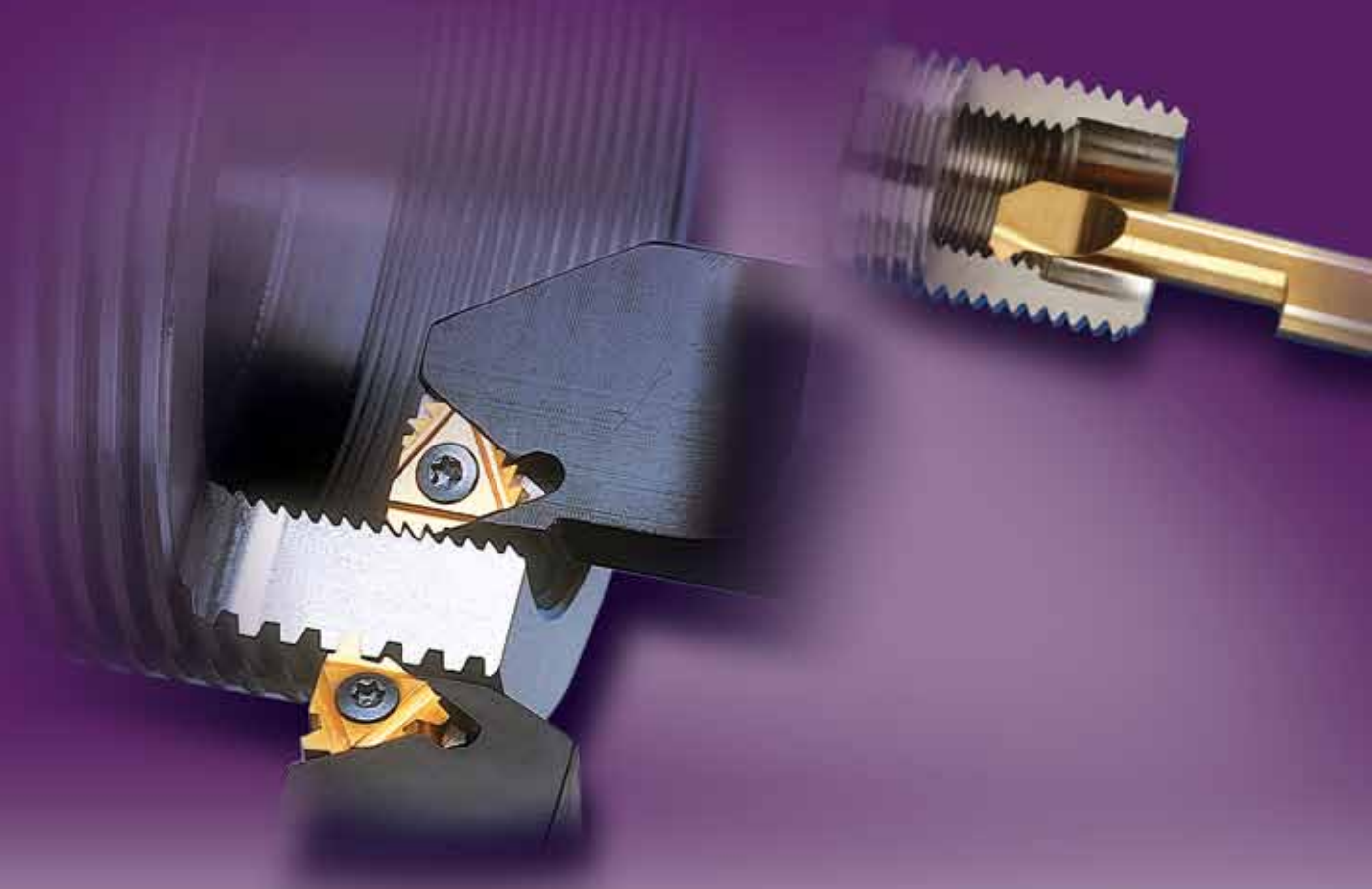
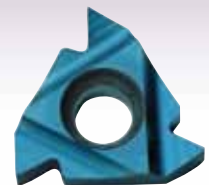


Thread Turning Inserts



BLU Grade

A sub-micrograin grade with PVD triple layer coating. The BLU grade provides a combination of very high strength with high wear resistance.



