	.0025	.180	.195	.344	.890	●	.0035-.0055
ING4125R/LCB	.125	.0010	.0075	.0025	.250	.255	.453	1.120	●	.0035-.0055
ING3M400R/LCB	.157	.0010	.0126	.0025	.180	.195	.344	.890	●	.0047-.0079
ING3189R/LCB	.189	.0010	.0224	.0025	.180	.195	.344	.890	●	.0047-.0087
ING4189R/LCB	.189	.0010	.0224	.0025	.250	.255	.453	1.120	●	.0047-.0087
ING4250R/LCB	.250	.0010	.0224	.0025	.250	.255	.453	1.120	●	.0047-.0098

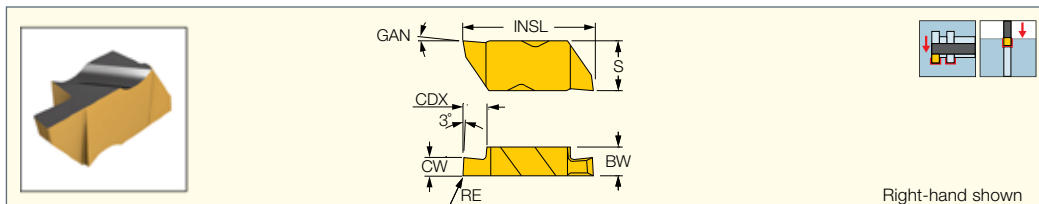
• DMIN according to related boring bar

<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

**NOTCH GRIP**  
GROOVE-TURN LINE

**ING/INGP-R/L**  
Precision Double-Ended  
Flat Top Grooving Inserts



	Dimensions									Tough ↔ Hard		Recommended Machining Data
Designation	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	GAN	BW	S	INSL	IC808	IC807	f groove (IPR)
INGP2031R/L	.031	.0010	.0035	.0012	.050	5	.150	.219	.514		●	.0008-.0016
ING2031R/L	.031	.0010	.0035	.0012	.050	0	.150	.219	.514		●	.0008-.0016
ING2041R/L	.041	.0010	.0035	.0012	.050	0	.150	.219	.514		●	.0012-.0020
ING2047R/L	.047	.0010	.0035	.0012	.050	0	.150	.219	.514		●	.0012-.0020
INGP2062R/L	.062	.0010	.0075	.0025	.110	5	.150	.219	.514		●	.0016-.0024
ING2062R/L	.062	.0010	.0075	.0025	.110	0	.150	.219	.514		●	.0016-.0024
ING2094R/L	.094	.0010	.0075	.0025	.110	0	.150	.219	.514		●	.0020-.0031
ING2125R/L	.125	.0010	.0075	.0025	.110	0	.150	.219	.514		●	.0031-.0047
ING3031R/L	.031	.0010	.0035	.0012	.050	0	.195	.344	.890	●		.0008-.0016
INGP3047R/L	.047	.0010	.0075	.0025	.075	5	.195	.344	.890		●	.0012-.0020
ING3047R/L	.047	.0010	.0075	.0025	.075	0	.195	.344	.890	●		.0012-.0020
ING3058R/L	.058	.0010	.0075	.0025	.094	0	.195	.344	.890	●		.0012-.0020
INGP3062R/L	.062	.0010	.0075	.0025	.120	5	.195	.344	.890		●	.0016-.0024
ING3062R/L	.062	.0010	.0075	.0025	.094	0	.195	.344	.890	●		.0016-.0024
ING3072R/L	.072	.0010	.0075	.0025	.094	0	.195	.344	.890	●		.0016-.0031
ING3078R/L	.078	.0010	.0075	.0025	.094	0	.195	.344	.890	●		.0016-.0035
ING3088R/L	.088	.0010	.0075	.0025	.094	0	.195	.344	.890	●		.0020-.0035
INGP3094R/L	.094	.0010	.0075	.0025	.180	5	.195	.344	.890		●	.0020-.0031
ING3094R/L	.094	.0010	.0075	.0025	.150	0	.195	.344	.890	●		.0020-.0035
ING3097R/L	.097	.0010	.0125	.0025	.150	0	.195	.344	.890	●		.0024-.0039
ING3105R/L	.105	.0010	.0075	.0025	.150	0	.195	.344	.890	●		.0027-.0043
ING3110R/L	.110	.0010	.0125	.0025	.150	0	.195	.344	.890	●		.0027-.0043
ING3122R/L	.122	.0010	.0075	.0025	.150	0	.195	.344	.890	●		.0027-.0047
INGP3125R/L	.125	.0010	.0075	.0025	.180	5	.195	.344	.890		●	.0031-.0047
ING3125R/L	.125	.0010	.0075	.0025	.150	0	.195	.344	.890	●		.0031-.0051
ING3142R/L	.142	.0010	.0125	.0025	.150	0	.195	.344	.890	●		.0035-.0059
ING3156R/L	.156	.0010	.0075	.0025	.150	0	.195	.344	.890	●		.0039-.0079
ING3178R/L	.178	.0010	.0075	.0025	.150	0	.195	.344	.890	●		.0043-.0083
ING3185R/L	.185	.0010	.0224	.0025	.150	0	.195	.344	.890	●		.0043-.0087
ING3189R/L	.189	.0010	.0224	.0025	.150	0	.195	.344	.890	●		.0043-.0087
ING4125R/L	.125	.0010	.0075	.0025	.250	0	.255	.453	1.120		●	.0031-.0047
ING4189R/L	.189	.0010	.0224	.0025	.250	0	.255	.453	1.120		●	.0039-.0079
ING4250R/L	.250	.0010	.0224	.0025	.250	0	.255	.453	1.120		●	.0039-.0087

• DMIN according to related boring bar

<sup>(1)</sup> Cutting width tolerance (+/-)

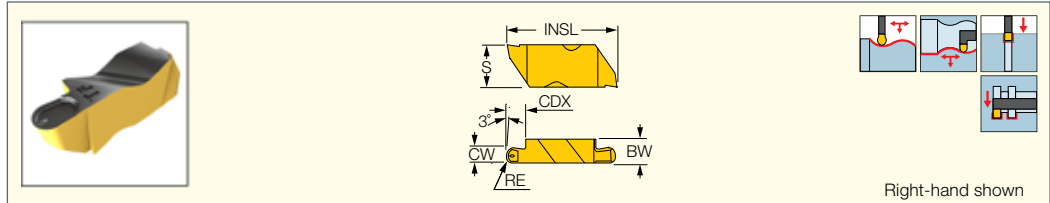
<sup>(2)</sup> Corner radius tolerance (+/-)



**NOTCH GRIP**  
GROOVE-TURN LINE

**INR-RCB/LCB**

Precision, Double-Ended  
Full Radius Grooving Inserts  
with a Chipformer



Designation	Dimensions								IC807	Recommended Machining Data	
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL		f groove (IPR)	
<b>INR3062R/LCB</b>	.125	.0010	.0625	.0025	.180	.195	.344	.890	●	.0027-.0047	

• DMIN according to related boring bar

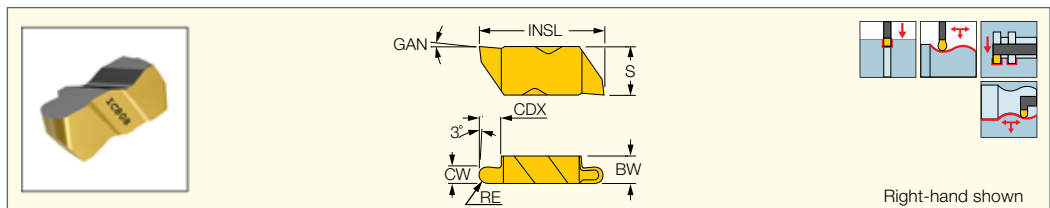
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

**NOTCH GRIP**  
GROOVE-TURN LINE

**INR/INRP-R/L**

Precision Double-Ended Flat  
Top Round Grooving Inserts



Designation	Dimensions									Tough ↔ Hard		Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL	GAN	IC808	IC807	
<b>INR2031R/L</b>	.062	.0010	.0307	.0025	.110	.150	.219	.514	0		●	.0012-.0020
<b>INRP3031R/L</b>	.062	.0010	.0307	.0025	.125	.195	.344	.890	5		●	.0012-.0020
<b>INR3031R/L</b>	.062	.0010	.0311	.0025	.125	.195	.344	.890	0	●		.0016-.0031
<b>INR2047R/L</b>	.094	.0010	.0469	.0025	.110	.150	.219	.514	0		●	.0016-.0027
<b>INRP3047R/L</b>	.094	.0010	.0469	.0025	.180	.195	.344	.890	5		●	.0016-.0027
<b>INR3047R/L</b>	.094	.0010	.0469	.0025	.150	.195	.344	.890	0	●		.0024-.0047
<b>INRP3062R/L</b>	.125	.0010	.0618	.0025	.180	.195	.344	.890	5		●	.0027-.0043
<b>INR3062R/L</b>	.125	.0010	.0626	.0025	.150	.195	.344	.890	0	●		.0031-.0063
<b>INR3078R/L</b>	.156	.0010	.0780	.0025	.150	.195	.344	.890	0	●		.0039-.0079
<b>INR3094R/L</b>	.188	.0010	.0941	.0025	.150	.195	.344	.890	0	●		.0047-.0087
<b>INR4125R/L</b>	.250	.0010	.1252	.0025	.250	.255	.453	1.120	0		●	.0039-.0087

• DMIN according to related boring bar

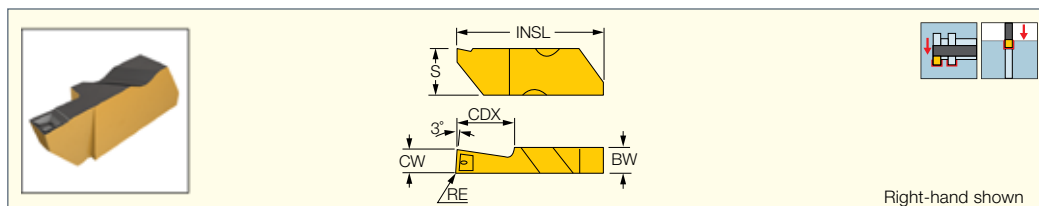
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

# NOTCH GRIP

## INGD-RCB/LCB

Precision, Single-Ended  
Deep Grooving Inserts  
with a Chipformer



Right-hand shown

Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL		f groove (IPR)
INGD3094R/LCB	.094	.0010	.0075	.0025	.250	.195	.344	.990	•	.0024-.0039
INGD3125R/LCB	.125	.0010	.0075	.0025	.250	.195	.344	.990	•	.0035-.0055

• DMIN according to related boring bar

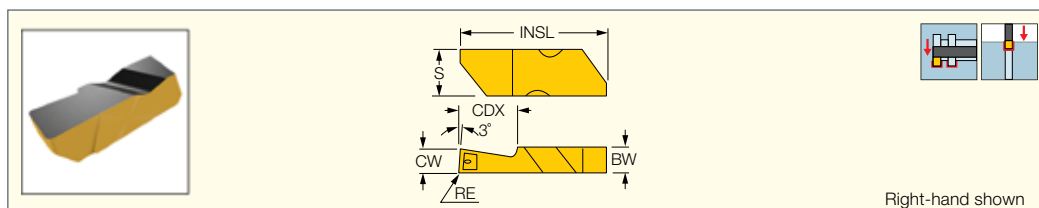
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

# NOTCH GRIP

## INGD-R/L

Precision, Single-Ended Flat  
Top Deep Grooving Inserts



Right-hand shown

Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL		f groove (IPR)
INGD3062R/L	.062	.0010	.0075	.0025	.120	.195	.344	.990	•	.0015-.0024
INGD3094R/L	.094	.0010	.0075	.0025	.250	.195	.344	.990	•	.0019-.0031
INGD3125R/L	.125	.0010	.0075	.0025	.250	.195	.344	.990	•	.0031-.0047
INGD3189R/L	.189	.0010	.0224	.0025	.250	.195	.344	.990	•	.0039-.0079

• DMIN according to related boring bar

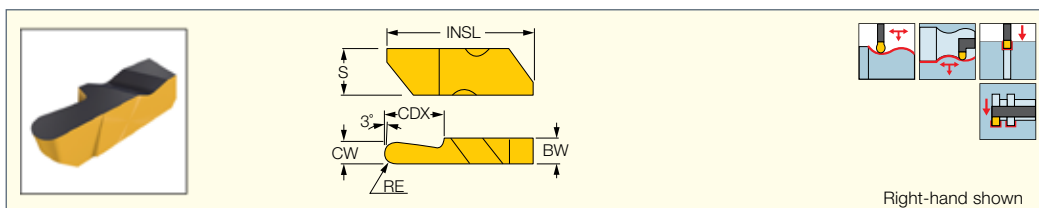
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

# NOTCH GRIP

## INRD-R/L

Precision, Single-Ended  
Full Radius Deep Grooving  
Inserts with a Flat Rake



Right-hand shown

Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL		f groove (IPR)
INRD3062R/L	.125	.0010	.0618	.0025	.250	.195	.344	.990	•	.0027-.0043

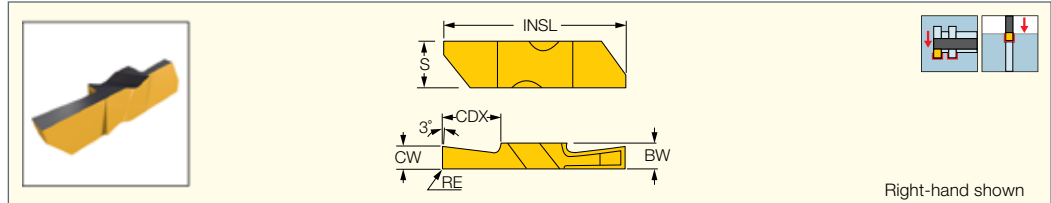
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

# NOTCH-GRIP

## INGT-R/L

Precision, Double-Ended Flat  
Top Deep Grooving Inserts



Right-hand shown

Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL		f groove (IPR)
INGT3094R/L	.094	.0010	.0075	.0025	.275	.195	.344	1.370	•	.0020-.0031
INGT3125R/L	.125	.0010	.0075	.0025	.437	.195	.344	1.370	•	.0031-.0047

• DMIN according to related boring bar

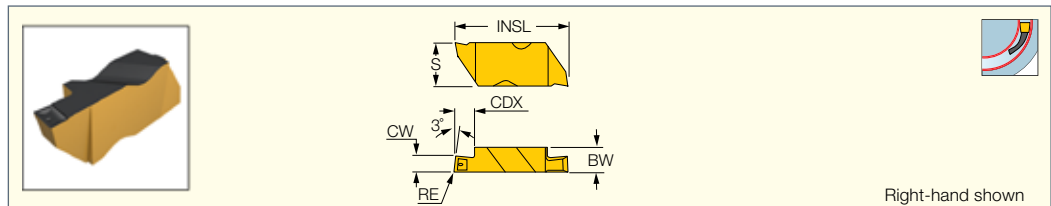
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

# NOTCH-GRIP

## INF-RCB/LCB

Precision, Double-Ended  
Face Grooving Inserts  
with a Chipformer



Right-hand shown

Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	DAXN <sup>(3)</sup>	BW	S		f face-groove (IPR)
INF3125R/LCB	.125	.0010	.0075	.0025	.180	.94	.195	.344	•	.0035-.0055

<sup>(1)</sup> Cutting width tolerance (+/-)

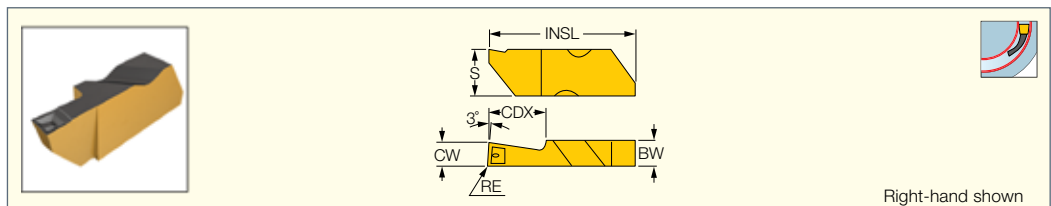
<sup>(2)</sup> Corner radius tolerance (+/-)

<sup>(3)</sup> Minimum axial grooving diameter

# NOTCH-GRIP

## INF-RCB/LCB

Precision, Single-Ended  
Deep Face Grooving Inserts  
with a Chipformer



Right-hand shown

Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	DAXN <sup>(3)</sup>	BW	S		f face-groove (IPR)
INF3125R/LCB	.125	.0010	.0075	.0025	.250	1.87	.195	.344	•	.0035-.0055

<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

<sup>(3)</sup> Minimum axial grooving diameter

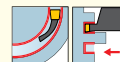
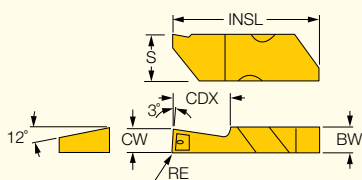
For tools, see pages: A-FLER/L () • FLASR/L (20) • FLSR/L (19) • H-FLER (21) • HS-FLER (22)

# NOTCH GRIP

GROOVE-TURN LINE

## INF D-RCB/LCB-I

Precision, Single-Ended  
Deep Face Grooving Inserts  
with a Chipformer



Right-hand shown

Designation	Dimensions									IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	DAXN <sup>(3)</sup>	BW	S	INSL		f face-groove (IPR)
INF D3125R/LCB-I	.125	.0010	.0075	.0025	.250	1.87	.195	.344	.990	•	.0035-.0055

<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

<sup>(3)</sup> Minimum axial grooving diameter

For tools, see pages: A-FLER/L () • FLASR/L (20) • FL SR/L (19) • H-FLER (21) • HS-FLER (22)

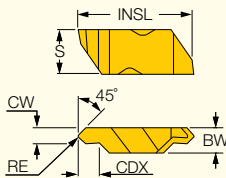
## UNDERCUTTING INSERTS

# NOTCH GRIP

GROOVE-TURN LINE

## INU-R/L

Precision Double-Ended Flat Top  
Inserts for External Undercutting



Designation	Dimensions									IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL			f groove (IPR)
INU3094R/L	.094	.0010	.0201	.0025	.125	.195	.344	.890		•	.0020-.0031

• Not recommended for turning • DMIN according to related boring bar

<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

# ISCAR THREAD

## Grooving/Threading Insert Identification Chart

1. Insert Style	2. Additional Info	3. Insert Size																		
<b>A</b> — Acme <b>B</b> — Blank <b>C</b> — API Thread <b>D</b> — API Thread <b>F</b> — Face grooving <b>G</b> — Grooving <b>J</b> — UNJ Thread <b>R</b> — Full Radius <b>T</b> — 60° Thread <b>U</b> — Undercut <b>V</b> — Poly Vee	<b>D</b> — Deep Grooving <b>F</b> — Fine Pitch <b>K</b> — Fine Pos Rake <b>P</b> — Positive Rake <b>T</b> — Double Ended	<table> <tr> <th>Size</th><th>Inch</th><th>Metric</th></tr> <tr> <td>2</td><td>.150</td><td>3,81</td></tr> <tr> <td>3</td><td>.195</td><td>4,95</td></tr> <tr> <td>4</td><td>.255</td><td>6,48</td></tr> <tr> <td>5</td><td>.380</td><td>9,65</td></tr> <tr> <td>6</td><td>.383</td><td>9,73</td></tr> </table>	Size	Inch	Metric	2	.150	3,81	3	.195	4,95	4	.255	6,48	5	.380	9,65	6	.383	9,73
Size	Inch	Metric																		
2	.150	3,81																		
3	.195	4,95																		
4	.255	6,48																		
5	.380	9,65																		
6	.383	9,73																		
		<b>4. Metric Size</b> Used to indicate metric groovers																		

