

# TUNGTHREAD

## *Round Shank*



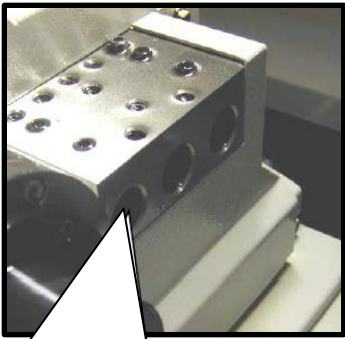
## Expansion to the Tung Thread series

- Expansion with the round shank holders for external threading on Swiss machines.
  - ※ Available for threading on the Star, Citizen, Tsugami, etc machines sub spindle.
- **16ER insert** for various thread shapes and pitches can be attached.

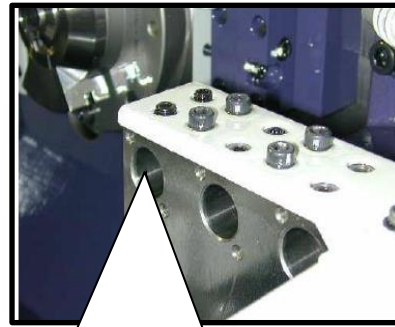
# TUNGTHREAD

## ➤ Features and Benefits;

- Suitable for both sub spindle and main spindle turrets.



For main spindle turret



For sub spindle turret

- High rigidity of the holder design prevents the deflection and chattering.



- **16ER insert** with a wide range of line up can be attached.

→ Available for various thread shapes.

The inserts are listed on page 3.

※The lead angle of round shanks is 1 degree.

For the lead angle more than 2 degrees, special tools will be available.

➤ Typical threading tools for Swiss machines

**TETRAMCUT**  
GROOVING LINE

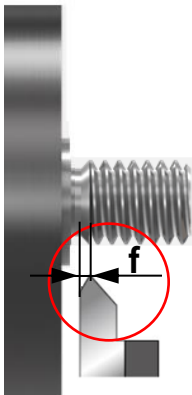
First recommendation



**New**

**DUO<sup>UST</sup>CUT**

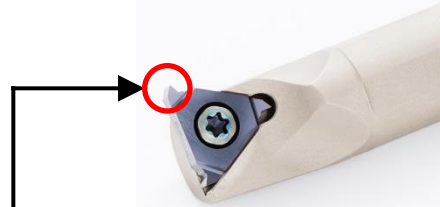
For the accessibility



Pitch[mm]	f [mm]
0.2 ~ 0.4	0.25
0.4 ~ 1	0.6
1 ~ 1.5	1.25

**TUNGTHREAD**

For the versatility

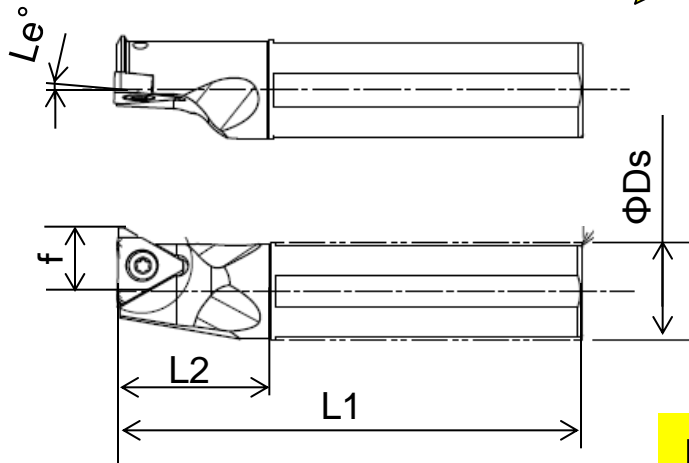


- ISO metric : Pitch 0.5 ~ 3 [mm]
- Unified : 32 ~ 8 TPI
- Whitworth : 28 ~ 8 TPI
- Taper pipe : 28 ~ 11 TPI
- NPT : 27 ~ 8 TPI
- NPTF : 27 ~ 8 TPI
- 30° Trapezoidal : Pitch 1.5 ~ 3 [mm]
- 29° Trapezoidal : 12 ~ 8 TPI
- API Round : 10 ~ 8 TPI
- Round : 8 ~ 6 TPI
- UNJ : 32 ~ 8 TPI
- 60° partial profile : Pitch 0.5 ~ 3 [mm]
- 55° partial profile : 48 ~ 8 TPI



➤ **New Holder**

**JS\*\*-SEL16**



**Metric**

Designation	Stock		Insert	Dimension (mm)				
	R	L		ΦDs	f	L1	L2	Lead angle : Le°
JS16F-SEL16		★	16ER	16	11	85	25	1°
JS19G-SEL16		★		19.05	12.5	90	30	1°
JS19X-SEL16		★		19.05	12.5	120	30	1°
JS20G-SEL16		★		20	13	90	30	1°
JS20X-SEL16		★		20	13	120	30	1°
JS25H-SEL16		★		25	15.5	100	30	1°
JS254X-SEL16		★		25.4	15.7	120	30	1°

**Inch**

Designation	Stock		Insert	Dimension (Inch)				
	R	L		ΦDs	f	L1	L2	Lead angle : Le°
JS16F-SEL16		★	16ER	0.630	0.433	3.346	0.984	1°
JS19G-SEL16		★		0.750	0.492	3.543	1.181	1°
JS19X-SEL16		★		0.750	0.492	4.724	1.181	1°
JS20G-SEL16		★		0.787	0.512	3.543	1.181	1°
JS20X-SEL16		★		0.787	0.512	4.724	1.181	1°
JS25H-SEL16		★		0.984	0.610	3.937	1.181	1°
JS254X-SEL16		★		1.000	0.618	4.724	1.181	1°

※The right hand insert (16ER) is used for this left hand tool holder (JS\*\*\*-SEL16).