HBA Grade

An extra-fine sub-micron grade with high toughness, for optimized performance on Hardened Steels and Cast Iron up to 62HRc, Titanium Alloys and Super Alloys (Hastelloy, Inconel, and Nickel based alloys).



Contents:

Page:

Contents:

Page:

Product Identification
Partial Profile 60°
Partial Profile 55°
ISO - metric
UN - unified
Whitworth 55°
NPT
NPTF
BSPT
DIN 477
Acme

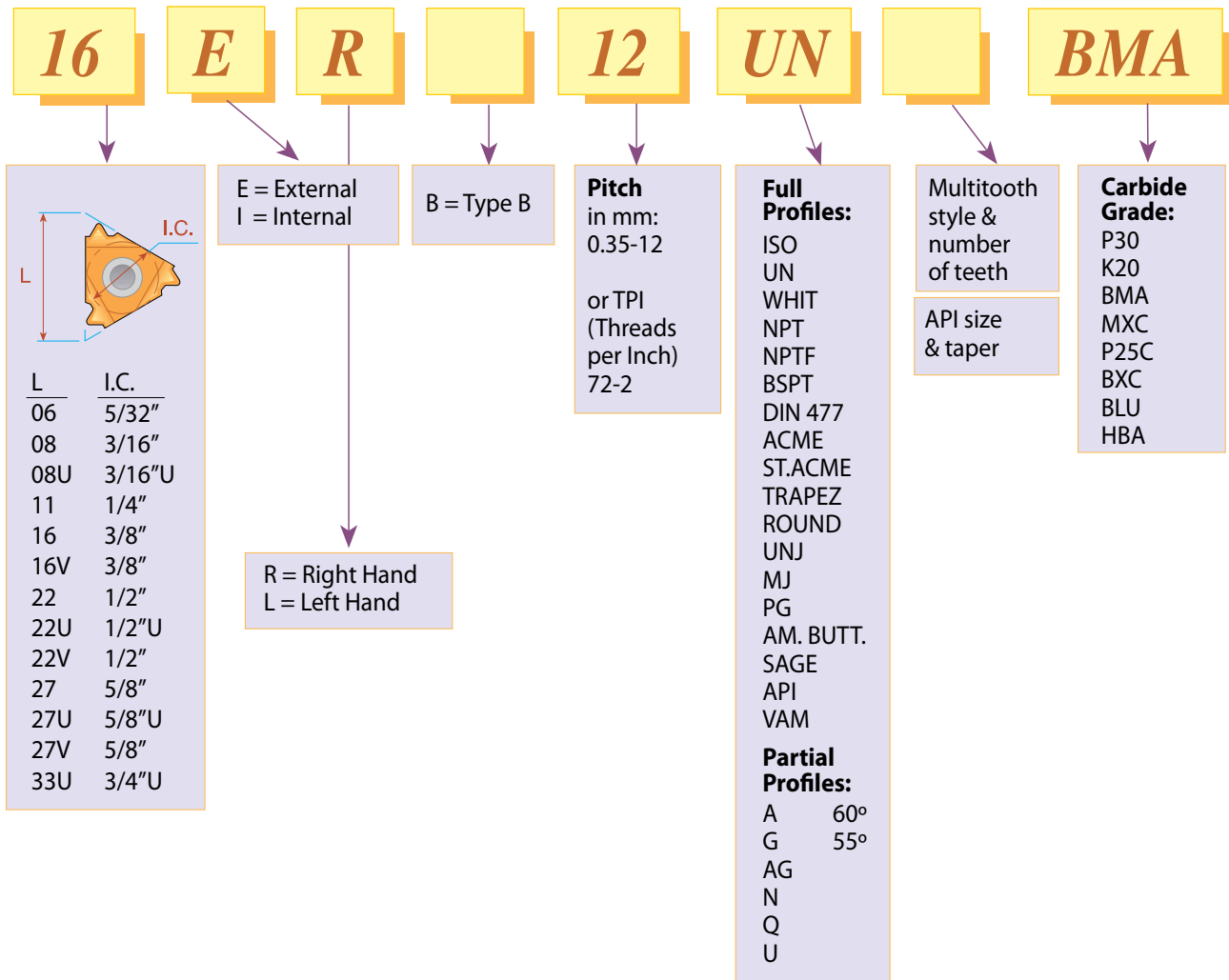
4
5-6
7-8
9-11
12-15
16-19
20-21
22
23-24
24
25