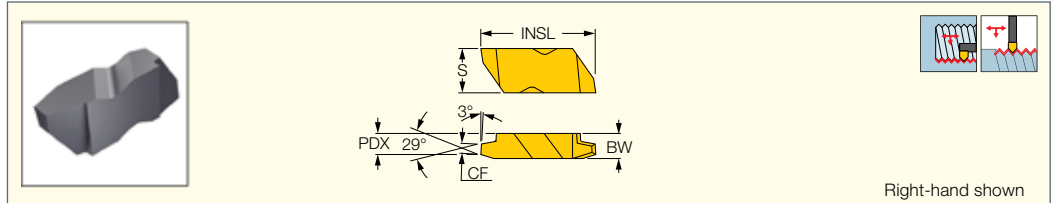
TF	G	P	3	M	125	R	C	CB	IC908
1	2	3	4	5	6	7	8	8	

5. Insert Width	6. Hand of Insert	7. Coarse
Inch/Metric sizes <b>Example:</b> <b>Inch:</b> .125 = 125 <b>Metric:</b> 1,50 = 150	<b>L</b> — .125 = 125 <b>R</b> — 1,50 = 150	Used to indicate coarse pitch threaders only
9. Grade		<b>8. Chipbreaker Style</b> <b>Threading:</b> <b>FCB</b> — Ultra Fine <b>CB</b> — Fine <b>HCB</b> — General Purpose <b>Grooving:</b> <b>CB</b> — General Purpose
IC908		

# ISCARTHREAD

## ACME THREADING FLA

Double-Ended Precision Flat  
Top Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLA-6R/L2	2.0	.180	.2835	.383	.453	1.120	●
FLA-6R/L2.5	2.5	.143	.2835	.383	.453	1.120	●
FLA-6R/L3	3.0	.118	.2835	.383	.453	1.120	●
FLA-3R/L4	4.0	.087	.1339	.195	.344	.890	●
FLA-4R/L4	4.0	.087	.2008	.255	.453	1.120	●
FLA-3R/L5	5.0	.069	.1496	.195	.344	.890	●
FLA-4R/L5	5.0	.069	.2008	.255	.453	1.120	●
FLA-3R/L6	6.0	.057	.1496	.195	.344	.890	●
FLA-4R/L6	6.0	.057	.2008	.255	.453	1.120	●
FLA-3R/L8	8.0	.041	.1496	.195	.344	.890	●
FLA-4R/L8	8.0	.041	.2008	.255	.453	1.120	●
FLA-3R/L10	10.0	.032	.1496	.195	.344	.890	●
FLA-3R/L12	12.0	.028	.1496	.195	.344	.890	●
FLA-3R/L14	14.0	.024	.1496	.195	.344	.890	●
FLA-3R/L16	16.0	.020	.1496	.195	.344	.890	●

- For ACME thread limits, see page
  - DMIN according to related boring bar
- <sup>(1)</sup> Threads per inch

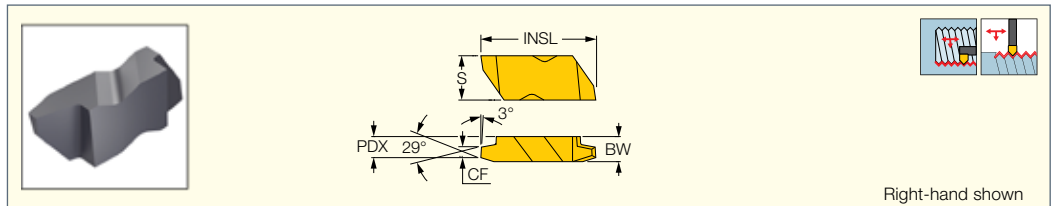
# NOTCH GRIP

GROOVE-TURN LINE

# ISCARTHREAD

## ACME THREADING FLAS

Double-Ended Precision Flat  
Top Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLAS-6R/L2	2.0	.206	.2835	.383	.453	1.120	●
FLAS-4R/L3	3.0	.135	.2008	.255	.453	1.120	●
FLAS-3L4	4.0	.100	.1496	.195	.344	.890	●
FLAS-3R/L5	5.0	.079	.1496	.195	.344	.890	●
FLAS-3R/L6	6.0	.065	.1496	.195	.344	.890	●
FLAS-3R/L8	8.0	.048	.1496	.195	.344	.890	●
FLAS-3R/L10	10.0	.037	.1496	.195	.344	.890	●
FLAS-3R/L12	12.0	.033	.1496	.195	.344	.890	●
FLAS-3R/L14	14.0	.028	.1496	.195	.344	.890	●
FLAS-3R/L16	16.0	.024	.1496	.195	.344	.890	●

- DMIN according to related boring bar
- <sup>(1)</sup> Threads per inch

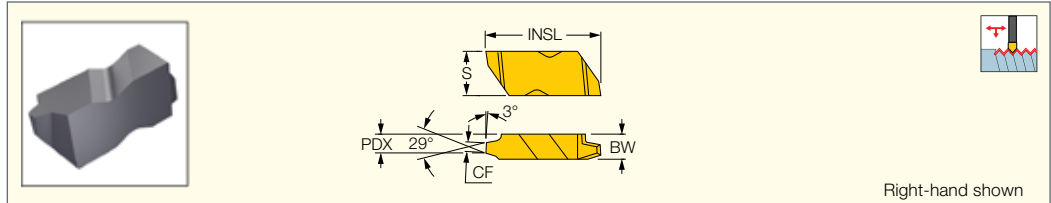


**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**ACME THREADING FLA-PT-E**

Double-Ended Precision Flat  
Top External Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLA-3R4-PT-E	4.0	.087	.1339	.195	.344	.890	●
FLA-3R5-PT-E	5.0	.069	.1496	.195	.344	.890	●
FLA-3R6-PT-E	6.0	.057	.1496	.195	.344	.890	●
FLA-3R8-PT-E	8.0	.041	.1496	.195	.344	.890	●
FLA-3R10-PT-E	10.0	.032	.1496	.195	.344	.890	●
FLA-3R12-PT-E	12.0	.028	.1496	.195	.344	.890	●
FLA-3R14-PT-E	14.0	.024	.1496	.195	.344	.890	●
FLA-3R16-PT-E	16.0	.020	.1496	.195	.344	.890	●
FLA-4R4-PT-E	4.0	.087	.2008	.255	.453	1.120	●
FLA-4R5-PT-E	5.0	.069	.2008	.255	.453	1.120	●
FLA-4R6-PT-E	6.0	.057	.2008	.255	.453	1.120	●
FLA-4R8-PT-E	8.0	.041	.2008	.255	.453	1.120	●
FLA-6R2-T-E	2.0	.180	.2835	.383	.453	1.120	●
FLA-6R2.5-PT-E	2.5	.143	.2835	.383	.453	1.120	●
FLA-6R3-PT-E	3.0	.118	.2835	.383	.453	1.120	●

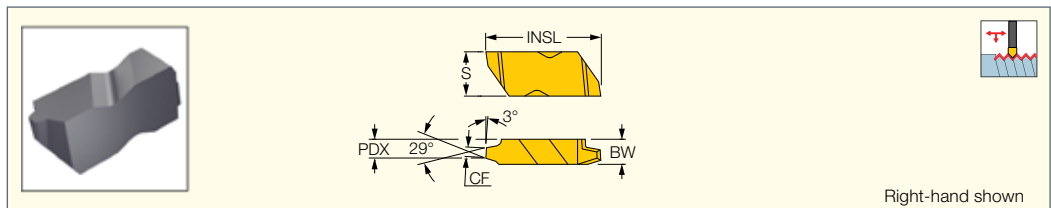
<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**STUB ACME THREADING FLAS-PT-E**

Double-Ended Precision Flat  
Top External Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLAS-3R4-PT-E	4.0	.100	.1496	.195	.344	.890	●
FLAS-3R5-PT-E	5.0	.079	.1496	.195	.344	.890	●
FLAS-3R6-PT-E	6.0	.065	.1496	.195	.344	.890	●
FLAS-3R8-PT-E	8.0	.048	.1496	.195	.344	.890	●
FLAS-3R10-PT-E	10.0	.037	.1496	.195	.344	.890	●
FLAS-3R12-PT-E	12.0	.033	.1496	.195	.344	.890	●
FLAS-3R14-PT-E	14.0	.028	.1496	.195	.344	.890	●
FLAS-3R16-PT-E	16.0	.024	.1496	.195	.344	.890	●
FLAS-4R3-PT-E	3.0	.136	.2008	.255	.453	1.120	●
FLAS-6R2-PT-E	2.0	.206	.2835	.383	.453	1.120	●

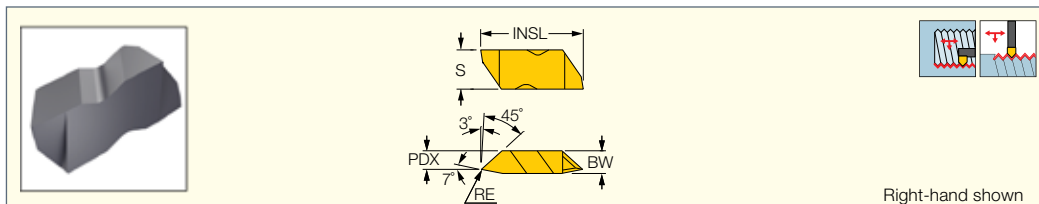
<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCAR THREAD**

**AMERICAN STANDARD  
BUTTRESS THREADING  
FLT-B-A**

Double-Ended Precision Flat Top  
Threading Inserts for 7° Lead



Designation	Dimensions							IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	RE	PDX	BW	S	INSL	
FLT-B-4R/LA	4.00	6.00	.0080	.2047	.255	.453	1.120	•
FLT-B-3R/LA	8.00	16.00	.0050	.1654	.195	.344	.890	•
FLT-B-2R/LA	16.00	20.00	.0020	.1260	.150	.219	.514	•

• For user guide, see page • DMIN according to related boring bar

<sup>(1)</sup> TPI min.

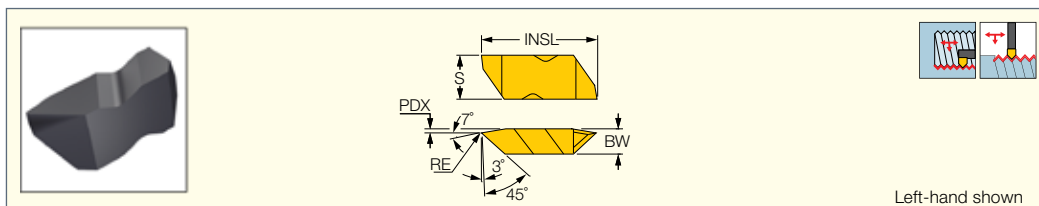
<sup>(2)</sup> TPI max.

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCAR THREAD**

**AMERICAN STANDARD  
BUTTRESS THREADING  
FLT-B-B**

Double-Ended Precision Flat Top  
Threading Inserts for 45° Lead



Designation	Dimensions							IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	RE	PDX	BW	S	INSL	
FLT-B-4R/LB	4.00	6.00	.0080	.0157	.255	.453	1.120	•
FLT-B-3R/LB	8.00	16.00	.0050	.0118	.195	.344	.890	•
FLT-B-2R/LB	16.00	20.00	.0020	.0118	.150	.219	.514	•

• For user guide, see page • DMIN according to related boring bar

<sup>(1)</sup> TPI min.

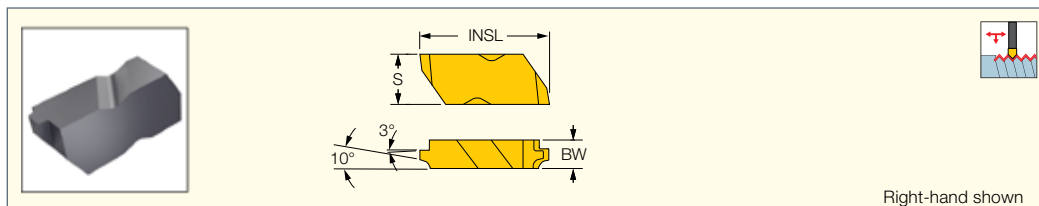
<sup>(2)</sup> TPI max.

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCAR THREAD**

**API BUTTRESS  
THREADING FLDC-B-E**

Double-Ended Precision Flat  
Top Threading Inserts



Designation	Dimensions					IC908
	TPI <sup>(1)</sup>	IPF <sup>(2)</sup>	BW	S	INSL	
FLDC-3-5B1E	5.0	1	.250	.344	.890	•
FLDC-4-5B1E	5.0	1	.255	.453	1.120	•
FLDC-3-5B75E	5.0	3/4	.250	.344	.890	•
FLDC-4-5B75E	5.0	3/4	.255	.453	1.120	•

<sup>(1)</sup> Threads per inch

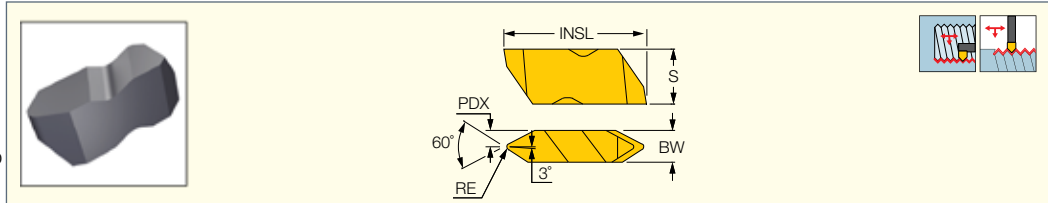
<sup>(2)</sup> Taper Per Foot (TPF) or Inch Per Foot (IPF)

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**PARTIAL PROFILE  
THREADING FLD**

Double-Ended, Precision, Flat Top  
Partial Profile Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLD-4050R/L	4.0	.0201	.1280	.255	.453	1.120	•
FLD-3038R/L	4.0	.0331	.0819	.195	.344	.890	•
FLD-4038R/L	4.0	.0331	.1280	.255	.453	1.120	•
FLD-3040R/L	5.0	.0150	.0819	.195	.344	.890	•
FLD-4040R/L	5.0	.0150	.1280	.255	.453	1.120	•

• DMIN according to related boring bar

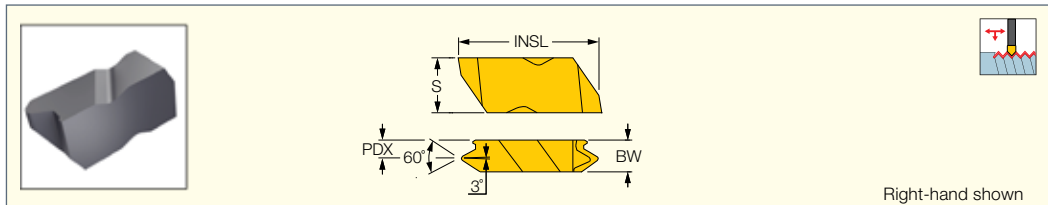
<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API THREADING FLDC-E**

Double-Ended Precision Flat  
Top Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-4-425E	4.0	2	.1831	.312	.453	1.120	•
FLDC-4-428E	4.0	2	.1831	.312	.453	1.120	•
FLDC-4-435E	4.0	3	.1831	.312	.453	1.120	•
FLDC-4-438E	4.0	3	.1831	.312	.453	1.120	•
FLDC-3-530E	5.0	3	.1469	.250	.344	.890	•

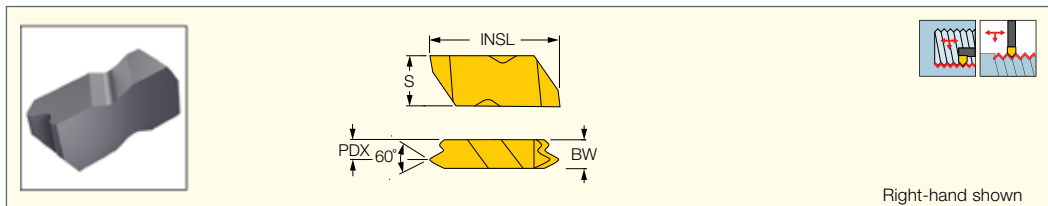
<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API ROUND THREADING  
FLDC-RD-75**

Double-Ended Precision Flat  
Top Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-3-8RDR/L75	8.0	3/4	.1969	.125	.344	.890	•
FLDC-3-10RDR/L75	10.0	3/4	.1969	.125	.344	.890	•

• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

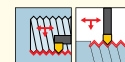
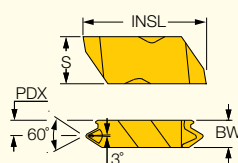
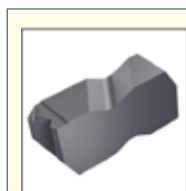
**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

# **API ROUND THREADING**

## **FLDC-RD-75-CB**

Double-Ended, Precision  
Threading Inserts with  
a Chipbreaker



Right-hand shown

Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
<b>FLDC-3-8RDR/L75-CB</b>	8.0	3/4	.1950	.125	.344	.990	●

• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

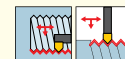
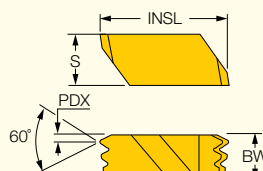
**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

# **API ROUND THREADING**

## **FLDC-RD-75M**

Double-Ended, Precision, Flat Top  
Multi-Tooth Threading Inserts



Left-hand shown

Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
<b>FLDC-6-8RDR75</b>	8.0	3/4	.0709	.383	.453	1.120	●
<b>FLDC-6-10RDR75</b>	10.0	3/4	.1339	.383	.453	1.120	●

• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

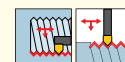
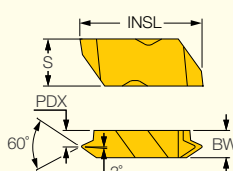
**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

# **NPT THREADING**

## **FLDC-V-75**

Double-Ended Precision Flat  
Top Threading Inserts



Right-hand shown

Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
<b>FLDC-3-8VR/L75</b>	8.0	3/4	.0984	.195	.344	.890	●
<b>FLDC-3-115VR/L75</b>	11.5	3/4	.1457	.195	.344	.890	●
<b>FLDC-3-14VR/L-75</b>	14.0	3/4	.1496	.195	.344	.890	●
<b>FLDC-3-18VR/L-75</b>	18.0	3/4	.1535	.195	.344	.890	●
<b>FLDC-3-27VR/L-75</b>	27.0	3/4	.1614	.195	.344	.890	●

• DMIN according to related boring bar

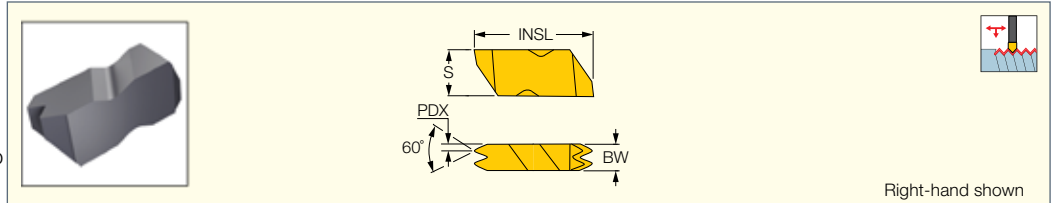
<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**NPT THREADING FLDC-  
NPT-E**

