Multi-Tooth Inserts (mm)

External	Metric 60° (I.S.O) Pitch (mm)					Unified 60° (UN) T.P.I					Whitworth (W) T.P.I			NPT T.P.I
	1,0	1,5	2,0	2,5	3,0	20	18	16	14	12	19	14	11	11.5
Number of Passes	Radial in-feed per pass (mm)					Radial in-feed per pass (mm)					Radial in-feed per pass (mm)			
1	0,356	0,356	0,483	0,457	0,559	0,432	0,483	0,381	0,432	0,533	0,483	0,483	0,457	0,508
2	0,330	0,330	0,483	0,432	0,533	0,381	0,432	0,356	0,406	0,483	0,432	0,432	0,432	0,019
3	**0,686**	0,279	0,330	0,406	0,483	**0,813**	**0,914**	0,279	0,330	0,356	**0,914**	0,330	0,381	0,432
4		**0,965**	**1,295**	0,279	0,330			**1,016**	**1,168**	**1,372**		**1,245**	0,279	0,254
				1,575	**1,905**								**1,549**	**1,676**

Internal	Metric 60° (I.S.O) Pitch (mm)					Unified 60° (UN) T.P.I					Whitworth (W) T.P.I			NPT T.P.I
	1,0	1,5	2,0	2,5	3,0	20	18	16	14	12	19	14	11	11.5
Number of Passes	Radial in-feed per pass (mm)					Radial in-feed per pass (mm)					Radial in-feed per pass (mm)			
1	0,330	0,330	0,457			0,356	0,483				0,356	0,483	0,457	0,508
2	0,305	0,305	0,432			0,330	0,432				0,305	0,432	0,432	0,483
3	**0,635**	0,254	0,330			0,254	0,330				0,254	0,330	0,381	0,432
4		**0,889**	**1,219**			**0,940**	**1,245**				**0,914**	**1,245**	0,279	0,254
													1,549	**1,676**

Last pass equals total depth of thread.