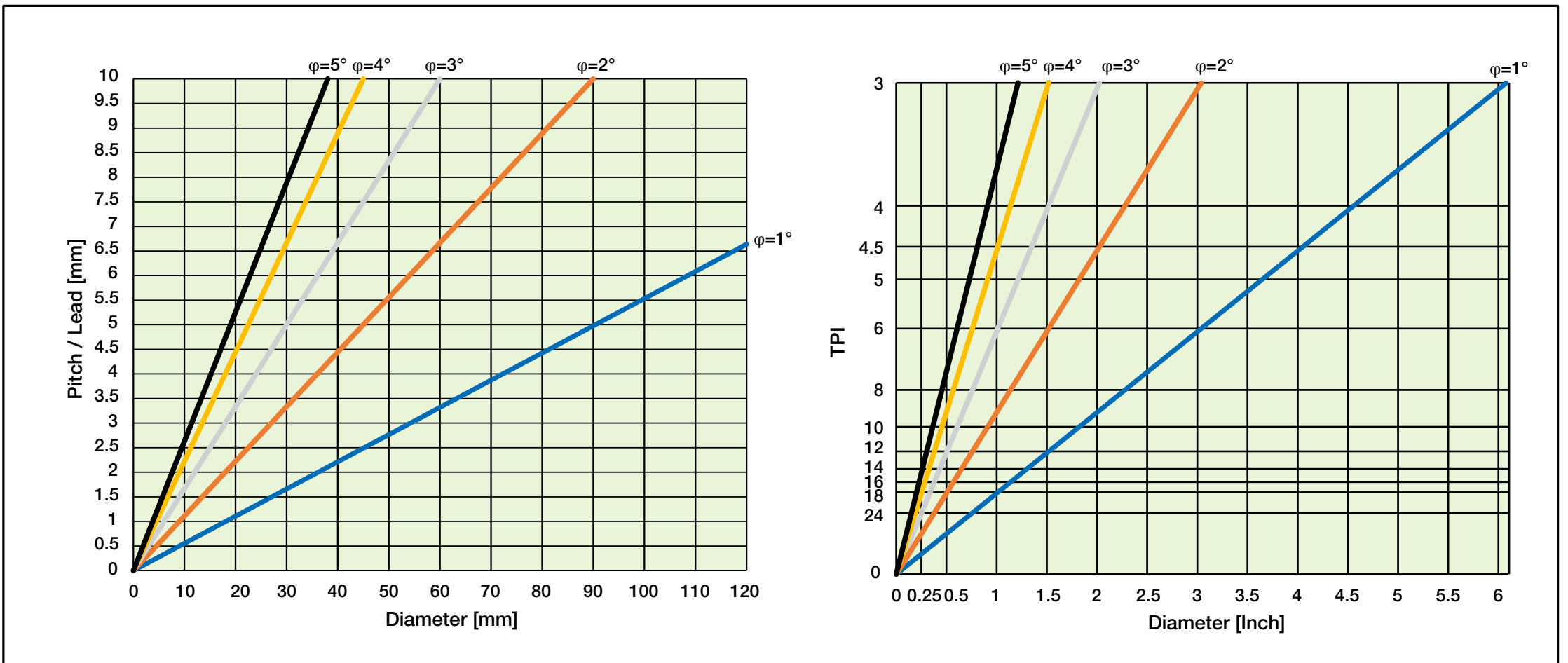
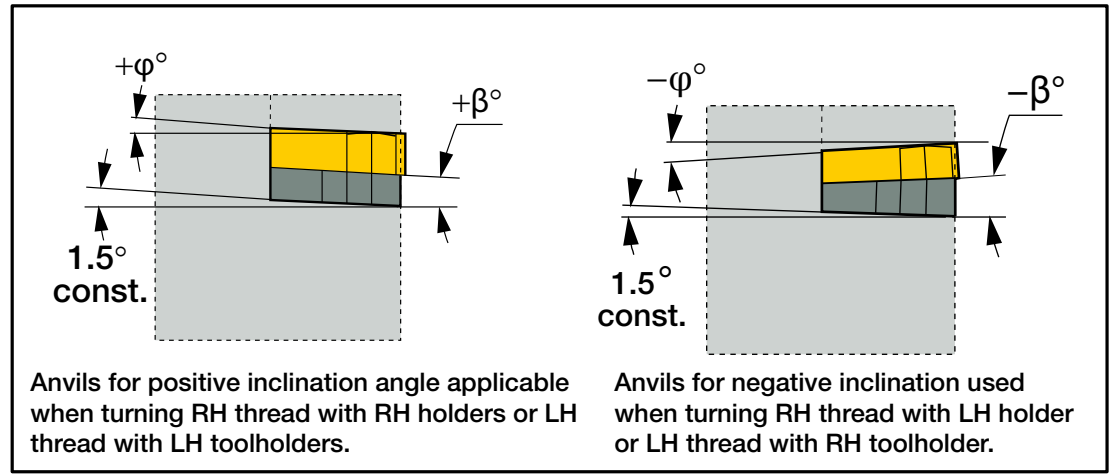
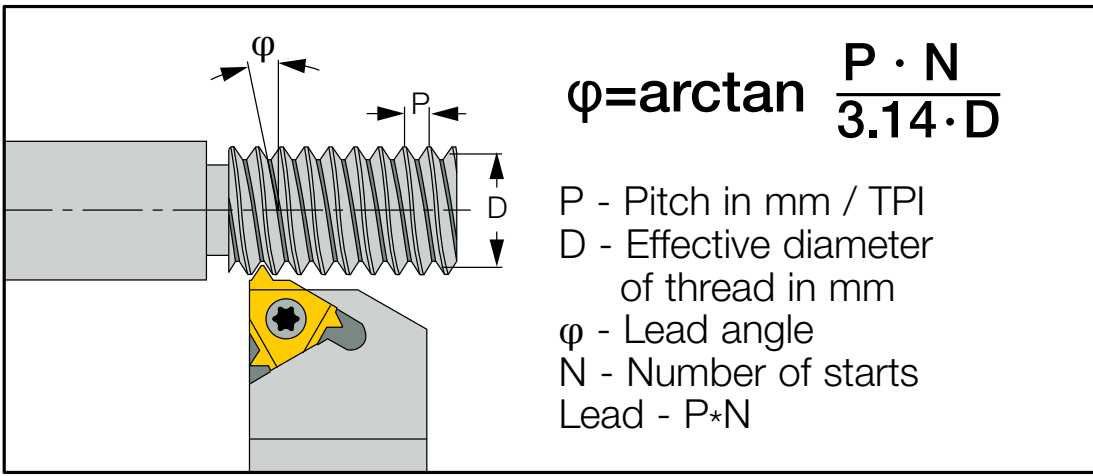


