

CRAFTSMAN CRIBSHEET

ISO (Metric) Threading Identification

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Our example insert is 16ER24UNHG.

Watch
Dave & Davey video



1	Edge Length
L(mm)	d(mm) - ic
06	3.97
08	4.76
11	6.35
16	9.525
22	12.70
27	15.875

2	Application
Standard	U-Type
Symbol	Application
E	External
N*	Internal
U	U-Type
* Some manufacturers use "I" to denote Internal.	

3	Insert Version
External Threading	
R	L
Internal Threading	
R	L

4	Thread Pitch										
Full Profile (mm)				Full Profile (tpi)					Part Profile		
0.5	0.7	0.75	0.8	48	40	32	24	20	A	0.5 – 1.5 mm	48 – 16tpi
1.0	1.25	1.5	1.75	18	16	14	13	12	AG	0.5 – 3.0 mm	48 – 8tpi
2.0	2.5	3.0	4.0	11	10	9	8	7	G	1.75 – 3.0 mm	18 – 8tpi
4.5	5.0	5.5	6.0	6	5	4.5	4	3	N	3.5 – 5.0 mm	7 – 5tpi
8.0	10.0	12.0	14.0	2.5	2				K	5.5 – 8.0 mm	4.5 – 3tpi

5	Thread Form				
Symbol	Profile	Symbol	Profile	Symbol	Profile
60	V Profile 60°	BUT2.5	Buttress Fig. 2.5	RND	Round DIN 405
55	V Profile 55°	BUT2.6	Buttress Fig. 2.6	STACME	Stub Acme
ABUT	American Buttress	BSPT	Whitworth Taper	TR	Trapezoidal DIN 103
ACME	Am.Acme-G	EL	Extreme Line Casting	UN	American Unified
API	American Pet. Inst.	H90	Hughes	UNJ	UN-Controlled Root
API RD	API RD Casting	ISO	ISO, Metric	VAM	Vam Vallourec
BUT	API Buttress	NPT	National Pipe Taper	W	Whitworth (BSW)

6	No. of Teeth / Chip Breaker		
Full Profile	Partial Profile	Single Tooth Insert	
Workpiece may be slightly oversize as insert "tops" the thread. No subsequent thread deburring is necessary.	Workpiece needs to be accurately pre-machined. One insert covers a wide range of pitches.		

16	E	R	24	UN	HG
↑	↑	↑	↑	↑	↑
①	②	③	④	⑤	⑥
(mm)					