Double-Ended, Precision, Flat Top  
Multi-Tooth Threading Inserts



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-3-8NPT 2E	8.0	3/4	.0590	.250	.344	.890	
FLDC-3-11.5NPT-2E	11.5	3/4	.0472	.250	.344	.890	

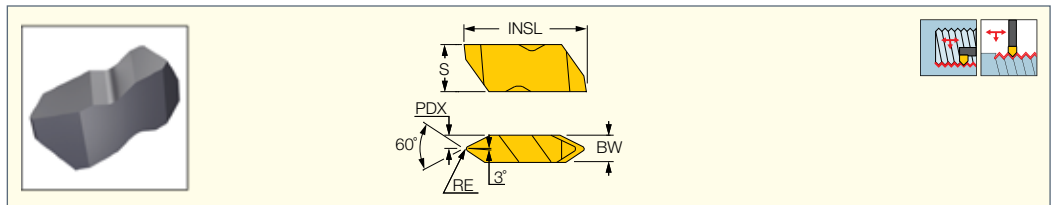
<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**UNJ THREADING FLJ**

Double-Ended Precision Flat  
Top Threading Inserts



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLJ-3020R/L8	8.0	.0189	.0980	.195	.344	.890	
FLJ-3014R/L12	12.0	.0126	.0980	.195	.344	.890	
FLJ-3010R/L16	16.0	.0094	.0980	.195	.344	.890	

• DMIN according to related boring bar

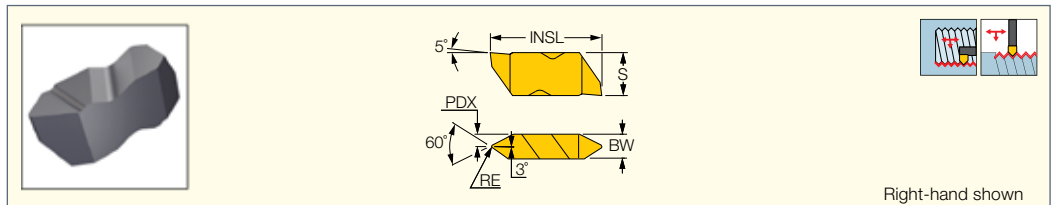
<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**UNJ THREADING FLJP**

Double-Ended, Precision  
Threading Inserts with  
a Positive Rake



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLJP-3020R/L8	8.0	.0189	.0984	.195	.344	.890	
FLJP-3014R/L12	12.0	.0126	.0984	.195	.344	.890	
FLJP-3010R/L16	16.0	.0094	.0984	.195	.344	.890	

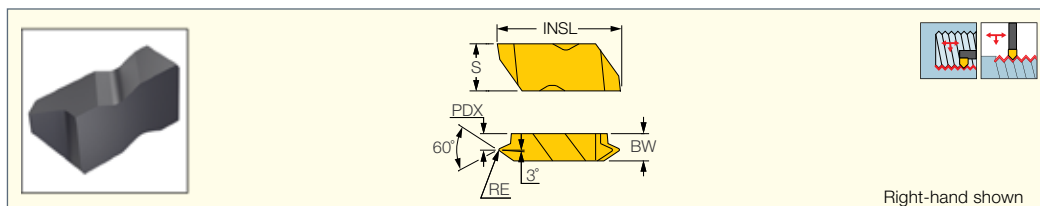
• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**UNJ THREADING FLJF**  
Double-Ended, Precision  
Flat Top Threading Inserts



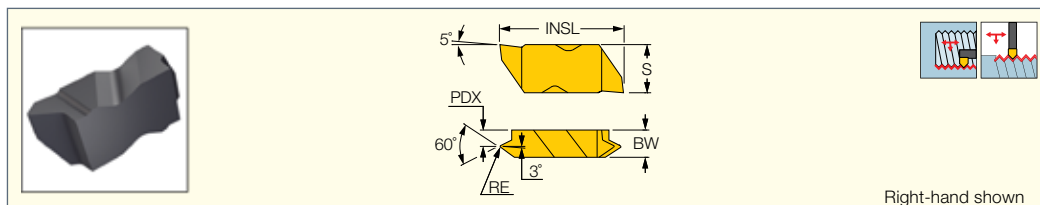
Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLJF-3012R/L14	14.0	.0106	.1409	.195	.344	.890	●
FLJF-3010R/L16	16.0	.0094	.1417	.195	.344	.890	●
FLJF-3009R/L18	18.0	.0083	.1417	.195	.344	.890	●
FLJF-3008R/L20	20.0	.0075	.1417	.195	.344	.890	●
FLJF-3007R/L24	24.0	.0063	.1417	.195	.344	.890	●
FLJF-3006R/L28	28.0	.0055	.1417	.195	.344	.890	●
FLJF-3005R/L32	32.0	.0047	.1417	.195	.344	.890	●

- DMIN according to related boring bar
- <sup>(1)</sup> Threads per inch

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**UNJ THREADING FLJK**  
Double-Ended, Precision  
Threading Inserts, with  
a Positive Rake



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLJK-3012R/L14	14.0	.0106	.1409	.195	.344	.890	●
FLJK-3010R/L16	16.0	.0094	.1417	.195	.344	.890	●
FLJK-3009R/L18	18.0	.0083	.1417	.195	.344	.890	●
FLJK-3008R/L20	20.0	.0075	.1417	.195	.344	.890	●
FLJK-3007R/L24	24.0	.0063	.1417	.195	.344	.890	●
FLJK-3006R/L28	28.0	.0055	.1417	.195	.344	.890	●
FLJK-3005R/L32	32.0	.0047	.1417	.195	.344	.890	●

- DMIN according to related boring bar
- <sup>(1)</sup> Threads per inch

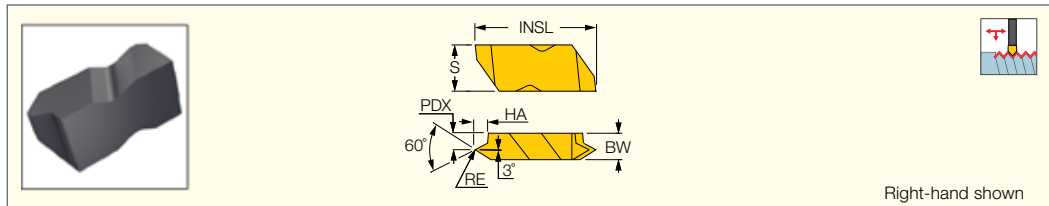


**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**UN THREADING FLTC-E**

Double-Ended, Precision, Flat  
Top Full Profile Threading Inserts



Designation	Dimensions							IC908
	TPI <sup>(1)</sup>	RE	HA	PDX	BW	S	INSL	
FLTC-3R/L7E	7.0	.0169	.108	.1063	.195	.344	.890	•
FLTC-3R/L8E	8.0	.0150	.094	.1063	.195	.344	.890	•
FLTC-3R/L9E	9.0	.0130	.084	.1063	.195	.344	.890	•
FLTC-3R/L10E	10.0	.0118	.076	.1063	.195	.344	.890	•
FLTC-3R/L11E	11.0	.0110	.069	.1063	.195	.344	.890	•
FLTC-3R/L12E	12.0	.0098	.051	.1496	.195	.344	.890	•
FLTC-3R/L14E	14.0	.0091	.054	.1496	.195	.344	.890	•
FLTC-3R/L16E	16.0	.0079	.046	.1496	.195	.344	.890	•
FLTC-3R/L18E	18.0	.0071	.041	.1496	.195	.344	.890	•
FLTC-3R/L20E	20.0	.0059	.037	.1496	.195	.344	.890	•
FLTC-3R/L24E	24.0	.0051	.031	.1496	.195	.344	.890	•
FLTC-3R/L28E	28.0	.0031	.023	.1496	.195	.344	.890	•
FLTC-3R/L32E	32.0	.0031	.021	.1496	.195	.344	.890	•

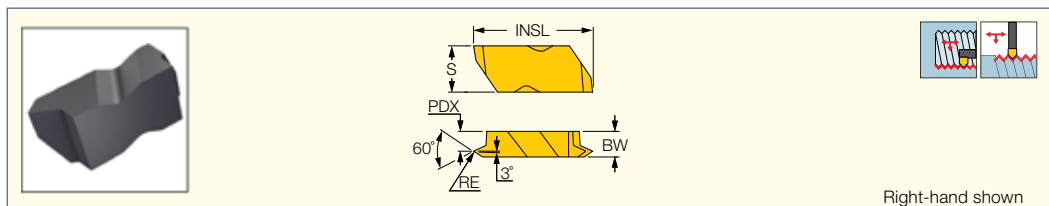
<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**60° PARTIAL PROFILE  
THREADING FLTF**

Double-Ended, Precision  
Flat Top Threading Inserts



Designation	Dimensions										IC908	
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN DF2 <sup>(3)</sup>	TPIX DF2 <sup>(4)</sup>	RE	PDX	BW	S	INSL	TPN_DF2		TPX_DF2
FLTF-3R/L	9.00	24.00	10.00	44.00	.0030	.1417	.195	.344	.890	2.500	1.750	●
FLTF-4R/L	9.00	24.00	10.00	44.00	.0030	.2008	.255	.453	1.120	2.500	1.750	●
FLTF-2R/L	12.00	24.00	14.00	44.00	.0030	.1102	.150	.219	.514	.600	1.750	●

• For 60° V-thread limits, see page • DMIN according to related boring bar

<sup>(1)</sup> TPI int. min.

<sup>(2)</sup> TPI int. max.

<sup>(3)</sup> TPI ext. min.

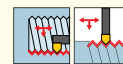
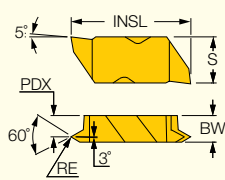
<sup>(4)</sup> TPI ext. max.

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

### 60° PARTIAL PROFILE THREADING FLTK

Double-Ended, Precision Positive  
Rake Threading Inserts



Right-hand shown

Designation	Dimensions										IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN_DF2 <sup>(3)</sup>	TPIX_DF2 <sup>(4)</sup>	RE	TTP	PDX	BW	S	INSL	
FLTK-3R/L	9.00	24.00	10.00	44.00	.0030	BOTH	.1417	.195	.344	.890	●
FLTK-4R/L	9.00	24.00	10.00	44.00	.0030	BOTH	.2008	.255	.453	1.120	●
FLTK-2R/L	12.00	24.00	14.00	44.00	.0030	BOTH	.1102	.150	.219	.514	●

• For 60° V-thread limits, see page • DMIN according to related boring bar

<sup>(1)</sup> TPI int. min.

<sup>(2)</sup> TPI int. max.

<sup>(3)</sup> TPI ext. min.

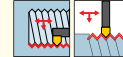
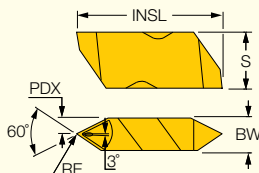
<sup>(4)</sup> TPI ext. max.

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

### 60° PARTIAL PROFILE THREADING FLT-CB

Double-Ended Precision  
Threading Inserts with  
Chipbreakers



Right-hand shown

Designation	Dimensions									IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN_DF2 <sup>(3)</sup>	TPIX_DF2 <sup>(4)</sup>	RE	PDX	BW	S	INSL	
FLT-4R/L-HCB	4.00	12.00	4.00	20.00	.0065	.1299	.255	.453	1.120	●
FLT-3R/LC-HCB	5.00	6.00	6.00	11.00	.0135	.0984	.195	.344	.890	●
FLT-3R/L-HCB	5.00	12.00	6.00	20.00	.0065	.0984	.195	.344	.890	●
FLT-3R/L-FCB	7.00	20.00	8.00	36.00	.0040	.0984	.195	.344	.890	●
FLT-3R/L-CB	8.00	12.00	8.00	20.00	.0065	.0984	.195	.344	.890	●

• DMIN according to related boring bar

<sup>(1)</sup> TPI int. min.

<sup>(2)</sup> TPI int. max.

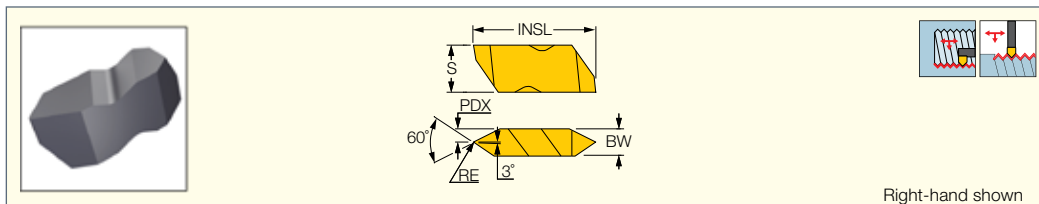
<sup>(3)</sup> TPI ext. min.

<sup>(4)</sup> TPI ext. max.

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**60° PARTIAL PROFILE  
THREADING FLT**  
Double-Ended, Precision  
Flat Top Threading Inserts



Designation	Dimensions									IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN_DF2 <sup>(3)</sup>	TPIX_DF2 <sup>(4)</sup>	RE	PDX	BW	S	INSL	
<b>FLT-4R/L</b>	4.00	12.00	4.00	20.00	.0065	.1299	.255	.453	1.120	●
<b>FLT-3R/L</b>	5.00	12.00	6.00	20.00	.0040	.0984	.195	.344	.890	●
<b>FLT-3010R/L</b>	5.00	12.00	6.00	18.00	.0100	.0984	.195	.344	.890	●
<b>FLT-2R/L</b>	7.00	20.00	8.00	36.00	.0040	.0748	.150	.219	.514	●

• For 60° V-thread limits, see page • DMIN according to related boring bar

<sup>(1)</sup> TPI int. min.

<sup>(2)</sup> TPI int. max.

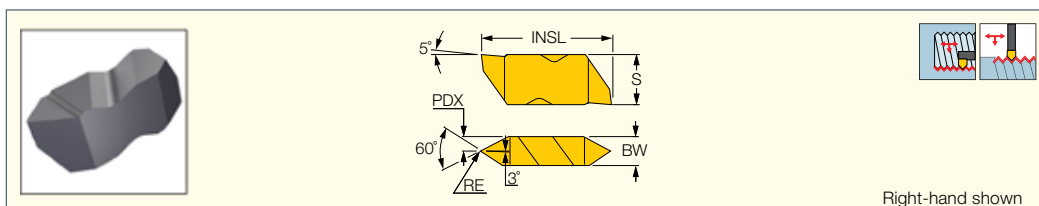
<sup>(3)</sup> TPI ext. min.

<sup>(4)</sup> TPI ext. max.

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**60° PARTIAL PROFILE  
THREADING FLTP**  
Double-Ended, Precision Positive  
Rake Threading Inserts



Designation	Dimensions									IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN_DF2 <sup>(3)</sup>	TPIX_DF2 <sup>(4)</sup>	RE	PDX	BW	S	INSL	
<b>FLTP-4R/L</b>	4.00	12.00	4.00	20.00	.0065	.1299	.256	.453	1.120	●
<b>FLTP-3R/L</b>	5.00	12.00	6.00	20.00	.0065	.0984	.197	.344	.890	●
<b>FLTP-2R/L</b>	7.00	20.00	8.00	36.00	.0040	.0748	.150	.219	.514	●

• For 60° V-thread limits, see page • DMIN according to related boring bar

<sup>(1)</sup> TPI int. min.

<sup>(2)</sup> TPI int. max.

<sup>(3)</sup> TPI ext. min.

<sup>(4)</sup> TPI ext. max.

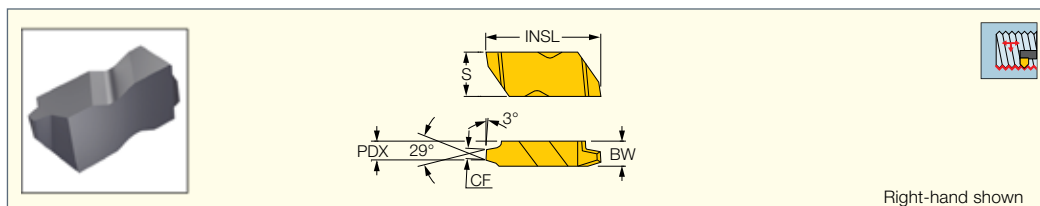
For tools, see pages: A-FLER/L () • FLASR/L (20) • FLSR/L (19) • H-FLER (21) • HS-FLER (22)

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

# **ACME THREADING FLA-PT-I**

Double-Ended Precision Flat  
Top Internal Threading Inserts



Right-hand shown

Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLA-3L16-PT-I	16.0	.020	.1496	.195	.344	.890	•
FLA-3L14-PT-I	14.0	.024	.1496	.195	.344	.890	•
FLA-3L12-PT-I	12.0	.028	.1496	.195	.344	.890	•
FLA-3L10-PT-I	10.0	.032	.1496	.195	.344	.890	•
FLA-3L8-PT-I	8.0	.041	.1496	.195	.344	.890	•
FLA-3L6-PT-I	6.0	.057	.1496	.195	.344	.890	•
FLA-3L5-PT-I	5.0	.069	.1496	.195	.344	.890	•
FLA-3L4-PT-I	4.0	.087	.1339	.195	.344	.890	•
FLA-4L8-PT-I	8.0	.041	.2008	.255	.453	1.120	•
FLA-4L6-PT-I	6.0	.057	.2008	.255	.453	1.120	•
FLA-4L5-PT-I	5.0	.069	.2008	.255	.453	1.120	•
FLA-4L4-PT-I	4.0	.087	.2008	.255	.453	1.120	•
FLA-6L3-PT-I	3.0	.118	.2835	.383	.453	1.120	•
FLA-6L2.5-PT-I	2.5	.143	.2835	.383	.453	1.120	•
FLA-6L2-PT-I	2.0	.180	.2835	.383	.453	1.120	•

• For internal thread limits, see page

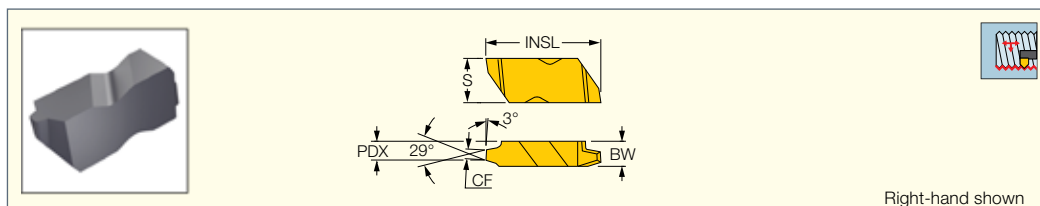
<sup>(1)</sup> Threads per inch

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

# **STUB ACME THREADING FLAS-PT-I**

Double-Ended Precisi Flat Top  
on Internal Threading Inserts



Right-hand shown

Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLAS-6L2-PT-I	2.0	.206	.2835	.383	.453	1.120	•
FLAS-4L3-PT-I	3.0	.135	.2008	.255	.453	1.120	•
FLAS-3L4-PT-I	4.0	.100	.1496	.195	.344	.890	•
FLAS-3L5-PT-I	5.0	.079	.1496	.195	.344	.890	•
FLAS-3L6-PT-I	6.0	.065	.1496	.195	.344	.890	•
FLAS-3L8-PT-I	8.0	.048	.1496	.195	.344	.890	•
FLAS-3L10-PT-I	10.0	.037	.1496	.195	.344	.890	•
FLAS-3L12-PT-I	12.0	.033	.1496	.195	.344	.890	•
FLAS-3L14-PT-I	14.0	.028	.1496	.195	.344	.890	•
FLAS-3L16-PT-I	16.0	.024	.1496	.195	.344	.890	•

