



TOOL-FLO

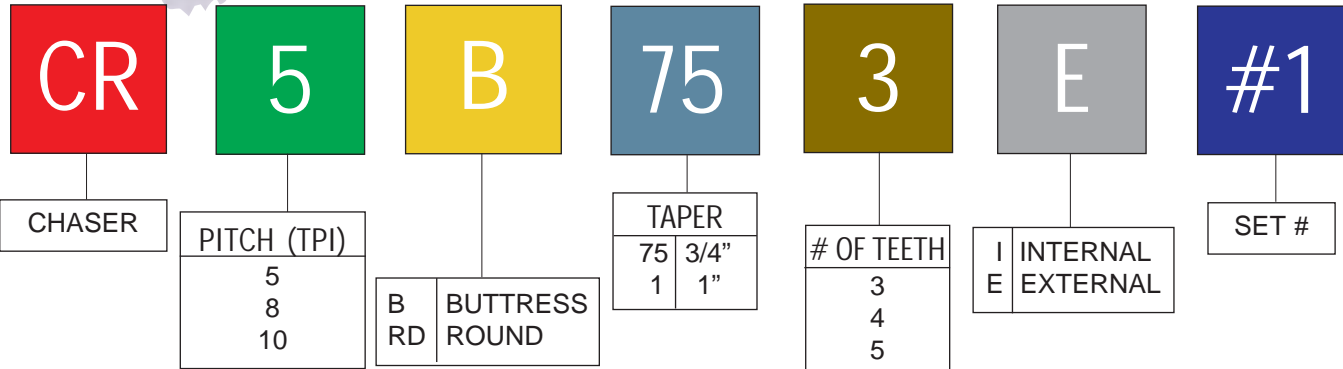


CHAMBERS

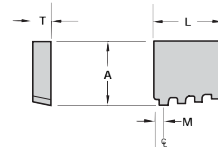




Chaser Insert Identification Chart

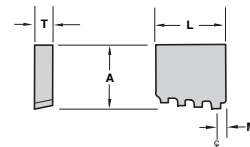


EXTERNAL API BUT-



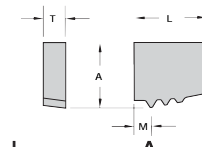
Insert Description	TOOL-FLO Drwg #	TPI	TPF	L	A	T	M	No. of Teeth	Coating			
									G50	GP50	AT50	AC50
CR-5B75-3E #1	TF15188	5	3/4	.670	.573	.205	.220	3	●	●	●	●
CR-5B75-3E #2	TF15189	5	3/4	.670	.582	.205	.149	3	●	●	●	●
CR-5B75-3E #3	TF15190	5	3/4	.670	.590	.205	.087	3	●	●	●	●
CR-5B75-3EC #1	TF22939	5	3/4	.670	.573	.205	.220	3	●	●	●	●
CR-5B75-3EC #2	TF22940	5	3/4	.670	.582	.205	.149	3	●	●	●	●
CR-5B75-3EC #3	TF22941	5	3/4	.670	.590	.205	.087	3	●	●	●	●
CR-5B75-4E	TF22675	5	3/4	.804	.625	.200	.100	4	●	●	●	●
CR-5B1-4E	TF1130	5	1	.800	.640	.200	.100	4	●	●	●	●
CR-8B75-4E	TF5353	8	3/4	.800	.605	.200	.143	4	●	●	●	●

INTERNAL API BUTTRESS



Insert Description	TOOL-FLO Drwg #	TPI	TPF	L	A	T	M	No. of Teeth	Coating			
									G50	GP50	AT50	AC50
CR-5B75-4I	TF1347	5	3/4	.800	.582	.205	.149	4	●	●	●	●
CR-5B75-5I	TF11593	5	3/4	1.000	.590	.205	.087	5	●	●	●	●
CR-5B1-3I	TF2052	5	1	.670	.573	.205	.220	3	●	●	●	●
CR-5B1-4I	TF2051	5	1	.800	.582	.205	.149	4	●	●	●	●
CR-8B75-4I	TF5353	8	3/4	.800	.590	.205	.087	4	●	●	●	●