Laydown Anvil Selection Guide



Anvil Selection Recommendation for Symmetric Profiles (ISO, UN, W, NPT, BSPT, TRAPEZOIDAL, ACME, ect.)										
Thread helix angle φ	$\varphi \geq 5^\circ$	$4^\circ \leq \varphi < 5^\circ$	$3^\circ < \varphi \leq 4^\circ$	$2^\circ < \varphi \leq 3^\circ$	$1^\circ < \varphi \leq 2^\circ$ ⁽²⁾	$0^\circ < \varphi < 1^\circ$	$0^\circ < \varphi \leq 1^\circ$ ⁽¹⁾	$1^\circ < \varphi \leq 2^\circ$ ⁽¹⁾	$\varphi \geq 2^\circ$	
Inclination angle β	Special solution ⁽⁴⁾	4.5°	3.5°	2.5°	1.5°	0.5°	-0.5°	-1.5°	Special solution ⁽⁴⁾	
SAGE DIN 513 ⁽³⁾										
Thread helix angle range			$\varphi \geq 5.7^\circ$	$5.1^\circ < \varphi \leq 5.6^\circ$	$3.1^\circ < \varphi \leq 5^\circ$ ⁽²⁾	$2.1^\circ < \varphi \leq 3^\circ$	$1.1^\circ < \varphi \leq 2^\circ$	$0^\circ < \varphi \leq 1^\circ$		
Inclination angle β			special solution ⁽⁴⁾	2.5°	1.5°	0.5°	-0.5°	-1.5°		
AMERICAN BUTTRESS ⁽³⁾										
Thread helix angle range				$\varphi \geq 3.6^\circ$	$3.1^\circ < \varphi \leq 3.5^\circ$ ⁽²⁾	$2.1^\circ < \varphi \leq 3^\circ$	$1.1^\circ < \varphi \leq 2^\circ$	$0^\circ < \varphi \leq 1^\circ$		
Inclination angle β				special solution ⁽⁴⁾	1.5°	0.5°	-0.5°	-1.5°		
I (d)	Toolholder	Anvil Designation								
16	EX RH or IN LH		AE16+4.5	AE16+3.5	AE16+2.5	AE16	AE16+0.5	AE16-0.5	AE16-1.5	Special solution ⁽⁴⁾
(3/8)	EX LH or IN RH		AI16+4.5	AI16+3.5	AI16+2.5	AI16	AI16+0.5	AI16-0.5	AI16-1.5	
22	EX RH or IN LH		AE22+4.5	AE22+3.5	AE22+2.5	AE22	AE22+0.5	AE22-0.5	AE22-1.5	
(1/2)	EX LH or IN RH		AI22+4.5	AI22+3.5	AI22+2.5	AI22	AI22+0.5	AI22-0.5	AI22-1.5	
27	EX RH or IN LH	Special solution ⁽⁴⁾	AE27+4.5	AE27+3.5	AE27+2.5	AE27	AE27+0.5	AE27-0.5	AE27-1.5	
(5/8)	EX LH or IN RH		AI27+4.5	AI27+3.5	AI27+2.5	AI27	AI27+0.5	AI27-0.5	AI27-1.5	
22U	EX RH or IN LH		AE22U+4.5	AE22U+3.5	AE22U+2.5	AE22U	AE22U+0.5	AE22U-0.5	AE22U-1.5	
(1/2U)	EX LH or IN RH		AI22U+4.5	AI22U+3.5	AI22U+2.5	AI22U	AI22U+0.5	AI22U-0.5	AI22U-1.5	
27U	EX RH or IN LH		AE27U+4.5	AE27U+3.5	AE27U+2.5	AE27U	AE27U+0.5	AE27U-0.5	AE27U-1.5	
(5/8U)	EX LH or IN RH		AI27U+4.5	AI27U+3.5	AI27U+2.5	AI27U	AI27U+0.5	AI27U-0.5	AI27U-1.5	

- (1) Symmetrical profiles by pulling
- (2) Supplied with tool holder
- (3) SAGE DIN 513; AMERICAN BUTTRESS profile by pushing
- (4) Contact ISCAR representative