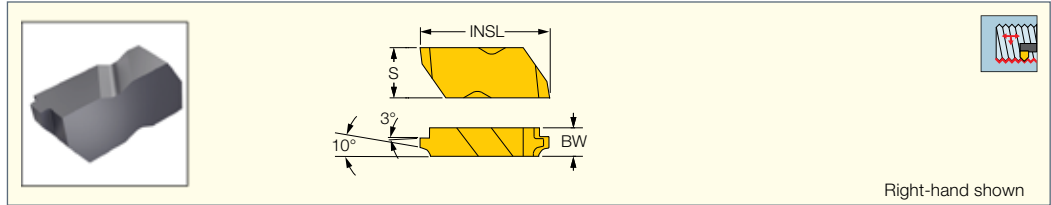
• For internal thread limits, see page

<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API BUTTRESS  
THREADING FLDC-B-I**  
Double-Ended Precision Flat  
Top Threading Inserts



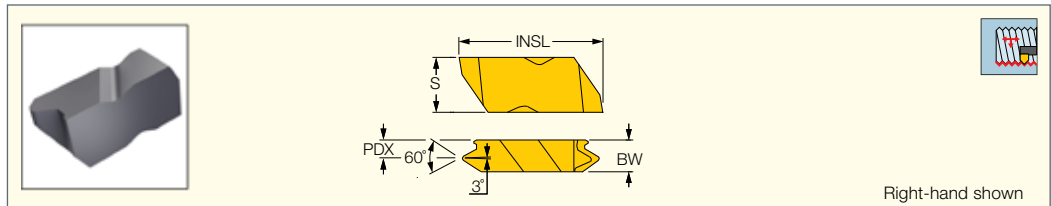
Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	BW	PDX	S	INSL	
FLDC-3-5B1I	5.0	1	.250	.4024	.344	.890	•
FLDC-4-5B1I	5.0	1	.255	.6319	.453	1.120	•
FLDC-3-5B75I	5.0	3/4	.250	.4024	.344	.890	•
FLDC-4-5B75I	5.0	3/4	.255	.6319	.453	1.120	•

<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API THREADING FLDC-I**  
Double-Ended Precision Flat  
Top Threading Inserts



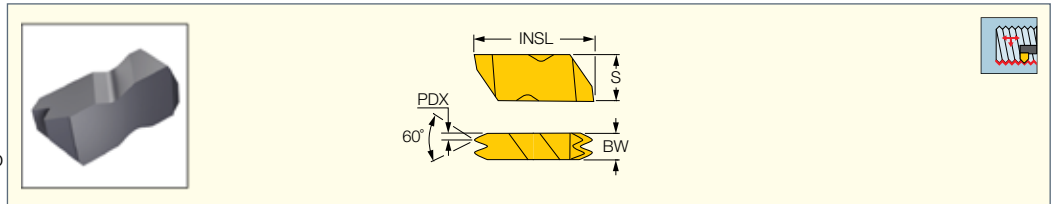
Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-4-425I	4.0	2	.1831	.312	.453	1.120	•
FLDC-4-428I	4.0	2	.1831	.312	.453	1.120	•
FLDC-4-435I	4.0	3	.1831	.312	.453	1.120	•
FLDC-4-438I	4.0	3	.1831	.312	.453	1.120	•
FLDC-3-530I	5.0	3	.1469	.250	.344	.890	•

<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**NPT THREADING FLDC-  
NPT-I**  
Double-Ended, Precision, Flat Top  
Multi-Tooth Threading Inserts



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-3-8NPT-2I	8.0	3/4	.0590	.250	.344	.890	•
FLDC-3-11.5NPT-2I	11.5	3/4	.0472	.250	.344	.890	•

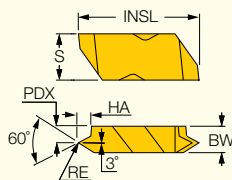
• For internal thread limits, see page

<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**UN THREADING FLTC-I**  
Double-Ended, Precision, Flat  
Top Full Profile Threading Inserts



Right-hand shown

Designation	Dimensions							IC908
	TPI <sup>(1)</sup>	RE	HA	PDX	BW	S	INSL	
FLTC-3R/L7I	7.0	.0091	.092	.1063	.195	.344	.890	●
FLTC-3R/L8I	8.0	.0071	.081	.1063	.195	.344	.890	●
FLTC-3R/L9I	9.0	.0059	.072	.1063	.195	.344	.890	●
FLTC-3R/L10I	10.0	.0051	.065	.1063	.195	.344	.890	●
FLTC-3R/L11I	11.0	.0051	.059	.1063	.195	.344	.890	●
FLTC-3R/L12I	12.0	.0039	.048	.1496	.195	.344	.890	●
FLTC-3R/L14I	14.0	.0031	.044	.1480	.195	.344	.890	●
FLTC-3R/L16I	16.0	.0031	.040	.1480	.195	.344	.890	●
FLTC-3R/L18I	18.0	.0031	.036	.1480	.195	.344	.890	●
FLTC-3R/L20I	20.0	.0031	.031	.1480	.195	.344	.890	●
FLTC-3R/L24I	24.0	.0031	.026	.1480	.195	.344	.890	●
FLTC-3R/L28I	28.0	.0031	.023	.1480	.195	.344	.890	●

• For internal thread limits, see page

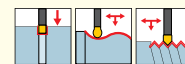
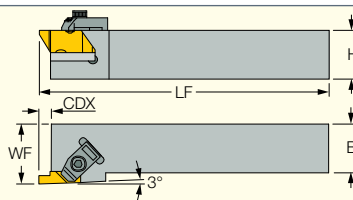
<sup>(1)</sup> Threads per inch

## EXTERNAL TOOLS

**NOTCH GRIP**  
GROOVE-TURN LINE

**FLSR/L**

Tools for External Grooving  
and Threading Inserts



Right-hand shown

Designation	SSC <sup>(1)</sup>	H	B	CDX	WF	LF	Insert
FLSL-62	2.0	.375	.375	.140	.560	2.500	FL/IN_-2L
FLSR-62	2.0	.375	.375	.140	.560	2.500	FL/IN_-2R
FLSL-82V	2.0	.500	.500	.140	.750	3.500	FL/IN_-2L
FLSR-82V	2.0	.500	.500	.140	.750	3.500	FL/IN_-2R
FLSR-102B	2.0	.625	.625	.140	1.000	4.500	FL/IN_-2R
FLSL-122B	2.0	.750	.750	.140	1.000	4.500	FL/IN_-2L
FLSR-122B	2.0	.750	.750	.140	1.000	4.500	FL/IN_-2R
FLSL-162C	2.0	1.000	1.000	.140	1.250	5.000	FL/IN_-2L
FLSR-162C	2.0	1.000	1.000	.140	1.250	5.000	FL/IN_-2R
FLSL-123B	3.0	.750	.750	.210	1.000	4.500	FL/IN_-3L
FLSR-123B	3.0	.750	.750	.210	1.000	4.500	FL/IN_-3R
FLSL-163C	3.0	1.000	1.000	.210	1.250	5.000	FL/IN_-3L
FLSR-163C	3.0	1.000	1.000	.210	1.250	5.000	FL/IN_-3R
FLSL-163D	3.0	1.000	1.000	.210	1.250	6.000	FL/IN_-3L
FLSL-203D	3.0	1.250	1.250	.210	1.500	6.000	FL/IN_-3L
FLSR-203D	3.0	1.250	1.250	.210	1.500	6.000	FL/IN_-3R
FLSL-164D	4.0	1.000	1.000	.290	1.250	6.000	FL/IN_-4L
FLSR-164D	4.0	1.000	1.000	.290	1.250	6.000	FL/IN_-4R
FLSL-204D	4.0	1.250	1.250	.290	1.500	6.000	FL/IN_-4L
FLSR-204D	4.0	1.250	1.250	.290	1.500	6.000	FL/IN_-4R
FLSL-205D	5.0	1.250	1.250	.400	1.500	6.000	FL/IN_-5L
FLSR-205D	5.0	1.250	1.250	.400	1.500	6.000	FL/IN_-5R
FLSL-206D	6.0	1.250	1.250	.290	1.500	6.000	FL/IN_-6L
FLSR-206D	6.0	1.250	1.250	.290	1.500	6.000	FL/IN_-6R

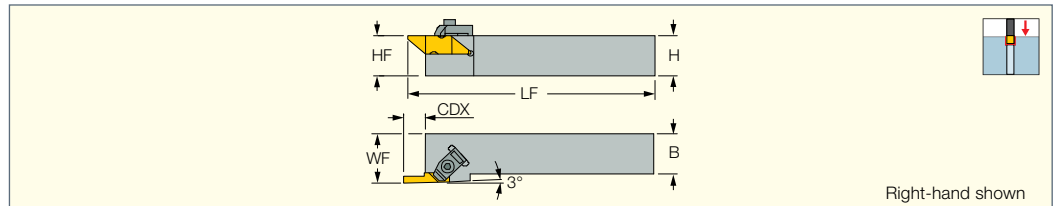
<sup>(1)</sup> Seat size code



**NOTCH-GRIP**  
GROOVE-TURN LINE

**FLSR/LT**

External Tools for Deep  
Grooving Inserts



Designation	SSC <sup>(1)</sup>	H	HF	B	CDX	WF	LF	Insert
FLSLT-163D	3.0	1.000	1.000	1.000	.440	1.250	6.440	INGT-3L
FLSRT-163D	3.0	1.000	1.000	1.000	.440	1.250	6.440	INGT-3R
FLSLT-203D	3.0	1.250	1.250	1.250	.440	1.500	6.440	INGT-3L
FLSRT-203D	3.0	1.250	1.250	1.250	.440	1.500	6.440	INGT-3R
FLSLT-164D	4.0	1.000	1.000	1.000	.560	1.250	6.560	INGT-4L
FLSRT-164D	4.0	1.000	1.000	1.000	.560	1.250	6.560	INGT-4R
FLSLT-204D	4.0	1.250	1.250	1.250	.560	1.500	6.560	INGT-4L
FLSRT-204D	4.0	1.250	1.250	1.250	.560	1.500	6.560	INGT-4R

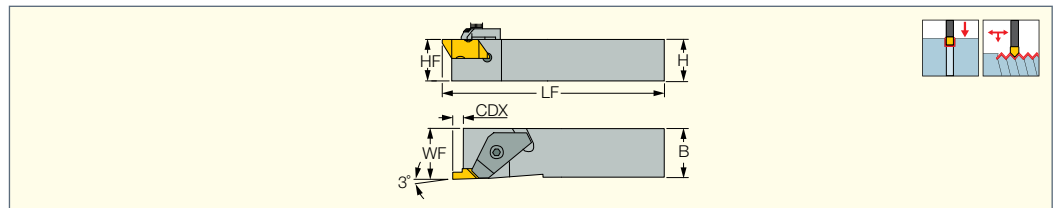
<sup>(1)</sup> Seat size code

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**FLASR/L**

External Tools for Grooving  
and Threading for Swiss-  
type Machines



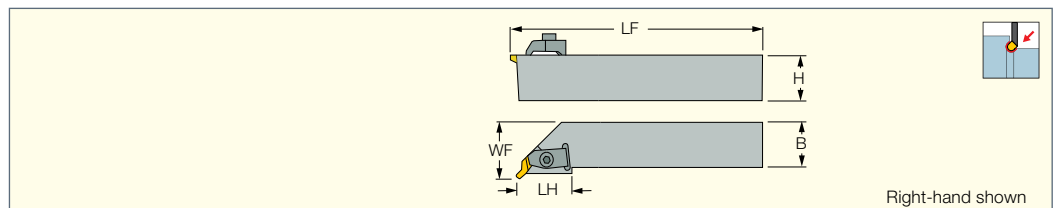
Designation	SSC <sup>(1)</sup>	H	HF	B	CDX	WF	LF	Insert
FLASR/L-062D	2.0	.375	.375	.375	.138	.380	6.000	FL/IN_-2
FLASR/L-082D	2.0	.500	.500	.500	.138	.500	6.000	FL/IN_-2
FLASR-102B	2.0	.625	.625	.625	.138	.630	4.500	FL/IN_-2
FLASR/L-103B	3.0	.625	.625	.625	.210	.630	4.500	FL/IN_-3

<sup>(1)</sup> Seat size code

**NOTCH-GRIP**  
GROOVE-TURN LINE

**FLRR/L**

External Tools for 45°  
Undercutting



Designation	SSC <sup>(1)</sup>	H	HF	B	WF	LH	LF	Insert
FLRR-123B	3.0	.750	.000	.750	1.000	1.250	4.500	INU-3
FLRR/L-163D	3.0	1.000	.000	1.000	1.250	1.250	6.000	INU-3
FLRR-203D	3.0	1.250	.000	1.250	1.500	1.250	6.000	INU-3

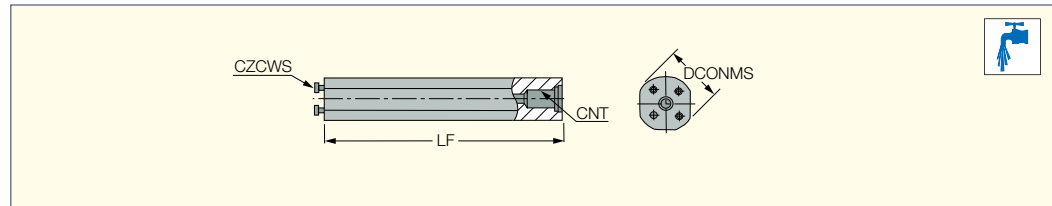
<sup>(1)</sup> Seat size code



## Straight Shank

### S-570

Steel Shanks with Through  
Coolant for HS-Type  
Interchangeable Heads



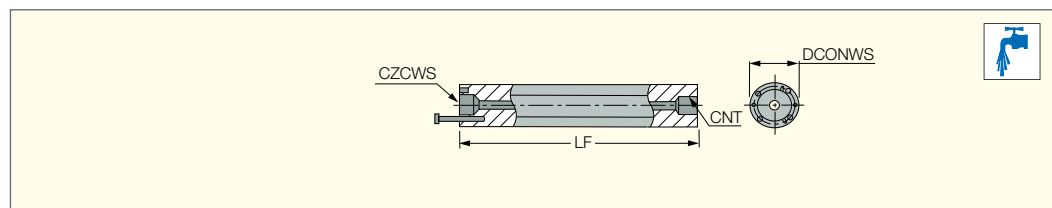
Designation	DCONMS	LF	CZCWS <sup>(1)</sup>	CNT
S-570-10-16	.625	4.21	HS16	1/8 - 27NPT
S-570-12-20	.750	5.20	HS20	1/4 - 18NPT
S-570-16-25	1.000	7.20	HS25	1/4 - 18NPT
S-570-20-32	1.250	8.74	HS32	3/8 - 18NPT
S-570-24-40	1.500	10.75	HS40	1/2 - 14NPT
S-570-32-50	2.000	14.41	HS50	1/2 - 14NPT

<sup>(1)</sup> Connection size code workpiece side

## Straight Shank

### S-4400W

Steel Shanks with Through  
Coolant for H-Type  
Interchangeable Heads



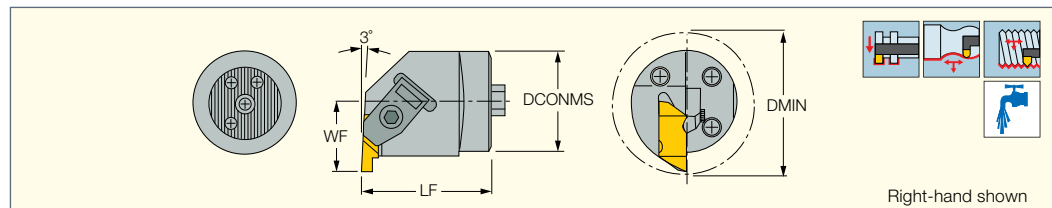
Designation	DCONWS	LF	CZCWS <sup>(1)</sup>	CNT
S-4416W	1.000	9.00	H16	1/4-18NPT
S-4424W	1.500	10.00	H24	3/8-18NPT
S-4428W	1.750	12.00	H28	3/8-18NPT
S-4432W	2.000	13.00	H32	3/8-18NPT
S-4440W	2.500	17.00	H40	3/8-18NPT

<sup>(1)</sup> Connection size code workpiece side

## NOTCH GRIP

### HS-FLER

Grooving and Threading  
Interchangeable Heads (HS-Type)



Designation	SSC <sup>(1)</sup>	DCONMS	DMIN	WF	LF	Insert
HS32-FLER3W	3.0	1.250	1.73	.870	1.34	FL/IN-3L
HS40-FLER3W	3.0	1.570	2.21	1.100	1.58	FL/IN-3L
HS50-FLER3W	3.0	1.970	2.76	1.380	1.65	FL/IN-3L
HS50-FLER4W	4.0	1.970	2.76	1.380	1.65	FL/IN-4L
HS60-FLER4W	4.0	2.360	3.48	1.740	1.75	FL/IN-4L

• Left-hand heads on request • Use left-hand inserts on right-hand tools and vice versa • Compatible with standard market adaptation

<sup>(1)</sup> Seat size code

# Metric Measurements

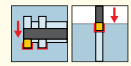
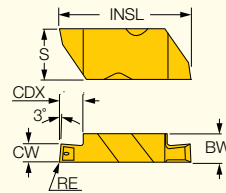
**NOTCH-GRIP**  
GROOVE-TURN LINE