EXTERNAL API ROUND



Insert Description	TOOL-FLO Drwg #	TPI	TPF	L	A	T	M	No. of Teeth	Coating			
									G50	GP50	AT50	AC50
CR-8R-3E #1	TF16731	8	3/4	.630	.577	.204	.304	3	●	●	●	●
CR-8R-3E #2	TF16732	8	3/4	.630	.586	.204	.262	3	●	●	●	●
CR-8R-3E #3	TF16733	8	3/4	.630	.591	.204	.220	3	●	●	●	●
CR-8R-3E	TF19310	8	3/4	.630	.592	.204	.222	3	●	●	●	●
CR-8R-4E 6P	TF1136	8	3/4	.640	.625	.200	.100	4	●	●	●	●
CR-8R-4E 12P	TF1163	8	3/4	.635	.625	.200	.150	4	●	●	●	●
CR-10R-3E #1	TF16728	10	3/4	.628	.563	.204	.287	3	●	●	●	●
CR-10R-3E #2	TF16729	10	3/4	.628	.572	.204	.253	3	●	●	●	●
CR-10R-3E #3	TF16730	10	3/4	.628	.575	.204	.222	3	●	●	●	●

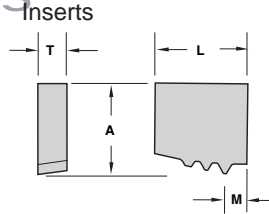
In an effort to improve our stock standard grade offering, there are periodic changes. Please see current price list for up-to-date grade offering.

● High performance choice in optimal conditions.
▲ Recommended grade under general conditions.

J-Series	▲	●		
K-Series	▲	●		
L-Series		●		
N-Series	▲	●		
P-Series	▲	●		
Q-Series	●	▲		

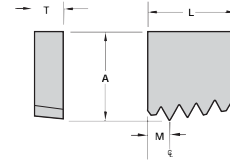


INTERNAL API ROUND



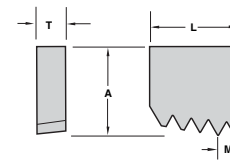
Insert Description	TOOL-FLO Drwg #	TPI	TPF	L	A	T	M	No. of Teeth	CVD Coated	TIN Coated	AlTiN Coated	AlTiN* Coated
									G50	GP50	AT50	AC50
CR-8R-3I	TF7464	8	3/4	.640	.592	.200	.222	3	●	●	●	●
CR-8R-4I	TF1136	8	3/4	.640	.625	.200	.100	4	●	●	●	●
CR-8R-4I	TF19437	8	3/4	.640	.625	.200	.150	4	●	●	●	●
CR-8R-7I	TF14828	8	3/4	1.000	.625	.200	.145	7	●	●	●	●
CR-8R-7I	TF17968HH	8	3/4	1.000	.625	.200	.145	7	●	●	●	●
CR-10R-3I	TF1291	10	3/4	.640	.625	.200	.220	3	●	●	●	●

EXTERNAL LPT/NPT



Insert Description	TOOL-FLO Drwg #	TPI	TPF	L	A	T	M	No. of Teeth	G50	GP50	AT50	AC50
									●	●	●	●
CR-8NPT-4E	TF8996	8	3/4	.625	.620	.203	.156	4	●	●	●	●
CR-11.5NPT-4E	TF9668	11.5	3/4	.625	.620	.1875	.294	4	●	●	●	●

INTERNAL LPT/NPT



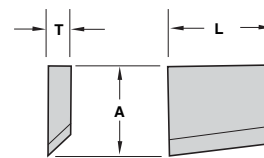
Insert Description	TOOL-FLO Drwg #	TPI	TPF	L	A	T	M	No. of Teeth	G50	GP50	AT50	AC50
									●	●	●	●
CR-8NPT-4I	TF9804	8	3/4	.625	.620	.203	.156	4	●	●	●	●

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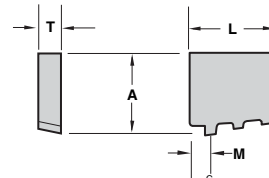
J-Series	▲	●		
K-Series	▲	●		
L-Series	▲	●		
N-Series	▲	●		
P-Series	▲	●		
Q-Series	●	▲		

CHIPBREAKER EXTERNAL



Insert Description	TOOL-FLO Drwg #	L	A	T	Inserts
CR-5B75/5B1-4E-CB	TF2993	.800	.500	.125	CR-5B75-4E/CR-5B1-4E
CR-8R/10R-3E/4E-CB	TF1353E	.630	.460	.125	CR-8R-3E/CR-8R-4E/CR-10R-3E/CR-8LPT-4E

