New Product Information

06/2021
NPI

Threading 22

nikkoTOOLS

TPM 22

THREADING

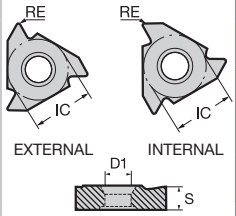
- 3 cutting edges threading insert
- Precision moulding technology for very good cutting edge accuracy
- Specific chipbreaker design for optimal chip control

HF: micrograin carbide
PVD: physical vapour deposition

	HF PVD
	JP5125
Stable machining, light cut	○
General machining, medium cut	●
Unstable machining, heavy cut	●

● 1st choice ○ suitable

Dimensions



ISO	Vc(m/min) - suggested cutting speed range (bold: 1st choice)
P	60 180
M	60 120
K	80 150
N	
S	30 60
H	

	Designation		TP	RE	IC	S	D1	Stock
EXTERNAL	M	22ER350ISO-TPM	3.5	0.45	12.70	4.71	5.0	●
		22ER400ISO-TPM	4.0	0.52	12.70	4.71	5.0	●
		22ER450ISO-TPM	4.5	0.58	12.70	4.71	5.0	●
	METRIC 60°	22ER500ISO-TPM	5.0	0.63	12.70	4.71	5.0	●
	W (55°) - M (60°)	22ERN55-TPM	7-5	0.44	12.70	4.71	5.0	●
		22ERN60-TPM	3.5-5.0	0.51	12.70	4.71	5.0	●
	PARTIAL PROFILE							
INTERNAL	M	22IR350ISO-TPM	3.5	0.22	12.70	4.71	5.0	●
		22IR400ISO-TPM	4.0	0.25	12.70	4.71	5.0	●
		22IR450ISO-TPM	4.5	0.28	12.70	4.71	5.0	●
	METRIC 60°	22IR500ISO-TPM	5.0	0.32	12.70	4.71	5.0	●
	W (55°) - M (60°)	22IRN55-TPM	7-5	0.44	12.70	4.71	5.0	●
		22IRN60-TPM	3.5-5.0	0.25	12.70	4.71	5.0	●
	PARTIAL PROFILE							

● stock standard

M

TP 3.5	No. of passes 12÷15
TP 4.0	No. of passes 14÷17
TP 4.5	No. of passes 14÷17
TP 5.0	No. of passes 14÷17

W

TP 7	No. of passes 12÷15
TP 6	No. of passes 14÷17
TP 5	No. of passes 14÷17

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