**NOTCH GRIP**  
GROOVE-TURN LINE

**ING-RCB/LCB**

Precision Double-Ended Grooving  
Inserts with a Chipformer



Right-hand shown

Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL		
ING3031LCB (0.79)	0.79	0.025	0.09	0.031	1.27	4.95	8.74	22.60	●	0.03-0.05
ING3031RCB (0.79)	0.79	0.025	0.09	0.063	1.27	4.95	8.74	22.60	●	0.03-0.05
ING2M100R/LCB (1.00)	1.00	0.025	0.19	0.063	1.27	3.81	5.56	12.95	●	0.04-0.06
ING3M100R/LCB (1.00)	1.00	0.025	0.19	0.063	1.90	4.95	8.74	22.60	●	0.04-0.06
ING3M120R/LCB (1.20)	1.20	0.025	0.19	0.063	1.90	4.95	8.74	22.60	●	0.04-0.06
ING3047R/LCB (1.19)	1.19	0.025	0.19	0.063	1.90	4.95	8.74	22.60	●	0.04-0.06
ING2M150R/LCB (1.50)	1.50	0.025	0.19	0.063	2.79	3.81	5.56	12.95	●	0.05-0.08
ING3M150R/LCB (1.50)	1.50	0.025	0.19	0.063	3.05	4.95	8.74	22.60	●	0.05-0.08
ING2062R/LCB (1.57)	1.57	0.025	0.19	0.063	2.79	3.81	5.56	12.95	●	0.05-0.08
ING3062R/LCB (1.57)	1.57	0.025	0.19	0.063	3.05	4.95	8.74	22.60	●	0.05-0.08
ING3M175R/LCB (1.75)	1.75	0.025	0.19	0.063	3.05	4.95	8.74	22.60	●	0.05-0.09
ING3072R/LCB (1.83)	1.83	0.025	0.19	0.063	3.05	4.95	8.74	22.60	●	0.05-0.09
ING3078R/LCB (1.98)	1.98	0.025	0.19	0.063	3.05	4.95	8.74	22.60	●	0.05-0.10
ING2M200R/LCB (2.00)	2.00	0.025	0.19	0.063	2.79	3.81	5.56	12.95	●	0.05-0.10
ING3M200R/LCB (2.00)	2.00	0.025	0.19	0.063	3.05	4.95	8.74	22.60	●	0.05-0.10
ING2094R/LCB (2.39)	2.39	0.025	0.19	0.063	2.79	3.81	5.56	12.95	●	0.06-0.10
ING3094R/LCB (2.39)	2.39	0.025	0.19	0.063	4.57	4.95	8.74	22.60	●	0.06-0.10
ING3M250R/LCB (2.50)	2.50	0.025	0.19	0.063	4.57	4.95	8.74	22.60	●	0.06-0.10
ING3M300R/LCB (3.00)	3.00	0.025	0.19	0.063	4.57	4.95	8.74	22.60	●	0.09-0.14
ING2125R/LCB (3.18)	3.18	0.025	0.19	0.063	2.79	3.81	5.56	12.95	●	0.09-0.14
ING3125R/LCB (3.18)	3.18	0.025	0.19	0.063	4.57	4.95	8.74	22.60	●	0.09-0.14
ING4125R/LCB (3.18)	3.18	0.025	0.19	0.063	6.35	6.48	11.51	28.45	●	0.09-0.14
ING3M400R/LCB (4.00)	4.00	0.025	0.32	0.063	4.57	4.95	8.74	22.60	●	0.12-0.20
ING3189R/LCB (4.80)	4.80	0.025	0.57	0.063	4.57	4.95	8.74	22.60	●	0.12-0.22
ING4189R/LCB (4.80)	4.80	0.025	0.57	0.063	6.35	6.48	11.51	28.45	●	0.12-0.22
ING4250R/LCB (6.35)	6.35	0.025	0.57	0.063	6.35	6.48	11.51	28.45	●	0.12-0.25

• DMIN according to related boring bar

<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

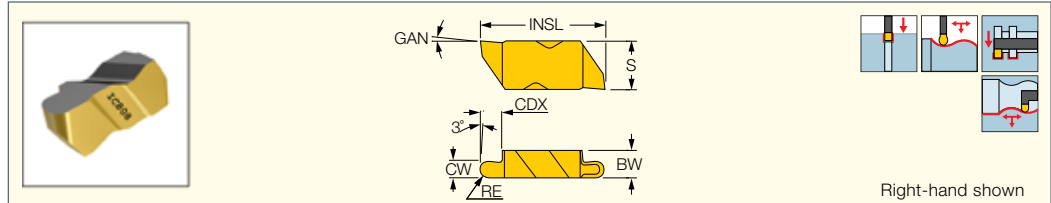




**NOTCH GRIP**  
GROOVE-TURN LINE

**INR/INRP-R/L**

Precision Double-Ended Flat  
Top Round Grooving Inserts



Designation	Dimensions									Tough ↔ Hard		Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL	GAN	IC808	IC807	
<b>INR2031R/L (1.57)</b>	1.57	0.025	0.78	0.064	2.79	3.81	5.56	12.95	0		●	0.03-0.05
<b>INRP3031R/L (1.57)</b>	1.57	0.025	0.78	0.064	3.18	4.95	8.74	22.60	5		●	0.03-0.05
<b>INR3031R/L (1.58)</b>	1.58	0.025	0.79	0.064	3.17	4.95	8.65	22.60	0	●		0.04-0.08
<b>INR2047R/L (2.39)</b>	2.39	0.025	1.19	0.064	2.79	3.81	5.56	12.95	0		●	0.04-0.07
<b>INRP3047R/L (2.39)</b>	2.39	0.025	1.19	0.064	4.57	4.95	8.74	22.60	5		●	0.04-0.07
<b>INR3047R/L (2.39)</b>	2.39	0.025	1.19	0.064	3.81	4.95	8.65	22.60	0	●		0.06-0.12
<b>INRP3062R/L (3.18)</b>	3.18	0.025	1.57	0.064	4.57	4.95	8.74	22.60	5		●	0.07-0.11
<b>INR3062R/L (3.18)</b>	3.18	0.025	1.59	0.064	3.81	4.95	8.65	22.60	0	●		0.08-0.16
<b>INR3078R/L (3.98)</b>	3.96	0.025	1.98	0.064	3.81	4.95	8.65	22.60	0	●		0.10-0.20
<b>INR3094R/L (4.78)</b>	4.78	0.025	2.39	0.064	3.81	4.95	8.65	22.60	0	●		0.12-0.22
<b>INR4125R/L (6.35)</b>	6.35	0.025	3.18	0.064	6.35	6.48	11.51	28.45	0		●	0.10-0.22

• DMIN according to related boring bar

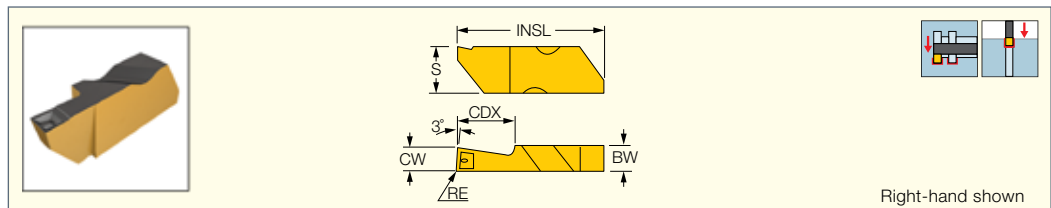
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

**NOTCH GRIP**  
GROOVE-TURN LINE

**INGD-RCB/LCB**

Precision, Single-Ended  
Deep Grooving Inserts  
with a Chipformer



Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL		f groove (mm/rev)
INGD3094R/LCB (2.39)	2.39	0.025	0.19	0.063	6.35	4.95	8.74	25.15	●	0.06-0.10
INGD3125R/LCB (3.18)	3.18	0.025	0.19	0.063	6.35	4.95	8.74	25.15	●	0.09-0.14

• DMIN according to related boring bar

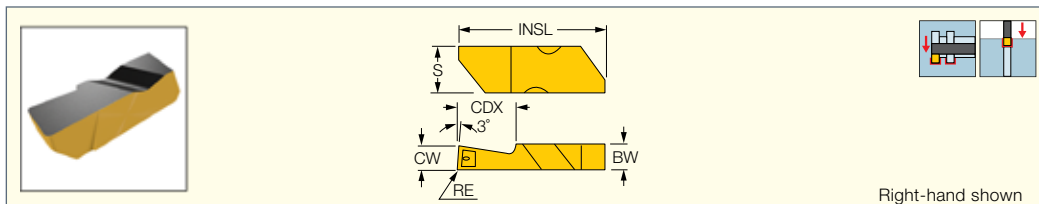
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

**NOTCH GRIP**  
GROOVE-TURN LINE

**INGD-R/L**

Precision, Single-Ended Flat  
Top Deep Grooving Inserts



Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INS L		
INGD3062R/L (1.57)	1.57	0.025	0.19	0.063	3.05	4.95	8.74	25.15	●	f groove (mm/rev) 0.04-0.06
INGD3094R/L (2.39)	2.39	0.025	0.19	0.063	6.35	4.95	8.74	25.15	●	0.05-0.08
INGD3125R/L (3.18)	3.18	0.025	0.19	0.063	6.35	4.95	8.74	25.15	●	0.08-0.12
INGD3189R/L (4.80)	4.80	0.025	0.57	0.063	6.35	4.95	8.74	25.15	●	0.10-0.20

• DMIN according to related boring bar

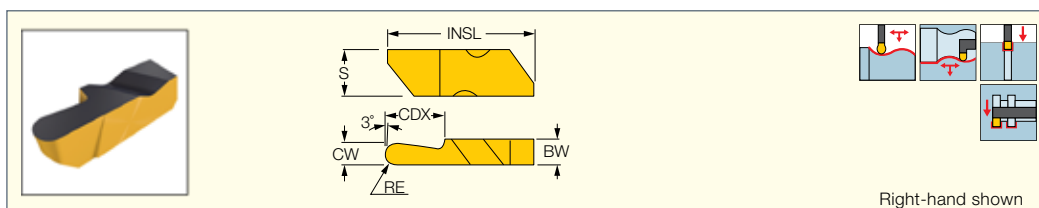
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

**NOTCH GRIP**  
GROOVE-TURN LINE

**INRD-R/L**

Precision, Single-Ended  
Full Radius Deep Grooving  
Inserts with a Flat Rake



Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INS L		
INRD3062R/L (3.18)	3.18	0.025	1.57	0.064	6.35	4.95	8.74	25.15	●	f groove (mm/rev) 0.07-0.11

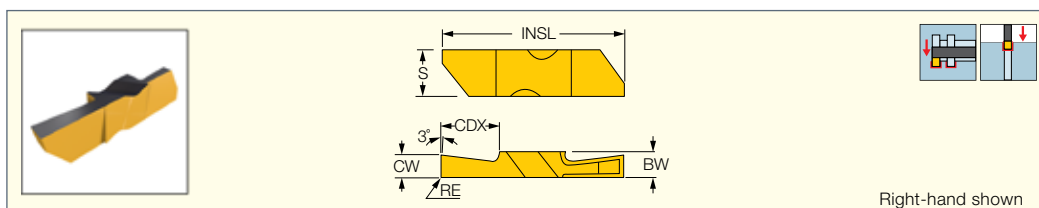
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

**NOTCH GRIP**  
GROOVE-TURN LINE

**INGT-R/L**

Precision, Double-Ended Flat  
Top Deep Grooving Inserts



Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INS L		
INGT3094R/L (2.39)	2.39	0.025	0.19	0.063	6.99	4.95	8.74	34.80	●	f groove (mm/rev) 0.05-0.08
INGT3125R/L (3.18)	3.18	0.025	0.19	0.063	11.10	4.95	8.74	34.80	●	0.08-0.12

• DMIN according to related boring bar

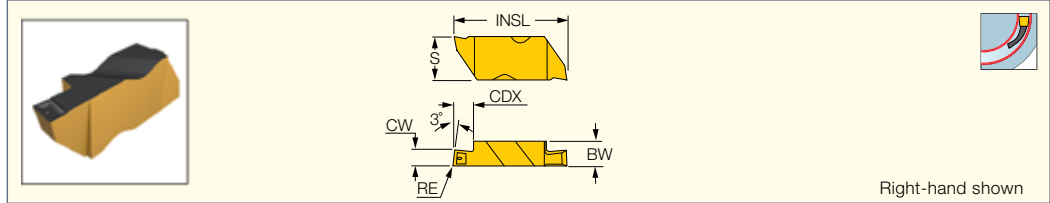
<sup>(1)</sup> Cutting width tolerance (+/-)

<sup>(2)</sup> Corner radius tolerance (+/-)

**NOTCH-GRIP**  
GROOVE-TURN LINE

**INF-RCB/LCB**

Precision, Double-Ended  
Face Grooving Inserts  
with a Chipformer



Designation	Dimensions										Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	DAXN <sup>(3)</sup>	BW	S	INSL	IC807	f face-groove (mm/rev)
<b>INF3125R/LCB (3.18)</b>	3.18	0.025	0.19	0.063	4.57	23.9	4.95	8.74	22.60	●	0.09-0.14

<sup>(1)</sup> Cutting width tolerance (+/-)

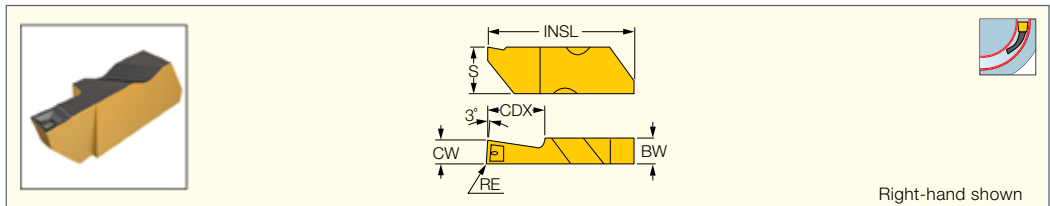
<sup>(2)</sup> Corner radius tolerance (+/-)

<sup>(3)</sup> Minimum axial grooving diameter

**NOTCH-GRIP**  
GROOVE-TURN LINE

**INF-RCB/LCB**

Precision, Single-Ended  
Deep Face Grooving Inserts  
with a Chipformer



Designation	Dimensions										Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	DAXN <sup>(3)</sup>	BW	S	INSL	IC807	f face-groove (mm/rev)
<b>INF3125R/LCB (3.18)</b>	3.18	0.025	0.19	0.063	6.35	47.6	4.95	8.74	25.15	●	0.09-0.14

<sup>(1)</sup> Cutting width tolerance (+/-)

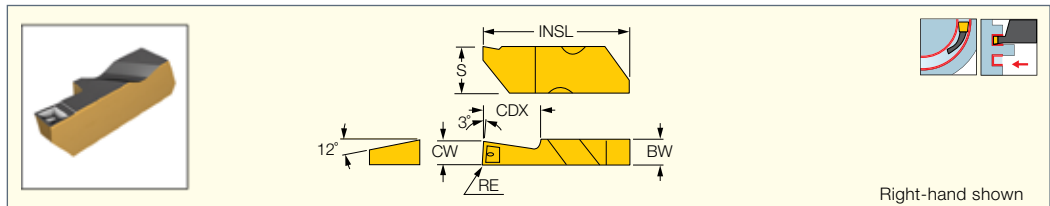
<sup>(2)</sup> Corner radius tolerance (+/-)

<sup>(3)</sup> Minimum axial grooving diameter

**NOTCH-GRIP**  
GROOVE-TURN LINE

**INF-RCB/LCB-I**

Precision, Single-Ended  
Deep Face Grooving Inserts  
with a Chipformer



Designation	Dimensions										Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	DAXN <sup>(3)</sup>	BW	S	INSL	IC807	f face-groove (mm/rev)
<b>INF3125R/LCB-I(3.18)</b>	3.18	0.025	0.19	0.063	6.35	47.6	4.95	8.74	25.15	●	0.09-0.14

<sup>(1)</sup> Cutting width tolerance (+/-)

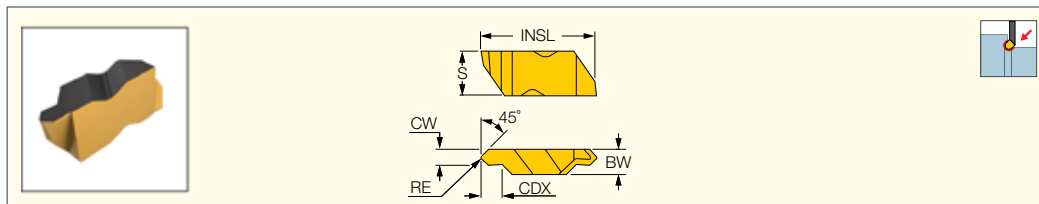
<sup>(2)</sup> Corner radius tolerance (+/-)

<sup>(3)</sup> Minimum axial grooving diameter

# NOTCH GRIP

## INU-R/L

Precision Double-Ended Flat Top  
Inserts for External Undercutting



Designation	Dimensions								IC807	Recommended Machining Data
	CW	CWTOL <sup>(1)</sup>	RE	RETOL <sup>(2)</sup>	CDX	BW	S	INSL		
INU3094R/L (2.39)	2.39	0.025	0.51	0.064	3.18	4.95	8.74	22.60	●	f groove (mm/rev) 0.05-0.08

• Not recommended for turning • DMIN according to related boring bar

<sup>(1)</sup> Cutting width tolerance (+/-)

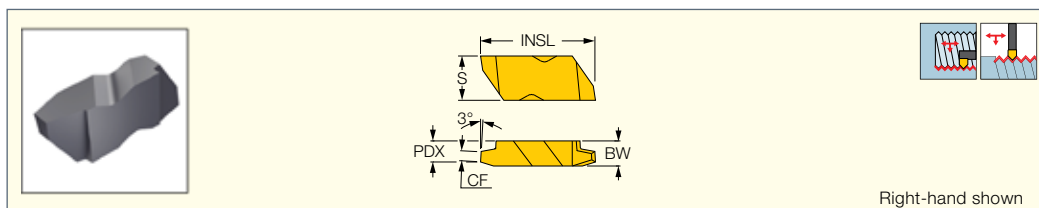
<sup>(2)</sup> Corner radius tolerance (+/-)

# ISCAR THREAD

## ISCAR THREAD

### ACME THREADING FLA

Double-Ended Precision Flat  
Top Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLA-6R/L2	2.0	4.58	7.20	9.73	11.51	28.45	●
FLA-6R/L2.5	2.5	3.63	7.20	9.73	11.51	28.45	●
FLA-6R/L3	3.0	3.01	7.20	9.73	11.51	28.45	●
FLA-3R/L4	4.0	2.22	3.40	4.95	8.74	22.60	●
FLA-4R/L4	4.0	2.22	5.10	6.48	11.51	28.45	●
FLA-3R/L5	5.0	1.75	3.80	4.95	8.74	22.60	●
FLA-4R/L5	5.0	1.75	5.10	6.48	11.51	28.45	●
FLA-3R/L6	6.0	1.44	3.80	4.95	8.74	22.60	●
FLA-4R/L6	6.0	1.44	5.10	6.48	11.51	28.45	●
FLA-3R/L8	8.0	1.04	3.80	4.95	8.74	22.60	●
FLA-4R/L8	8.0	1.04	5.10	6.48	11.51	28.45	●
FLA-3R/L10	10.0	0.81	3.80	4.95	8.74	22.60	●
FLA-3R/L12	12.0	0.72	3.80	4.95	8.74	22.60	●
FLA-3R/L14	14.0	0.61	3.80	4.95	8.74	22.60	●
FLA-3R/L16	16.0	0.52	3.80	4.95	8.74	22.60	●

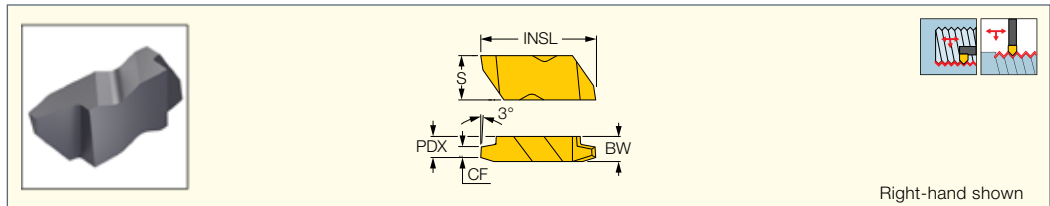
• For ACME thread limits, see page • DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**ACME THREADING FLAS**  
Double-Ended Precision Flat  
Top Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLAS-6R/L2	2.0	5.23	7.20	9.73	11.51	28.45	●
FLAS-4R/L3	3.0	3.44	5.10	6.48	11.51	28.45	●
FLAS-3L4	4.0	2.55	3.80	4.95	8.74	22.60	●
FLAS-3R/L5	5.0	2.01	3.80	4.95	8.74	22.60	●
FLAS-3R/L6	6.0	1.66	3.80	4.95	8.74	22.60	●
FLAS-3R/L8	8.0	1.21	3.80	4.95	8.74	22.60	●
FLAS-3R/L10	10.0	0.94	3.80	4.95	8.74	22.60	●
FLAS-3R/L12	12.0	0.83	3.80	4.95	8.74	22.60	●
FLAS-3R/L14	14.0	0.70	3.80	4.95	8.74	22.60	●
FLAS-3R/L16	16.0	0.60	3.80	4.95	8.74	22.60	●