Stub Acme
Trapez - DIN 103
PG - DIN 40430
Sägengewinde - DIN 513
Round - DIN 405
Round - DIN 20400
UNJ
MJ - ISO 5855
American Buttress
Oil Threads
VAM

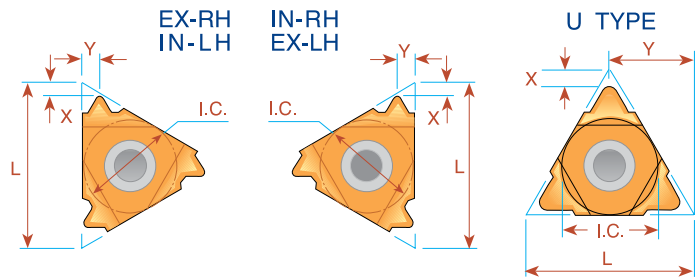
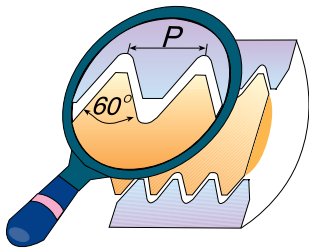
26
27
28
28
29
29
30-31
32
33
34-36
36

Product Identification

Thread Turning Inserts Ordering Codes



Partial Profile 60°

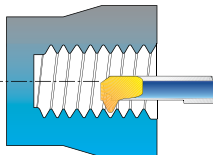


L	I.C. in	Pitch Range mm TPI	EXTERNAL Ordering Code		INTERNAL Ordering Code		X	Y
			Right Hand	Left Hand	Right Hand	Left Hand		
6	5/32	0.5 -1.25 48-20	<i>ULTRA MINIATURE</i> →		*06 IR A60	*06 IL A60	0.6	0.6
8	3/16	0.5 -1.5 48-16	<i>MINIATURE</i> →		*08 IR A60	*08 IL A60	0.6	0.7
8U	3/16U	1.75-2.0 14-11	<i>"U" MINIATURE</i> →		*08U IR/L U60		0.8	4.0
11	1/4	0.5 -1.5 48-16	11 ER A60	11 EL A60	11 IR A60	11 IL A60	0.8	0.9
16	3/8	0.5 -1.5 48-16	16 ER A60	16 EL A60	16 IR A60	16 IL A60	0.8	0.9
16	3/8	1.75-3.0 14- 8	16 ER G60	16 EL G60	16 IR G60	16 IL G60	1.2	1.7
16	3/8	0.5 -3.0 48- 8	16 ER AG60	16 EL AG60	16 IR AG60	16 IL AG60	1.2	1.7
22	1/2	3.5 -5.0 7- 5	22 ER N60	22 EL N60	22 IR N60	22 IL N60	1.7	2.5
22U	1/2U	5.5 -8.0 4.5- 3.25	22U E/R/L U60				0.6	11.0
27	5/8	5.5 -6.0 4.5- 4	27 ER Q60	27 EL Q60	27 IR Q60	27 IL Q60	2.1	3.1
27U	5/8U	6.5 -9.0 4- 2.75	27U E/R/L U60				1.0	13.7

