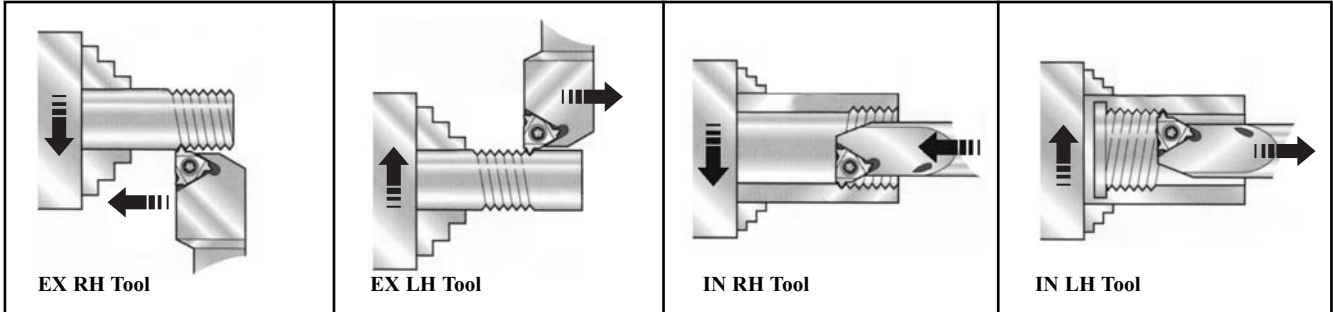


# Thread turning and anvil combinations

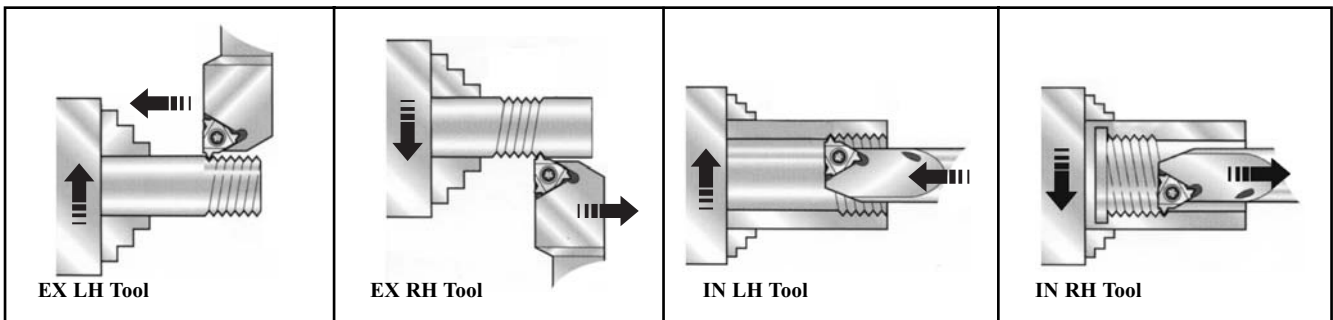


## External Right Hand Threads

Thread Helix Angle	Positive Anvil required for RH tool	Negative Anvil required for LH tool
0° - 1°	AE..+0.5	AL..-0.5
1° - 2°	Standard	AL..-1.5
2° - 3°	AE..+2.5	-
3° - 4°	AE..+3.5	-
4° - 5°	AE..+4.5	-

## Internal Right Hand Threads

Thread Helix Angle	Positive Anvil required for RH tool	Negative Anvil required for LH tool
0° - 1°	AL..+0.5	AE..-0.5
1° - 2°	Standard	AE..-1.5
2° - 3°	AL..+2.5	-
3° - 4°	AL..+3.5	-
4° - 5°	AL..+4.5	-



## External Left Hand Threads

Thread Helix Angle	Positive Anvil required for LH tool	Negative Anvil required for RH tool
0° - 1°	AL..+0.5	AE..-0.5
1° - 2°	Standard	AE..-1.5
2° - 3°	AL..+2.5	-
3° - 4°	AL..+3.5	-
4° - 5°	AL..+4.5	-

## Internal Left Hand Threads

Thread Helix Angle	Positive Anvil required for LH tool	Negative Anvil required for RH tool
0° - 1°	AE..+0.5	AL..-0.5
1° - 2°	Standard	AL..-1.5
2° - 3°	AE..+2.5	-
3° - 4°	AE..+3.5	-
4° - 5°	AE..+4.5	-

Standard anvils are supplied with toolholders that allow for the helix angle to be altered. These anvils are neutral, maintaining the helix angle at the 1.5° pocket angle. Refer to anvil selection chart for correct anvil size to suit insert being used.