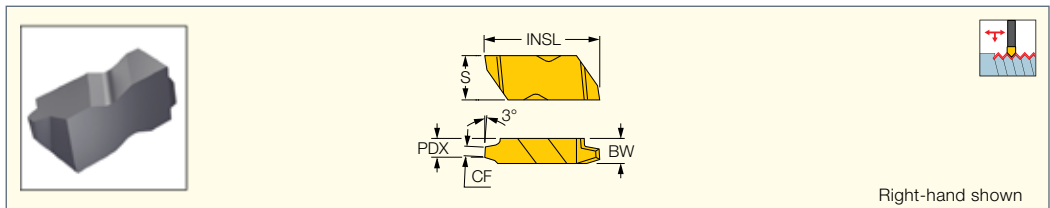
• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**ACME THREADING FLA-PT-E**  
Double-Ended Precision Flat  
Top External Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLA-3R4-PT-E	4.0	2.22	3.40	4.95	8.74	28.45	●
FLA-3R5-PT-E	5.0	1.75	3.80	4.95	8.74	28.45	●
FLA-3R6-PT-E	6.0	1.44	3.80	4.95	8.74	22.60	●
FLA-3R8-PT-E	8.0	1.04	3.80	4.95	8.74	28.45	●
FLA-3R10-PT-E	10.0	0.81	3.80	4.95	8.74	22.60	●
FLA-3R12-PT-E	12.0	0.72	3.80	4.95	8.74	22.60	●
FLA-3R14-PT-E	14.0	0.61	3.80	4.95	8.74	22.60	●
FLA-3R16-PT-E	16.0	0.52	3.80	4.95	8.74	22.60	●
FLA-4R4-PT-E	4.0	2.22	5.10	6.48	11.51	28.45	●
FLA-4R5-PT-E	5.0	1.75	5.10	6.48	11.51	22.60	●
FLA-4R6-PT-E	6.0	1.44	5.10	6.48	11.51	28.45	●
FLA-4R8-PT-E	8.0	1.04	5.10	6.48	11.51	22.60	●
FLA-6R2-PT-E	2.0	4.58	7.20	9.73	11.51	28.45	●
FLA-6R2.5-PT-E	2.5	3.63	7.20	9.73	11.51	28.45	●
FLA-6R3-PT-E	3.0	3.01	7.20	9.73	11.51	28.45	●

<sup>(1)</sup> Threads per inch

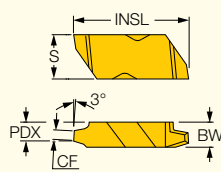
**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**STUB ACME THREADING**

**FLAS-PT-E**

Double-Ended Precision Flat Top External Threading Inserts



Right-hand shown

Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLAS-3R4-PT-E	4.0	2.55	3.80	4.95	8.74	22.60	●
FLAS-3R5-PT-E	5.0	2.01	3.80	4.95	8.74	22.60	●
FLAS-3R6-PT-E	6.0	1.66	3.80	4.95	8.74	22.60	●
FLAS-3R8-PT-E	8.0	1.21	3.80	4.95	8.74	22.60	●
FLAS-3R10-PT-E	10.0	0.94	3.80	4.95	8.74	22.60	●
FLAS-3R12-PT-E	12.0	0.83	3.80	4.95	8.74	22.60	●
FLAS-3R14-PT-E	14.0	0.70	3.80	4.95	8.74	22.60	●
FLAS-3R16-PT-E	16.0	0.60	3.80	4.95	8.74	22.60	●
FLAS-4R3-PT-E	3.0	3.44	5.10	6.48	11.51	28.45	●
FLAS-6R2-PT-E	2.0	5.23	7.20	9.73	11.51	28.45	●

<sup>(1)</sup> Threads per inch

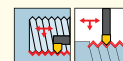
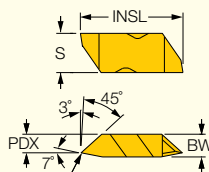
**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**AMERICAN STANDARD BUTTRESS THREADING**

**FLT-B-A**

Double-Ended Precision Flat Top Threading Inserts for 7° Lead



Right-hand shown

Designation	Dimensions							IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	RE	PDX	BW	S	INSL	
FLT-B-4R/LA	4.00	6.00	0.20	5.20	6.48	11.51	28.45	•
FLT-B-3R/LA	8.00	16.00	0.13	4.20	4.95	8.74	22.60	•
FLT-B-2R/LA	16.00	20.00	0.05	3.20	3.81	5.56	12.95	•

• For user guide, see page • DMIN according to related boring bar

<sup>(1)</sup> TPI min.

<sup>(2)</sup> TPI max.

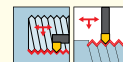
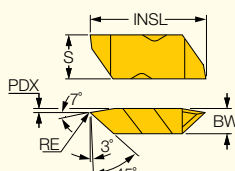
**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**AMERICAN STANDARD BUTTRESS THREADING**

**FLT-B-B**

Double-Ended Precision Flat Top Threading Inserts for 45° Lead



Left-hand shown

Designation	Dimensions							IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	RE	PDX	BW	S	INSL	
FLT-B-4R/LB	4.00	6.00	0.20	0.40	6.48	11.51	28.45	•
FLT-B-3R/LB	8.00	16.00	0.13	0.30	4.95	8.74	22.60	•
FLT-B-2R/LB	16.00	20.00	0.05	0.30	3.81	5.56	12.95	•

• For user guide, see page • DMIN according to related boring bar

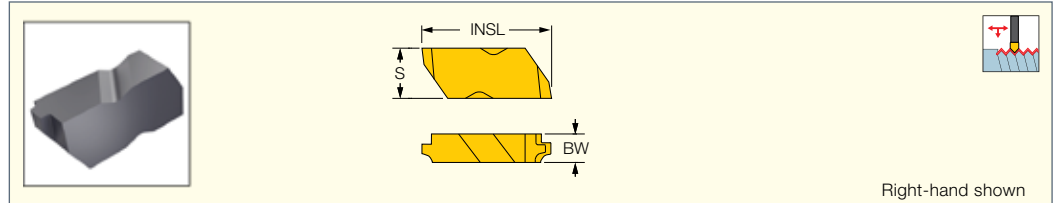
<sup>(1)</sup> TPI min.

<sup>(2)</sup> TPI max.

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API BUTTRESS  
THREADING FLDC-B-E**  
Double-Ended Precision Flat  
Top Threading Inserts



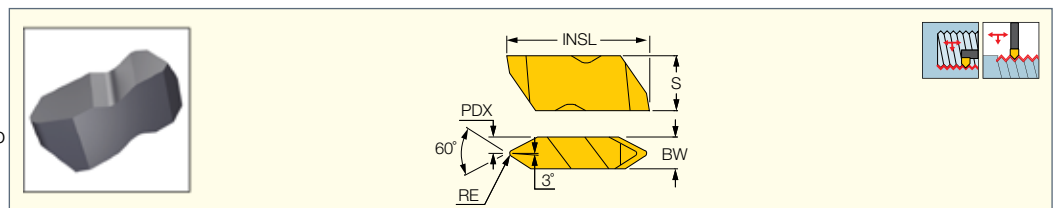
Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	BW	S	INSL		
FLDC-3-5B1E	5.0	1	6.35	8.74	22.60		•
FLDC-4-5B1E	5.0	1	6.48	11.51	28.45		•
FLDC-3-5B75E	5.0	3/4	6.35	8.74	22.60		•
FLDC-4-5B75E	5.0	3/4	6.48	11.51	28.45		•

<sup>(1)</sup> Threads per inch

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**PARTIAL PROFILE  
THREDDING FLD**  
Double-Ended, Precision, Flat Top  
Partial Profile Threading Inserts



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLD-4050R/L	4.0	0.51	3.25	6.48	11.51	28.45	•
FLD-3038R/L	4.0	0.84	2.08	4.95	8.74	22.60	•
FLD-4038R/L	4.0	0.84	3.25	6.48	11.51	28.45	•
FLD-3040R/L	5.0	0.38	2.08	4.95	8.74	22.60	•
FLD-4040R/L	5.0	0.38	3.25	6.48	11.51	28.45	•

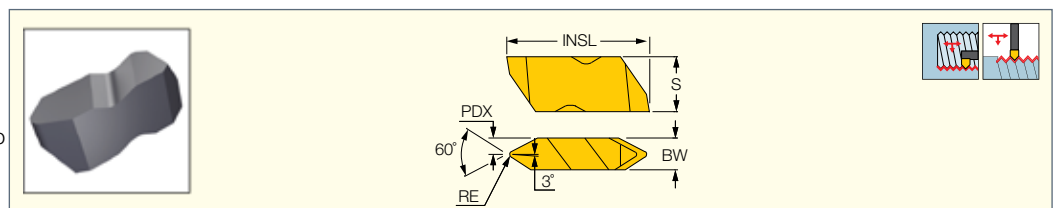
• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**PARTIAL PROFILE  
THREDDING FLD**  
Double-Ended, Precision, Flat Top  
Partial Profile Threading Inserts



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLD-4050R/L	4.0	0.51	3.25	6.48	11.51	28.45	•
FLD-3038R/L	4.0	0.84	2.08	4.95	8.74	22.60	•
FLD-4038R/L	4.0	0.84	3.25	6.48	11.51	28.45	•
FLD-3040R/L	5.0	0.38	2.08	4.95	8.74	22.60	•
FLD-4040R/L	5.0	0.38	3.25	6.48	11.51	28.45	•

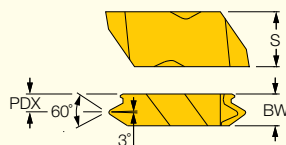
• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API THREADING FLDC-E**  
Double-Ended Precision Flat  
Top Threading Inserts



Right-hand shown

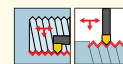
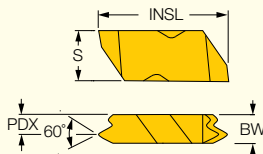
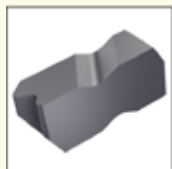
Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-4-425E	4.0	2	4.65	7.92	11.51	28.45	•
FLDC-4-428E	4.0	2	4.65	7.92	11.51	28.45	•
FLDC-4-435E	4.0	3	4.65	7.92	11.51	28.45	•
FLDC-4-438E	4.0	3	4.65	7.92	11.51	28.45	•
FLDC-3-530E	5.0	3	3.73	6.35	8.74	22.60	•

<sup>(1)</sup> Threads per inch

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API ROUND THREADING  
FLDC-RD-75**  
Double-Ended Precision Flat  
Top Threading Inserts



Right-hand shown

Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-3-8RDR/L75	8.0	3/4	5.00	3.18	8.74	22.60	•
FLDC-3-10RDR/L75	10.0	3/4	5.00	3.18	8.74	22.60	•

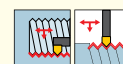
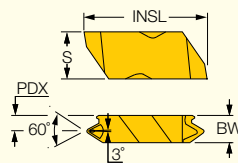
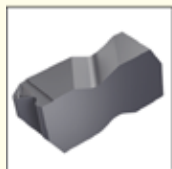
• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API ROUND THREADING  
FLDC-RD-75-CB**  
Double-Ended, Precision  
Threading Inserts with  
a Chipbreaker



Right-hand shown

Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-3-8RDR/L75-CB	8.0	3/4	4.95	3.18	8.74	25.15	•

• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

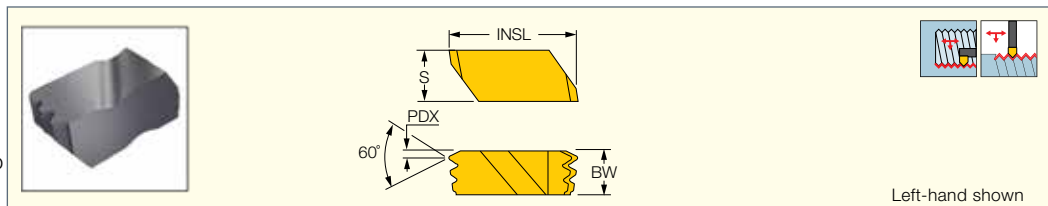


**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API ROUND THREADING  
FLDC-RD-75M**

Double-Ended, Precision, Flat Top  
Multi-Tooth Threading Inserts,



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-6-8RDR75	8.0	3/4	1.80	9.73	11.51	28.45	
FLDC-6-10RDR75	10.0	3/4	3.40	9.73	11.51	28.45	•

• DMIN according to related boring bar

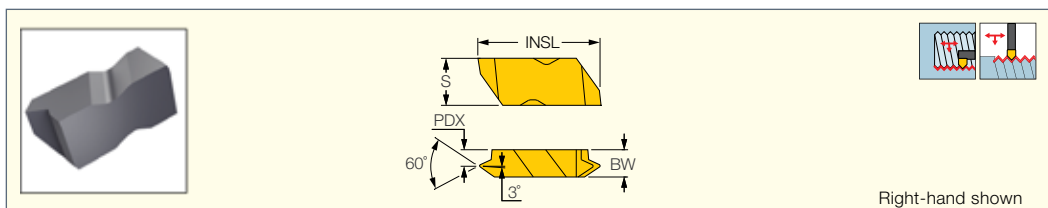
<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**NPT THREADING  
FLDC-V-75**

Double-Ended Precision Flat  
Top Threading Inserts



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-3-8VR/L75	8.0	3/4	2.50	4.95	8.74	22.60	
FLDC-3-115VR/L75	11.5	3/4	3.70	4.95	8.74	22.60	•
FLDC-3-14VR/L-75	14.0	3/4	3.80	4.95	8.74	22.60	•
FLDC-3-18VR/L-75	18.0	3/4	3.90	4.95	8.74	22.60	•
FLDC-3-27VR/L-75	27.0	3/4	4.10	4.95	8.74	22.60	•

• DMIN according to related boring bar

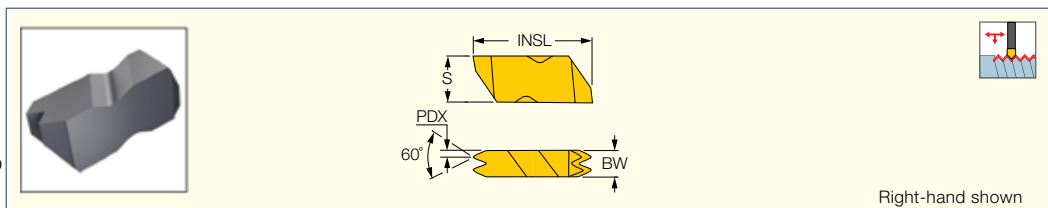
<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**NPT THREADING FLDC-  
NPT-E**

Double-Ended, Precision, Flat Top  
Multi-Tooth Threading Inserts



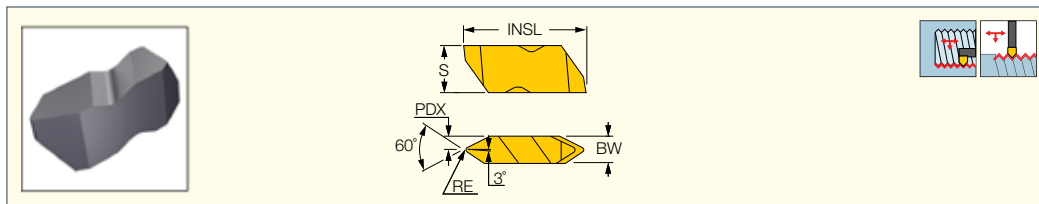
Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-3-8NPT 2E	8.0	3/4	1.50	6.35	8.74	22.60	
FLDC-3-11.5NPT-2E	11.5	3/4	1.20	6.35	8.74	22.60	•

<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCAR THREAD**

**UNJ THREADING FLJ**  
Double-Ended Precision Flat  
Top Threading Inserts



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLJ-3020R/L8	8.0	0.48	2.49	4.95	8.74	22.60	
FLJ-3014R/L12	12.0	0.32	2.49	4.95	8.74	22.60	
FLJ-3010R/L16	16.0	0.24	2.49	4.95	8.74	22.60	

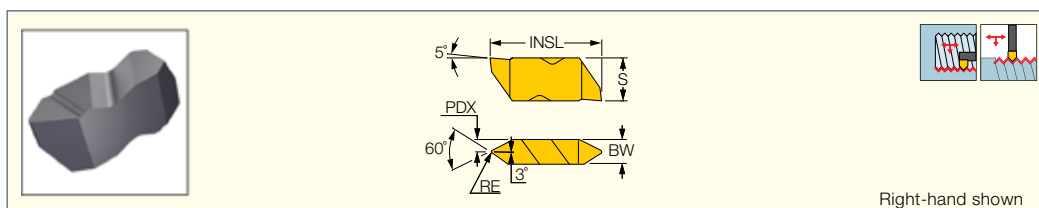
• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCAR THREAD**

**UNJ THREADING FLJP**  
Double-Ended, Precision  
Threading Inserts with  
a Positive Rake



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLJP-3020R/L8	8.0	0.48	2.50	4.95	8.74	22.60	
FLJP-3014R/L12	12.0	0.32	2.50	4.95	8.74	22.60	
FLJP-3010R/L16	16.0	0.24	2.50	4.95	8.74	22.60	

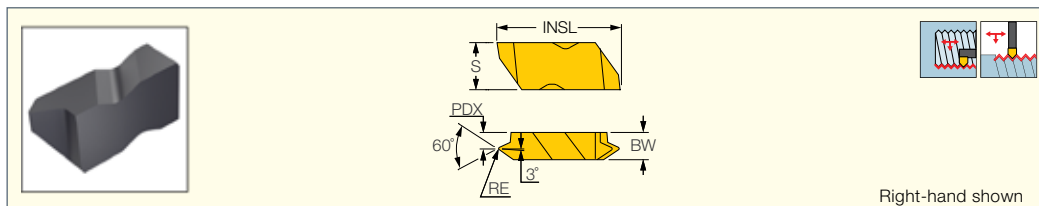
• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCAR THREAD**

**UNJ THREADING FLJF**  
Double-Ended, Precision  
Flat Top Threading Inserts



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLJF-3012R/L14	14.0	0.27	3.58	4.95	8.74	22.60	
FLJF-3010R/L16	16.0	0.24	3.60	4.95	8.74	22.60	
FLJF-3009R/L18	18.0	0.21	3.60	4.95	8.74	22.60	
FLJF-3008R/L20	20.0	0.19	3.60	4.95	8.74	22.60	
FLJF-3007R/L24	24.0	0.16	3.60	4.95	8.74	22.60	
FLJF-3006R/L28	28.0	0.14	3.60	4.95	8.74	22.60	
FLJF-3005R/L32	32.0	0.12	3.60	4.95	8.74	22.60	