Order example: 16 ER G60 MXC

For small bore threading see page 82

* Available only in BXC and BMA grades



Type B

Ground Profile with Sintered Chip-breaker

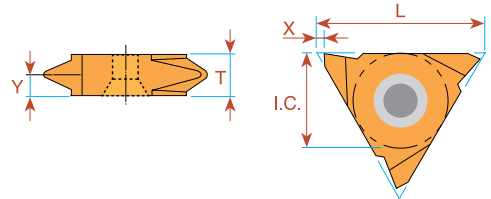


L	I.C. in	Pitch Range mm TPI		<i>EXTERNAL</i>	<i>INTERNAL</i>	X	Y
				Ordering Code Right Hand	Ordering Code Left Hand		
16	3/8	0.5 -1.5	48-16	16 ER B A60	16 IR B A60	0.8	0.9
16	3/8	1.75-3.0	14- 8	16 ER B G60	16 IR B G60	1.2	1.7
16	3/8	0.5 -3.0	48- 8	16 ER B AG60	16 IR B AG60	1.2	1.7

Order example: 16 ER B G60 BMA

For Carbide Grade and Cutting Speed see page 60-61

Partial Profile 60° Vertical

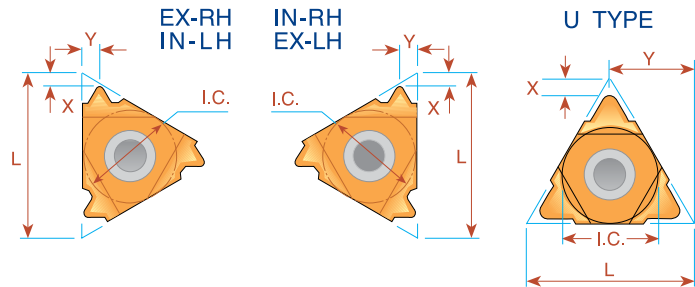
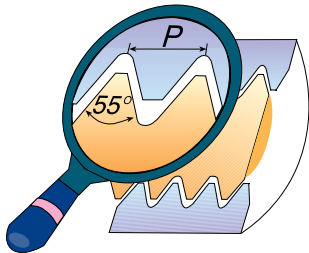


L	I.C. in	Pitch Range mm TPI		EXTERNAL Ordering Code		INTERNAL Ordering Code		X	Y	T
				Right Hand	Left Hand	Right Hand	Left Hand			
16	3/8	0.5 - 1.5	48-16	16V ER A60	16V EL A60			1.0	0.9	3.6
16	3/8	1.75- 3.0	14- 8	16V ER G60	16V EL G60			1.0	1.8	3.6
16	3/8	0.5 - 3.0	48- 8	16V ER AG60	16V EL AG60			1.0	1.8	3.6
22	1/2	1.75- 3.0	14- 8	22V ER G60	22V EL G60			1.2	1.7	4.0
22	1/2	0.5 - 5.0	7- 5	22V ER N60	22V EL N60			1.2	2.5	4.8
27	5/8	6.0 -10.0	4- 2.5	27V ER V60	27V EL V60	27V IR V60	27V IL V60	1.8	5.2	10.4

Order example: 16V ER G60 BMA

For Carbide Grade and Cutting Speed see page 60-61

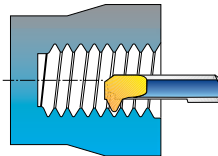
Partial Profile 55°



L	I.C. in	Pitch Range mm TPI	EXTERNAL Ordering Code		INTERNAL Ordering Code		X	Y
			Right Hand	Left Hand	Right Hand	Left Hand		
6	5/32	0.5 -1.25 48-20	<i>ULTRA MINIATURE</i> →		*06 IR A55	*06 IL A55	0.5	0.6
8	3/16	0.5 -1.5 48-16	<i>MINIATURE</i> →		*08 IR A55	*08 IL A55	0.6	0.7
8U	3/16U	1.75-2.0 14-11	<i>"U" MINIATURE</i> →		*08U IR/L U55		0.9	4.0
11	1/4	0.5 -1.5 48-16	11 ER A55	11 EL A55	11 IR A55	11 IL A55	0.8	0.9
16	3/8	0.5 -1.5 48-16	16 ER A55	16 EL A55	16 IR A55	16 IL A55	0.8	0.9
16	3/8	1.75-3.0 14- 8	16 ER G55	16 EL G55	16 IR G55	16 IL G55	1.2	1.7
16	3/8	0.5 -3.0 48- 8	16 ER AG55	16 EL AG55	16 IR AG55	16 IL AG55	1.2	1.7
22	1/2	3.5 -5.0 7- 5	22 ER N55	22 EL N55	22 IR N55	22 IL N55	1.7	2.5
22U	1/2U	5.5 -8.0 4.5- 3.25	22U E/R/L U55				0.9	11.0
27	5/8	5.5 -6.0 4.5- 4	27 ER Q55	27 EL Q55	27 IR Q55	27 IL Q55	2.0	2.9
27U	5/8U	6.5 -9.0 4 - 2.75	27U E/R/L U55				1.2	13.7

