

ISCAR*THREAD*

**Expanding the Range of
Laydown Threading Right Hand
Small Size 06 and 08 Made from
IC908 and IC928 PVD Coated Grades**

ISCAR THREAD

Highlights

ISCAR is expanding its range of laydown threading inserts for internal threading to include sizes 06 and 08 made from PVD coated IC908 and IC928 grades, for a wide range of materials.

Features

- Full profile threading ISO metric thread pitch from 0.5 mm up to 1.75 mm
- The new inserts are fully ground profiles for higher accuracy and better surface quality
- Available in the IC908 versatile PVD coated IC908 and IC928 grades:

IC908

- Very good wear resistant
- A hard, substrate with excellent chipping resistance, combined with a TiAlN PVD coating. Provides high wear and oxidation resistance.

IC928

- A TiAlN PVD coated tough grade, is recommended for interrupted cut and heavy operations
 - Suitable for wet and dry machining
 - For a wide range of materials
- The new line is interchangeable with all standard holders.
 - The new full profile types share the same characteristics as the rest of the line
 - Cutting conditions according to the existing line

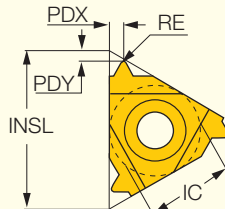
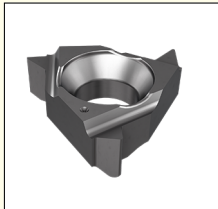
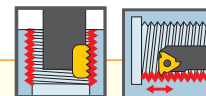
ISCAR THREAD

Description ASA	Description ISO	C.S.	In catalog	Size	Geometry	Item No.
06IR 0.50 ISO IC908	06IR 0.50 ISO IC908	6	YES	6	06IR	5991111
06IR 0.50 ISO IC928	06IR 0.50 ISO IC928	6	YES	6	06IR	3373463
06IR 0.75 ISO IC908	06IR 0.75 ISO IC908	6	YES	6	06IR	3373462
06IR 0.75 ISO IC928	06IR 0.75 ISO IC928	6	YES	6	06IR	3373464
06IR 1.00 ISO IC908	06IR 1.00 ISO IC908	6	YES	6	06IR	5991058
06IR 1.00 ISO IC928	06IR 1.00 ISO IC928	6	YES	6	06IR	5994039
06IR 1.25 ISO IC908	06IR 1.25 ISO IC908	6	YES	6	06IR	5991112
06IR 1.25 ISO IC928	06IR 1.25 ISO IC928	6	YES	6	06IR	3373465
08IR 0.50 ISO IC928	08IR 0.50 ISO IC928	6	YES	8	08IR	3373466
08IR 0.50 ISO IC908	08IR 0.50 ISO IC908	6	YES	8	08IR	5991228
08IR 0.75 ISO IC908	08IR 0.75 ISO IC908	6	YES	8	08IR	3373467
08IR 0.75 ISO IC928	08IR 0.75 ISO IC928	6	YES	8	08IR	3373468
08IR 1.00 ISO IC928	08IR 1.00 ISO IC928	6	YES	8	08IR	5994740
08IR 1.25 ISO IC928	08IR 1.25 ISO IC928	6	YES	8	08IR	3373469
08IR 1.50 ISO IC928	08IR 1.50 ISO IC928	6	YES	8	08IR	3373470
08IR 1.75 ISO IC928	08IR 1.75 ISO IC928	6	YES	8	08IR	3373471

ISCAR THREAD

IR-ISO

Internal ISO Metric (DIN13 12-1986 class 6H)
Laydown Threading Inserts for General Industry



Internal left-hand shown

Designation	Dimensions						Tough ↔ Hard	
	IC	TP ⁽¹⁾	RE	INSL	PDY	PDX	IC928	IC908
06IR 0.50 ISO	4.00	0.500	0.04	6.88	0.9	0.4	•	•
06IR 0.75 ISO	4.00	0.750	0.05	6.88	0.6	0.5	•	•
06IR 1.00 ISO	4.00	1.000	0.05	6.88	0.6	0.6	•	•
06IR 1.25 ISO	4.00	1.250	0.07	6.88	0.6	0.6	•	•
08IR 0.50 ISO	5.00	0.500	0.04	8.24	0.6	0.5	•	•
08IR 0.75 ISO	5.00	0.750	0.05	8.24	0.6	0.5	•	•
08IR 1.00 ISO	5.00	1.000	0.05	8.24	0.6	0.6	•	•
08IR 1.25 ISO	5.00	1.250	0.07	8.24	0.7	0.7	•	•
08IR 1.50 ISO	5.00	1.500	0.09	8.24	0.7	0.7	•	•
08IR 1.75 ISO	5.00	1.750	0.10	8.24	0.6	0.8	•	•

• Tolerance: Class 6H.

⁽¹⁾ Thread pitch