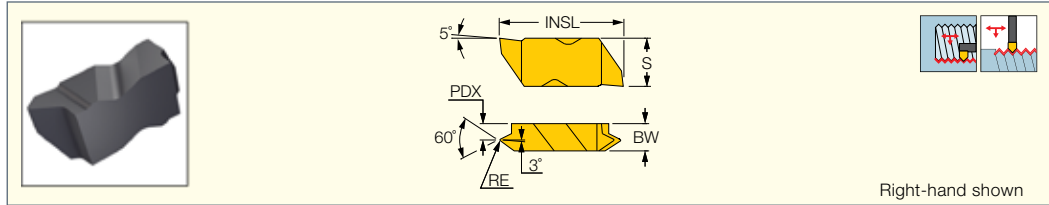
• DMIN according to related boring bar

<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**UNJ THREADING FLJK**  
Double-Ended, Precision  
Threading Inserts, with  
a Positive Rake



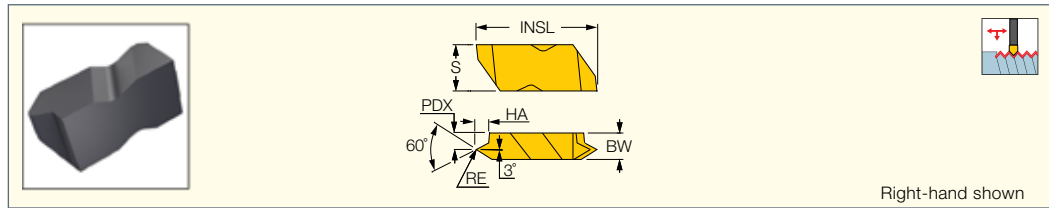
Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	RE	PDX	BW	S	INSL	
FLJK-3012R/L14	14.0	0.27	3.58	4.95	8.74	22.60	●
FLJK-3010R/L16	16.0	0.24	3.60	4.95	8.74	22.60	●
FLJK-3009R/L18	18.0	0.21	3.60	4.95	8.74	22.60	●
FLJK-3008R/L20	20.0	0.19	3.60	4.95	8.74	22.60	●
FLJK-3007R/L24	24.0	0.16	3.60	4.95	8.74	22.60	●
FLJK-3006R/L28	28.0	0.14	3.60	4.95	8.74	22.60	●
FLJK-3005R/L32	32.0	0.12	3.60	4.95	8.74	22.60	●

- DMIN according to related boring bar
- <sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**UN THREADING FLTC-E**  
Double-Ended, Precision, Flat  
Top Full Profile Threading Inserts,



Designation	Dimensions							IC908
	TPI <sup>(1)</sup>	RE	HA	PDX	BW	S	INSL	
FLTC-3R/L7E	7.0	0.43	2.74	2.70	4.95	8.74	22.60	●
FLTC-3R/L8E	8.0	0.38	2.39	2.70	4.95	8.74	22.60	●
FLTC-3R/L9E	9.0	0.33	2.13	2.70	4.95	8.74	22.60	●
FLTC-3R/L10E	10.0	0.30	1.93	2.70	4.95	8.74	22.60	●
FLTC-3R/L11E	11.0	0.28	1.75	2.70	4.95	8.74	22.60	●
FLTC-3R/L12E	12.0	0.25	1.30	3.80	4.95	8.74	22.60	●
FLTC-3R/L14E	14.0	0.23	1.37	3.80	4.95	8.74	22.60	●
FLTC-3R/L16E	16.0	0.20	1.17	3.80	4.95	8.74	22.60	●
FLTC-3R/L18E	18.0	0.18	1.04	3.80	4.95	8.74	22.60	●
FLTC-3R/L20E	20.0	0.15	0.94	3.80	4.95	8.74	22.60	●
FLTC-3R/L24E	24.0	0.13	0.79	3.80	4.95	8.74	22.60	●
FLTC-3R/L28E	28.0	0.08	0.58	3.80	4.95	8.74	22.60	●
FLTC-3R/L32E	32.0	0.08	0.53	3.80	4.95	8.74	22.60	●

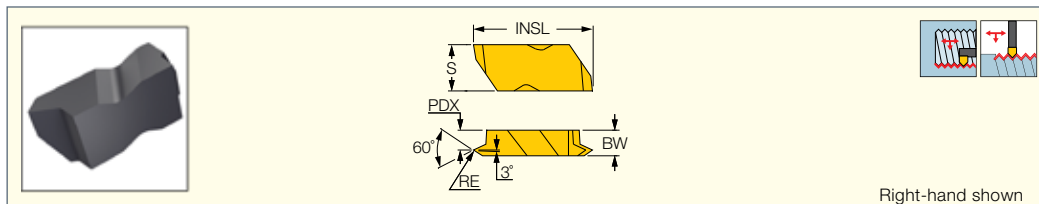
- <sup>(1)</sup> Threads per inch

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**60° PARTIAL PROFILE  
THREADING FLTF**

Double-Ended, Precision  
Flat Top Threading Inserts



Designation	Dimensions											IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN_DF2 <sup>(3)</sup>	TPIX_DF2 <sup>(4)</sup>	RE	PDX	BW	S	INS	TPN_DF2	TPX_DF2	
FLTF-3R/L	9.00	24.00	10.00	44.00	0.00	3.60	4.95	8.74	22.60	2.500	1.750	●
FLTF-4R/L	9.00	24.00	10.00	44.00	0.00	5.10	6.48	11.51	28.45	2.500	1.750	●
FLTF-2R/L	12.00	24.00	14.00	44.00	0.00	2.80	3.81	5.56	12.95	0.600	1.750	●

• For 60° V-thread limits, see page • DMIN according to related boring bar

<sup>(1)</sup> TPI int. min.

<sup>(2)</sup> TPI int. max.

<sup>(3)</sup> TPI ext. min.

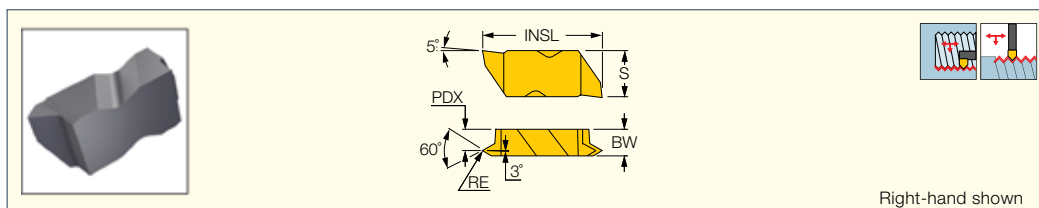
<sup>(4)</sup> TPI ext. max.

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**60° PARTIAL PROFILE  
THREADING FLTK**

Double-Ended, Precision Positive  
Rake Threading Inserts



Designation	Dimensions										IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN_ DF2 <sup>(3)</sup>	TPIX_DF2 <sup>(4)</sup>	RE	TTP	PDX	BW	S	INSL	
FLTK-3R/L	9.00	24.00	10.00	44.00	0.00	BOTH	3.60	4.95	8.74	22.60	●
FLTK-4R/L	9.00	24.00	10.00	44.00	0.00	BOTH	5.10	6.48	11.51	28.45	●
FLTK-2R/L	12.00	24.00	14.00	44.00	0.00	BOTH	2.80	3.81	5.56	12.95	●

• For 60° V-thread limits, see page • DMIN according to related boring bar

<sup>(1)</sup> TPI int. min.

<sup>(2)</sup> TPI int. max.

<sup>(3)</sup> TPI ext. min.

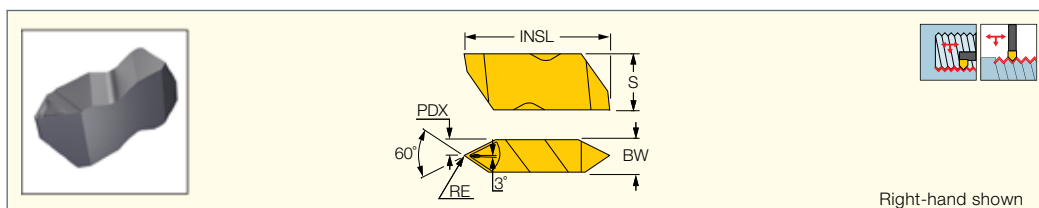
<sup>(4)</sup> TPI ext. max.

**NOTCH-GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**60° PARTIAL PROFILE  
THREADING FLT-CB**

Double-Ended Precision  
Threading Inserts with  
Chipbreakers



Designation	Dimensions									IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN_DF2 <sup>(3)</sup>	TPIX_DF2 <sup>(4)</sup>	RE	PDX	BW	S	INSL	
FLT-4R/L-HCB	4.00	12.00	4.00	20.00	0.00	3.30	6.48	11.51	28.45	●
FLT-3R/LC-HCB	5.00	6.00	6.00	11.00	0.00	2.50	4.95	8.74	22.60	●
FLT-3R/L-HCB	5.00	12.00	6.00	20.00	0.00	2.50	4.95	8.74	22.60	●
FLT-3R/L-FCB	7.00	20.00	8.00	36.00	0.00	2.50	4.95	8.74	22.60	●
FLT-3R/L-CB	8.00	12.00	8.00	20.00	0.00	2.50	4.95	8.74	22.60	●

• DMIN according to related boring bar

<sup>(1)</sup> TPI int. min.

<sup>(2)</sup> TPI int. max.

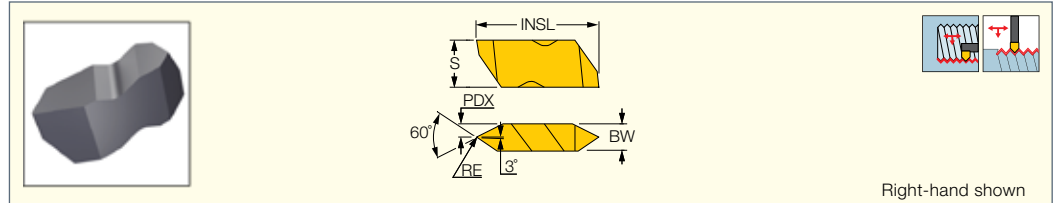
<sup>(3)</sup> TPI ext. min.

<sup>(4)</sup> TPI ext. max.

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**60° PARTIAL PROFILE  
THREADING FLT**  
Double-Ended, Precision  
Flat Top Threading Inserts



Designation	Dimensions									IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN_DF2 <sup>(3)</sup>	TPIX_DF2 <sup>(4)</sup>	RE	PDX	BW	S	INSL	
<b>FLT-4R/L</b>	4.00	12.00	4.00	20.00	0.00	3.30	6.48	11.51	28.45	●
<b>FLT-3R/L</b>	5.00	12.00	6.00	20.00	0.00	2.50	4.95	8.74	22.60	●
<b>FLT-3010R/L</b>	5.00	12.00	6.00	18.00	0.00	2.50	4.95	8.74	22.60	●
<b>FLT-2R/L</b>	7.00	20.00	8.00	36.00	0.00	1.90	3.81	5.56	12.95	●

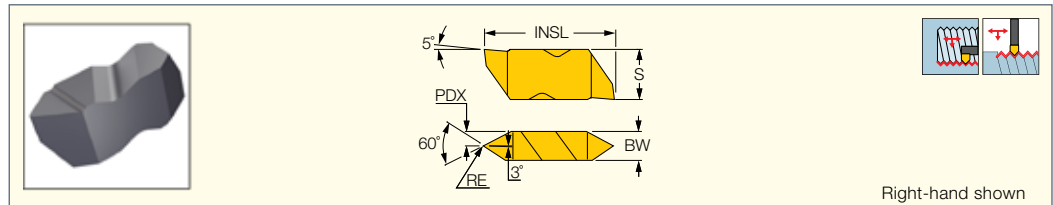
• For 60° V-thread limits, see page • DMIN according to related boring bar

- (1) TPI int. min.  
(2) TPI int. max.  
(3) TPI ext. min.  
(4) TPI ext. max.

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**60° PARTIAL PROFILE  
THREADING FLTP**  
Double-Ended, Precision Positive  
Rake Threading Inserts



Designation	Dimensions									IC908
	TPIN <sup>(1)</sup>	TPIX <sup>(2)</sup>	TPIN_DF2 <sup>(3)</sup>	TPIX_DF2 <sup>(4)</sup>	RE	PDX	BW	S	INSL	
<b>FLTP-4R/L</b>	4.00	12.00	4.00	20.00	0.00	3.30	6.50	11.51	28.45	●
<b>FLTP-3R/L</b>	5.00	12.00	6.00	20.00	0.00	2.50	5.00	8.74	22.60	●
<b>FLTP-2R/L</b>	7.00	20.00	8.00	36.00	0.00	1.90	3.80	5.56	12.95	●

• For 60° V-thread limits, see page • DMIN according to related boring bar

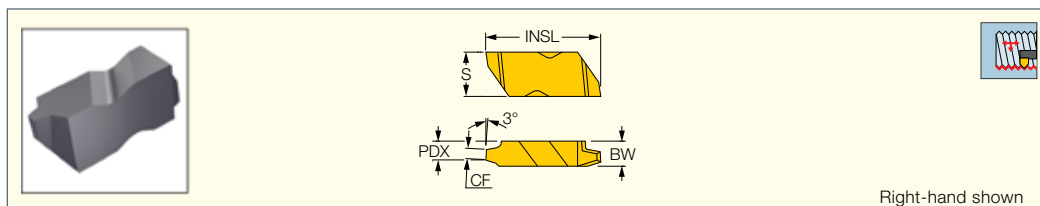
- (1) TPI int. min.  
(2) TPI int. max.  
(3) TPI ext. min.  
(4) TPI ext. max.

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

# **ACME THREADING FLA-PT-I**

Double-Ended Precision Flat Top Internal Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLA-3L16-PT-I	16.0	0.52	3.80	4.95	8.74	22.60	●
FLA-3L14-PT-I	14.0	0.61	3.80	4.95	8.74	22.60	●
FLA-3L12-PT-I	12.0	0.72	3.80	4.95	8.74	22.60	●
FLA-3L10-PT-I	10.0	0.81	3.80	4.95	8.74	22.60	●
FLA-3L8-PT-I	8.0	1.04	3.80	4.95	8.74	22.60	●
FLA-3L6-PT-I	6.0	1.44	3.80	4.95	8.74	22.60	●
FLA-3L5-PT-I	5.0	1.75	3.80	4.95	8.74	22.60	●
FLA-3L4-PT-I	4.0	2.22	3.40	4.95	8.74	22.60	●
FLA-4L8-PT-I	8.0	1.04	5.10	6.48	11.51	28.45	●
FLA-4L6-PT-I	6.0	1.44	5.10	6.48	11.51	28.45	●
FLA-4L5-PT-I	5.0	1.75	5.10	6.48	11.51	28.45	●
FLA-4L4-PT-I	4.0	2.22	5.10	6.48	11.51	28.45	●
FLA-6L3-PT-I	3.0	3.01	7.20	9.73	11.51	28.45	●
FLA-6L2.5-PT-I	2.5	3.63	7.20	9.73	11.51	28.45	●
FLA-6L2-PT-I	2.0	4.58	7.20	9.73	11.51	28.45	●

• For internal thread limits, see page

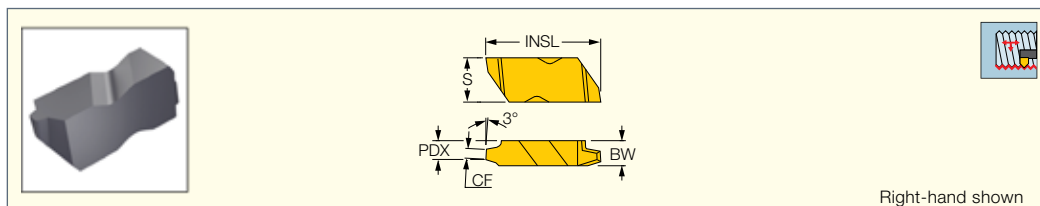
<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

# **STUB ACME THREADING FLAS-PT-I**

Double-Ended Precision Flat Top on Internal Threading Inserts



Designation	Dimensions						IC908
	TPI <sup>(1)</sup>	CF	PDX	BW	S	INSL	
FLAS-6L2-PT-I	2.0	5.23	7.20	9.73	11.51	28.45	●
FLAS-4L3-PT-I	3.0	3.44	5.10	6.48	11.51	28.45	●
FLAS-3L4-PT-I	4.0	2.55	3.80	4.95	8.74	22.60	●
FLAS-3L5-PT-I	5.0	2.01	3.80	4.95	8.74	22.60	●
FLAS-3L6-PT-I	6.0	1.66	3.80	4.95	8.74	22.60	●
FLAS-3L8-PT-I	8.0	1.21	3.80	4.95	8.74	22.60	●
FLAS-3L10-PT-I	10.0	0.94	3.80	4.95	8.74	22.60	●
FLAS-3L12-PT-I	12.0	0.83	3.80	4.95	8.74	22.60	●
FLAS-3L14-PT-I	14.0	0.70	3.80	4.95	8.74	22.60	●
FLAS-3L16-PT-I	16.0	0.60	3.80	4.95	8.74	22.60	●

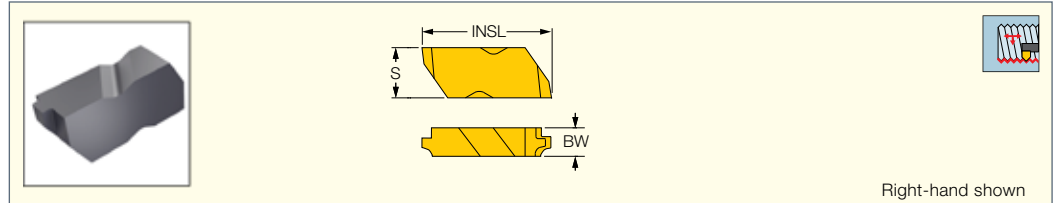
• For internal thread limits, see page

<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API BUTTRESS  
THREADING FLDC-B-I**  
Double-Ended Precision Flat  
Top Threading Inserts



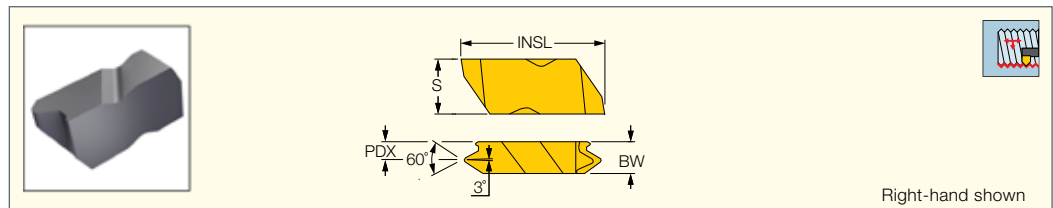
Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	BW	PDX	S	INSL	
FLDC-3-5B1I	5.0	1	6.35	10.22	8.74	22.60	•
FLDC-4-5B1I	5.0	1	6.48	16.05	11.51	28.45	•
FLDC-3-5B75I	5.0	3/4	6.35	10.22	8.74	22.60	•
FLDC-4-5B75I	5.0	3/4	6.48	16.05	11.51	28.45	•