Order example: 16 ER G55 MXC

For small bore threading see page 82
* Available only in BXC and BMA grades



Type B

Ground Profile with Sintered Chip-breaker

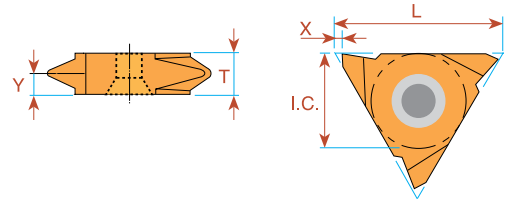


L	I.C. in	Pitch Range mm TPI		<i>EXTERNAL</i>	<i>INTERNAL</i>	X	Y
				Ordering Code Right Hand	Ordering Code Right Hand		
16	3/8	1.75-3.0	14-8	16 ER B G55	16 IR B G55	1.2	1.7
16	3/8	0.5-3.0	48-8	16 ER B AG55	16 IR B AG55	1.2	1.7

Order example: 16 ER B G55 BMA

For Carbide Grade and Cutting Speed see page 60-61

Partial Profile 55° Vertical

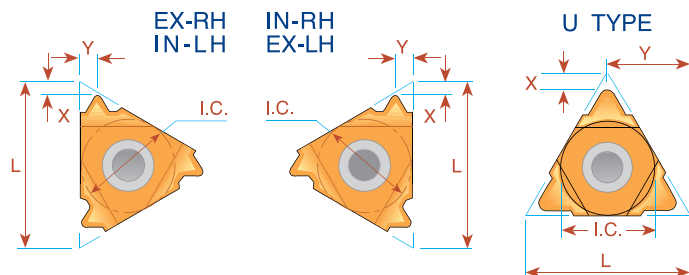
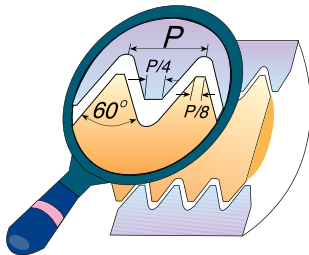


L	I.C. in	Pitch Range mm TPI		EXTERNAL Ordering Code		INTERNAL Ordering Code		X	Y	T
				Right Hand	Left Hand	Right Hand	Left Hand			
16	3/8	0.5 - 1.5	48-16	16V ER A55	16V EL A55			1.0	0.9	3.6
16	3/8	1.75- 3.0	14- 8	16V ER G55	16V EL G55			1.0	1.7	3.6
16	3/8	0.5 - 3.0	48- 8	16V ER AG55	16V EL AG55			1.0	1.8	3.6
22	1/2	3.5 - 5.0	7- 5	22V ER N55	22V EL N55			1.2	2.5	4.8
27	5/8	6.0 -10.0	4- 2.5	27V ER V55	27V EL V55	27V IR V55	27V IL V55	1.8	5.2	10.4