CHIPBREAKER EXTERNAL



Insert Description	TOOL-FLO Drwg #	L	A	T	Coolant Grooves	Inserts
TD4601 5B75-1-CB	TF16660	.665	.550	.170	✓	CR-5B75-3E #1
TD4602 5B75-2-CB	TF16661	.668	.550	.170	✓	CR-5B75-3E #2
TD4603 5B75-3-CB	TF16662	.665	.560	.170	✓	CR-5B75-3E #3
TD3931 8R-1-CB	TF16657	.628	.518	.165	✓	CR-8R-3E #1
TD3932 8R-2-CB	TF16658	.635	.526	.165	✓	CR-8R-3E #2
TD3933 8R-3-CB	TF16659	.628	.520	.165	✓	CR-8R-3E #3

70 CHIPBREAKER

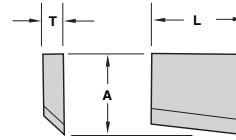
INTERNAL

CB

CHASERS



Inserts

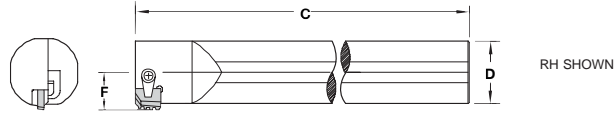


Insert Description	TOOL-FLO Drwg #	L	A	T	Inserts
CR-5B75/5B1-4I-CB	TF16104	.800	.500	.125	CR-5B75-4I/CR-5B1-4I
CR-8R/10R-3I/4I-CB	TF1353I	.630	.460	.125	CR-8R-3I/CR-8R-4I/CR-10R-3I/CR-8LPT-4I
CR-8R-7I-CB	TF3445	1.000	.510	.125	CR-8R-7I

INTERNAL BAR

SI-CLHOR

Threading

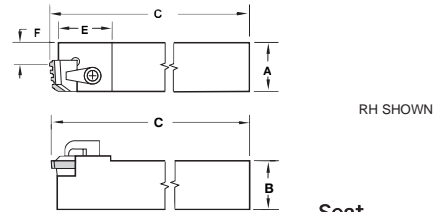


Bar Description	Insert	D	F	C	Min. Bore	Seat	Seat Screw	Clamp	Clamp Screw
SI-CLHOR-206	CR-8R-3I	1-1/4	.750	14	1.500	-	-	TC311	STC-8
	CR-8R-4I	1-1/4	.750	14	1.500	-	-	TC311	STC-8
	CR-5B75-3I	1-1/4	.750	14	1.500	-	-	TC311	STC-8
SI-CLHOR-326	CR-8R-3IDC	2	1.125	14	2.250	TF1780I	SF80	TC311	STC-8
SI-CLHOR-328	CR-5B1-4I	2	1.125	14	2.250	TF8132I	SF60	TC311	STC-8
	CR-5B75-4I	2	1.125	14	2.250	TF8132I	SF60	TC311	STC-8
	CR-8B75-4I	2	1.125	14	2.250	TF8132I	SF60	TC311	STC-8
SI-CLHOR-408	CR-5B1-4I	2-1/2	1.375	14	2.250	TF8132I	SF60	TC311	STC-8
	CR-5B75-4I	2-1/2	1.375	14	2.250	TF8132I	SF60	TC311	STC-8
	CR-8B75-4I	2-1/2	1.375	14	2.250	TF8132I	SF60	TC311	STC-8

EXTERNAL HOLDER

CLVOR

Threading



Bar Description	Insert	A	B	C	E	F	Seat	Seat Screw	Clamp	Clamp Screw	Chip Breaker
CLVOR-166	3 TOOTH*	1	1	8	1.25	.475	TF1207	SF80	TC311	STC-4	TF1353
CLVOR-206	3 TOOTH*	1-1/4	1-1/4	7	1.25	.725	TF1207	SF80	TC311	STC-4	TF1353
CLVOR-168	4 TOOTH**	1	1	6	1.25	.800	TF1207	SF80	TC311	STC-4	TF2993
CLVOR-208	4 TOOTH**	1-1/4	1-1/4	7	1.25	.800	TF8132E	SF60	TC311	STC-4	TF2993
CLVOR-248	4 TOOTH**	1-1/2	1-1/2	7	1.25	.800	TF8132E	SF60	TC311	STC-4	TF2993

*Accepts 3 & 4 Tooth RD, NPT, and 3 Tooth Buttress **Accepts 4 Tooth Buttress Only

Technical Information

API ROUND THREADING	8 & 10 PITCH
application	surface feet/minute (SFPM)
External	500 - 800
Internal	500 - 700

API BUTTRESS THREADING	5 PITCH
application	surface feet/minute (SFPM)
External	300 - 500
Internal	500 - 700

- Number of passes is dictated by the number of teeth on the insert.
 - 3-4 tooth requires 3-5 passes
 - 7 tooth requires 1-2 passes
 - One or two additional passes may be required for heat treated materials.