<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**API THREADING FLDC-I**  
Double-Ended Precision Flat  
Top Threading Inserts



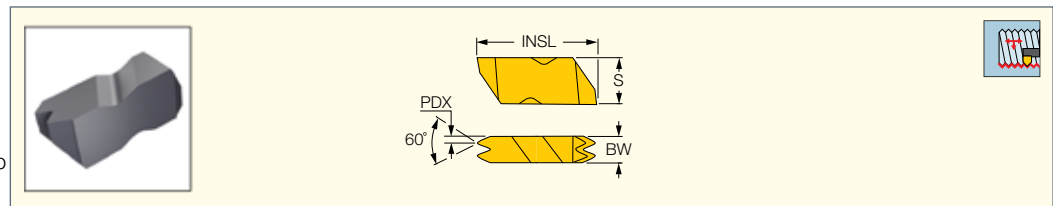
Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-4-425I	4.0	2	4.65	7.92	11.51	28.45	•
FLDC-4-428I	4.0	2	4.65	7.92	11.51	28.45	•
FLDC-4-435I	4.0	3	4.65	7.92	11.51	28.45	•
FLDC-4-438I	4.0	3	4.65	7.92	11.51	28.45	•
FLDC-3-530I	5.0	3	3.73	6.35	8.74	22.60	•

<sup>(1)</sup> Threads per inch

**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

**NPT THREADING FLDC-  
NPT-I**  
Double-Ended, Precision, Flat Top  
Multi-Tooth Threading Inserts



Dimensions							IC908
Designation	TPI <sup>(1)</sup>	IPF	PDX	BW	S	INSL	
FLDC-3-8NPT 2I	8.0	3/4	1.50	6.35	8.74	22.60	•
FLDC-3-11.5NPT-2I	11.5	3/4	1.20	6.35	8.74	22.60	•

• For internal thread limits, see page

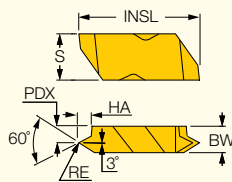
<sup>(1)</sup> Threads per inch

**NOTCH GRIP**  
GROOVE-TURN LINE

**ISCAR THREAD**

**FLTC-I**

Double-Ended, Precision, Full Profile Threading Inserts, for UN Internal Thread Applications



Designation	Dimensions							IC908
	TPI <sup>(1)</sup>	BW	INSL	PDX	S	RE	HA	
FLTC-3R/L7I	7.0	4.95	22.60	2.70	8.74	0.23	2.34	●
FLTC-3R/L8I	8.0	4.95	22.60	2.70	8.74	0.18	2.06	●
FLTC-3R/L9I	9.0	4.95	22.60	2.70	8.74	0.15	1.83	●
FLTC-3R/L10I	10.0	4.95	22.60	2.70	8.74	0.13	1.65	●
FLTC-3R/L11I	11.0	4.95	22.60	2.70	8.74	0.13	1.50	●
FLTC-3R/L12I	12.0	4.95	22.60	3.80	8.74	0.10	1.22	●
FLTC-3R/L14I	14.0	4.95	22.60	3.76	8.74	0.08	1.12	●
FLTC-3R/L16I	16.0	4.95	22.60	3.76	8.74	0.08	1.02	●
FLTC-3R/L18I	18.0	4.95	22.60	3.76	8.74	0.08	0.91	●
FLTC-3R/L20I	20.0	4.95	22.60	3.76	8.74	0.08	0.79	●
FLTC-3R/L24I	24.0	4.95	22.60	3.76	8.74	0.08	0.66	●
FLTC-3R/L28I	28.0	4.95	22.60	3.76	8.74	0.08	0.58	●

• For internal thread limits, see page

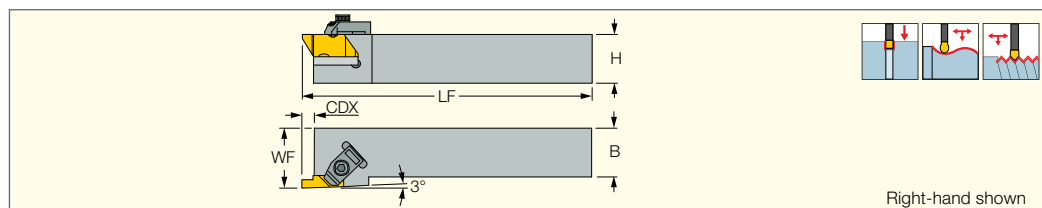
<sup>(1)</sup> Threads per inch

## EXTERNAL TOOLS

**NOTCH GRIP**  
GROOVE-TURN LINE

**FLSR/L**

Tools for External Grooving and Threading Inserts



Right-hand shown

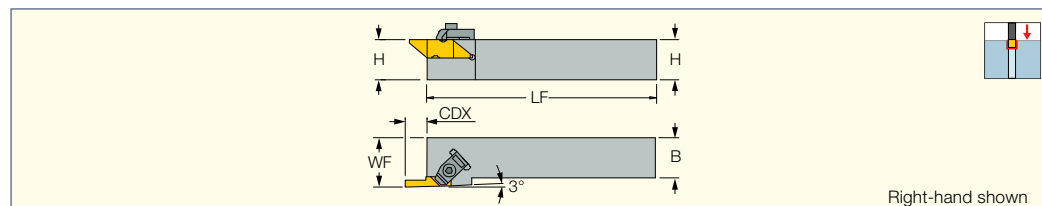
Designation	SSC <sup>(1)</sup>	H	B	CDX	WF	LF	Insert
FLSR/L-2020M2	2.0	20.0	20.0	3.00	25.00	125.00	FL/IN_-2
FLSR/L-2020M3	3.0	20.0	20.0	5.00	32.00	125.00	FL/IN_-3
FLSR/L-2525M2	2.0	25.0	25.0	3.00	32.00	150.00	FL/IN_-2
FLSR/L-2525M3	3.0	25.0	25.0	5.00	32.00	150.00	FL/IN_-3

<sup>(1)</sup> Seat size code

**NOTCH GRIP**  
GROOVE-TURN LINE

**FLSR/LT**

External Tools for Deep Grooving Inserts



Right-hand shown

Designation	H	B	SSC <sup>(1)</sup>	CDX	WF	LF	MIID <sup>(2)</sup>
FLSR/LT-2525M3	25.0	25.0	3.0	11.20	32.00	152.40	INGT-3L
FLSR/LT-2525M4	25.0	25.0	4.0	14.20	32.00	152.40	INGT-4L
FLSR/LT-3232M3	32.0	32.0	3.0	11.20	40.00	152.40	INGT-3L
FLSR/LT-3232M4	32.0	32.0	4.0	14.20	40.00	152.40	INGT-4L

<sup>(1)</sup> Seat size code

<sup>(2)</sup> Master insert identification

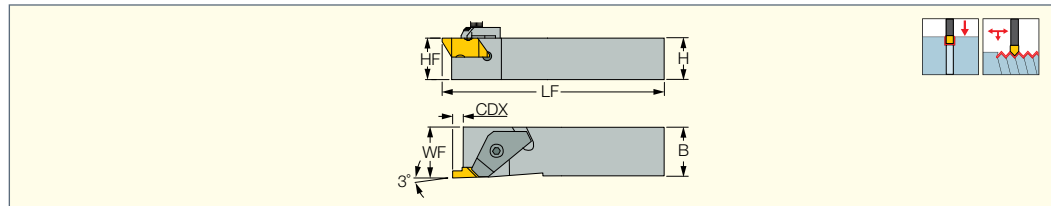


**NOTCHGRIP**  
GROOVE-TURN LINE

**ISCARTHREAD**

# FLASR/L

External Tools for Grooving  
and Threading for Swiss-  
type Machines

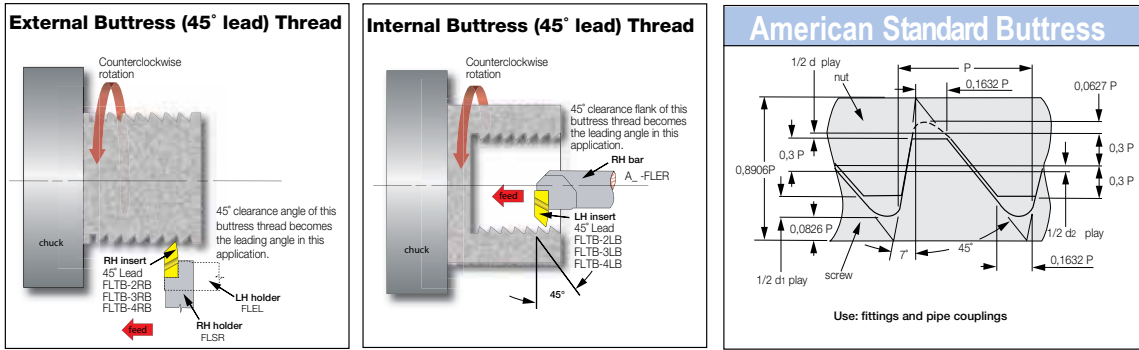


Designation	SSC <sup>(1)</sup>	H	HF	B	CDX	WF	LF	Insert
FLASR/L-1010M2	2.0	10.0	10.0	10.0	3.51	10.00	150.00	FL/IN_-2
FLASR/L-1212M2	2.0	12.0	12.0	12.0	3.51	12.00	150.00	FL/IN_-2
FLASR-1616M2	2.0	16.0	16.0	16.0	3.51	16.00	150.00	FL/IN_-2
FLASR/L-1616M3	3.0	16.0	16.0	16.0	5.31	16.00	125.00	FL/IN_-3

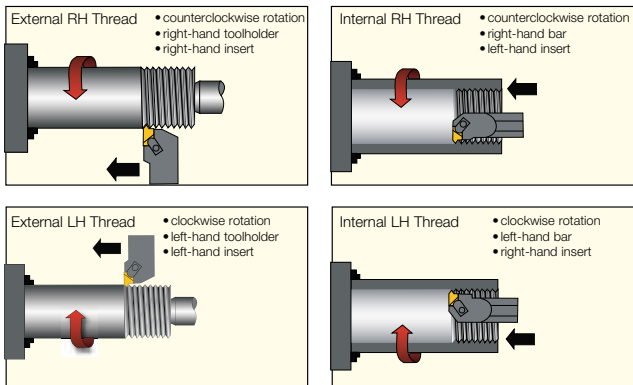
<sup>(1)</sup> Seat size code

## American Standard Buttress Thread Designations

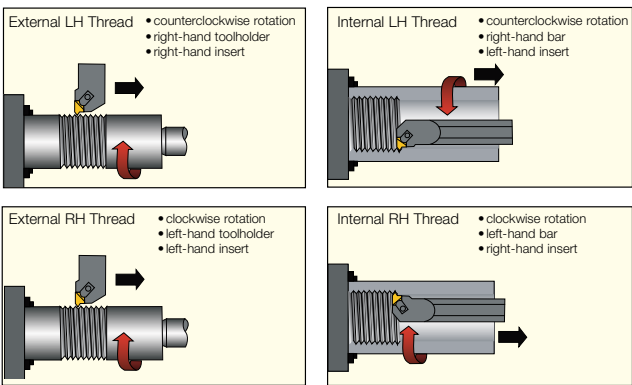
- When only the designation **BUTT** is used, the thread is a “pull” type buttress (external thread pulls) with the clearance flank (45°) leading and the pressure flank (7°) following.
- When the designation **PUSH-BUTT** is used, the thread is a push type buttress (external thread pushes) with the load flank (7°) leading and the 45° clearance flank following.
- Whenever possible this description should be confirmed by a simplified view showing thread angles on the drawing of the product that has the buttress thread.
- Always remember that the position of your holder and direction of your feed will determine the lead angle on the insert.



### Feed direction towards the chuck



### Feed direction towards the tailstock



## Cross Reference Chart

STYLE	TOOL-FLO	KENNAMETAL®	SANDVIK®*	VALENITE®*	HORIZON®*	RTW®*
ACME	FLA	NA	TLA	VLA	HA	PA
ACME STUBFLAS	NAS	TLAS	VLAS	HAS	PAS	
API-NON TOPPING	FLD	ND	TLD	#	#	#
API-TOPPING	FLDC	NDC	TLDC	#	HDC	PDC
UNJ	FLJ	NJ	TLJ	#	HJ	#
UNJ-FINE PITCH	FLJF	NJF	TLJF	#	HJF	#
UNJ-FINE PITCH-POSITIVE	FLJK	NJK	TLJK	#	#	#
UNJ-POSITIVE	FLJP	NJP	TLJP	#	#	#
60° V	FLT	NT	TLT	VLRT	HT	PT
AMERICAN STANDARD BUTTRESS	FLTB	NTB	TLTB	#	HTB	#
UN - UNIFIED	FLTC	NTC	TLTC	VLTC	HTC	PTC
60° V - FINE PITCH	FLTF	NTF	TLTF	VLTF	HTF	PTF
60° V - FINE PITCH POSITIVE	FLTK	NTK	TLTK	VLTK	HTK	PTK
60° V - POSITIVE	FLTP	NTP	TLTP	VLTP	HTP	PTP

\*Top Clamp change is required when converting from SANDVIK®

# USER GUIDE

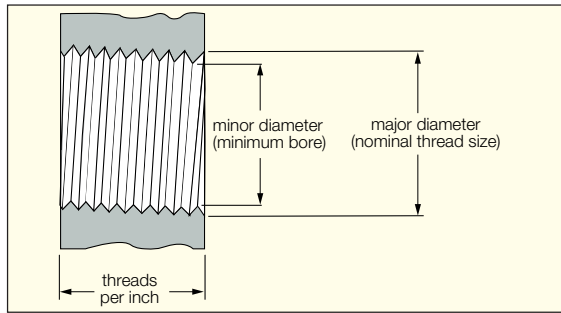
## Threading Limits with Standard NOTCH-GRIP Inserts

The following charts list the largest pitch that can be applied on internal applications for Acme and V-Threading NOTCH-GRIP inserts in sizes 2,3, 4 and 6.

### 60° V-Threading Limits

FLT-2 Inserts		Internal Threading Limitations	
Threads per Inch	Nominal Thread Size	Minimum Minor Diameter	
		Inch	MM
6	1-7/8	1.695	43.05
7	1-3/4	1.595	40.51
8	1-5/8	1.490	37.85
9	1-9/16	1.442	36.63
10	1-1/2	1.392	35.36
11	1-7/16	1.339	34.01
12	1-3/8	1.285	32.64
13	1-5/16	1.229	31.22
14	1-1/4	1.173	29.79
16	1-1/4	1.182	30.02
18	1-1/8	1.065	27.05
20	1-1/8	1.071	27.20
24	1-1/16	1.017	25.83

\* 24 TPI and finer can be cut with a #2 series insert provided that the minor diameter is 1.000 or larger.



FLT-3 & 4 Inserts		Internal Threading Limitations	
Threads per Inch	Nominal Thread Size	Minimum Minor Diameter	
		Inch	MM
4**	3	2.729	69.32
4-1/2**	2-7/8	2.634	66.90
5	2-3/4	2.534	64.36
6	2-1/2	2.320	58.93
7	2-1/4	2.095	53.21
8	2	1.865	47.37
9	1-15/16	1.817	46.15
10	1-7/8	1.767	44.88
11	1-13/16	1.714	43.54
12	1-3/4	1.660	42.16
13	1-5/8	1.542	39.17
14	1-9/16	1.485	37.72
16*	1-7/16	1.370	34.80

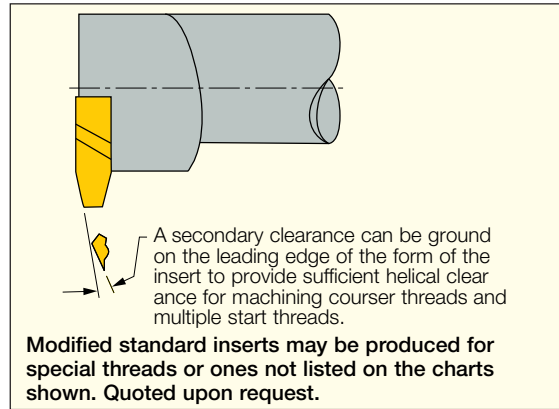
\* 16 pitch acme threads and finer can be cut provided the minor diameter is 1.370 or larger.

\*\* FLT-4 only.

### Acme Threading Limits

FLA-2		Internal Threading Limitations	
Threads per Inch	Nominal Thread Size	Minimum Minor Diameter	
		Inch	MM
6	2-1/2	2.333	59.26
8	2-1/4	2.125	53.98
10	2	1.900	48.26
12	1-3/4	1.667	42.34
14	1-5/8	1.554	39.47
16*	1-1/2	1.438	36.53

\* 16 pitch acme threads and finer can be cut provided the minor diameter is 1.438 or larger.

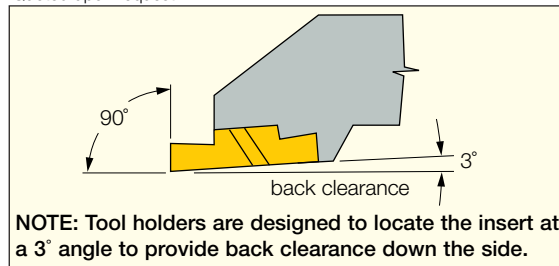


FLA-3, 4 & 6		Internal Threading Limitations	
Threads per Inch	Nominal Thread Size	Minimum Minor Diameter	
		Inch	MM
2*	5	4.500	114.30
2-1/2**	4-1/2	4.100	104.14
3**	4	3.665	93.09
4	3-1/2	3.250	82.55
5	3	2.800	71.12
6	2-1/2	2.333	59.26
8	2-1/4	2.125	53.98
10	2	1.900	48.26
12	1-3/4	1.667	42.34
14	1-5/8	1.554	39.47
16*	1-1/2	1.438	36.53

\* 16 pitch acme threads and finer can be cut provided the minor diameter is 1.438 or larger.

\*\* FLA-6 only.

**NOTE:** Positive rake ACME inserts are recommended for stainless steels and high-temp alloy applications. Quoted upon request.



FLTB-2A & 2B		Internal Threading Limitations	
Threads per Inch	Nominal Thread Size	Minimum Minor Diameter	
		Inch	MM
8	1-3/4	1.600	40.64
10	1-5/8	1.505	38.23
12	1-1/2	1.400	35.56
16	1-1/4	1.175	29.85
20	1-1/16	1.002	25.45

FLTB-3A & 4A		Internal Threading Limitations	
Threads per Inch	Nominal Thread Size	Minimum Minor Diameter	
		Inch	MM
4*	2-1/2	2.200	55.88
5	2-1/4	2.010	51.05
6	2	1.800	45.72
8	1-3/4	1.600	40.64
10	1-5/8	1.505	38.23
12**	1-1/2	1.400	35.56

\* FLTB-4A insert only

\*\* 16 or 20 threads per inch can be cut providing minor diameter is 1.375 or larger.

FLTB-3B & 4B		Internal Threading Limitations	
Threads per Inch	Nominal Thread Size	Minimum Minor Diameter	
		Inch	MM
4	*2-7/8	2.575	65.41
5	2-3/4	2.510	63.75
6	2-3/8	1.175	29.85
8	2-1/8	1.975	50.17
10	1-7/8	1.755	44.58
12	1-5/8	1.525	38.74
16	1-1/2	1.407	35.74
20	1-7/16	1.378	35.00

\* FLTB-4B insert only

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