Order example: 22V ER N55 BMA

For Carbide Grade and Cutting Speed see page 60-61

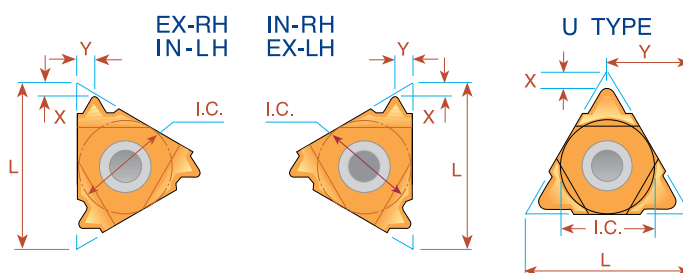
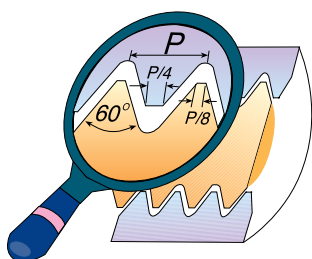
ISO - metric



Pitch mm	L	I.C. in	EXTERNAL				INTERNAL			
			Ordering Code		X	Y	Ordering Code		X	Y
			Right Hand	Left Hand			Right Hand	Left Hand		
0.5	6	5/32	ULTRA MINIATURE →				*06 IR 0.5 ISO	*06 IL 0.5 ISO	0.9	0.5
0.75	6	5/32					*06 IR 0.75 ISO	*06 IL 0.75 ISO	0.8	0.5
1.0	6	5/32					*06 IR 1.0 ISO	*06 IL 1.0 ISO	0.7	0.6
1.25	6	5/32					*06 IR 1.25 ISO	*06 IL 1.25 ISO	0.6	0.6
0.5	8	3/16	MINIATURE →				*08 IR 0.5 ISO	*08 IL 0.5 ISO	0.6	0.5
0.75	8	3/16					*08 IR 0.75 ISO	*08 IL 0.75 ISO	0.6	0.5
1.0	8	3/16					*08 IR 1.0 ISO	*08 IL 1.0 ISO	0.6	0.6
1.25	8	3/16					*08 IR 1.25 ISO	*08 IL 1.25 ISO	0.6	0.7
1.5	8	3/16					*08 IR 1.5 ISO	*08 IL 1.5 ISO	0.6	0.7
1.75	8	3/16					*08 IR 1.75 ISO	*08 IL 1.75 ISO	0.6	0.8
2.0	8U	3/16U	"U" MINIATURE →				*08U IR/L 2.0 ISO		0.9	4.0
0.35	11	1/4	11 ER 0.35 ISO	11 EL 0.35 ISO	0.8	0.4	11 IR 0.35 ISO	11 IL 0.35 ISO	0.8	0.3
0.4	11	1/4	11 ER 0.4 ISO	11 EL 0.4 ISO	0.7	0.4	11 IR 0.4 ISO	11 IL 0.4 ISO	0.8	0.4
0.45	11	1/4	11 ER 0.45 ISO	11 EL 0.45 ISO	0.7	0.4	11 IR 0.45 ISO	11 IL 0.45 ISO	0.8	0.4
0.5	11	1/4	11 ER 0.5 ISO	11 EL 0.5 ISO	0.6	0.6	11 IR 0.5 ISO	11 IL 0.5 ISO	0.6	0.6
0.6	11	1/4	11 ER 0.6 ISO	11 EL 0.6 ISO	0.6	0.6	11 IR 0.6 ISO	11 IL 0.6 ISO	0.6	0.6
0.7	11	1/4	11 ER 0.7 ISO	11 EL 0.7 ISO	0.6	0.6	11 IR 0.7 ISO	11 IL 0.7 ISO	0.6	0.6
0.75	11	1/4	11 ER 0.75 ISO	11 EL 0.75 ISO	0.6	0.6	11 IR 0.75 ISO	11 IL 0.75 ISO	0.6	0.6
0.8	11	1/4	11 ER 0.8 ISO	11 EL 0.8 ISO	0.6	0.6	11 IR 0.8 ISO	11 IL 0.8 ISO	0.6	0.6
1.0	11	1/4	11 ER 1.0 ISO	11 EL 1.0 ISO	0.7	0.7	11 IR 1.0 ISO	11 IL 1.0 ISO	0.6	0.7
1.25	11	1/4	11 ER 1.25 ISO	11 EL 1.25 ISO	0.8	0.9	11 IR 1.25 ISO	11 IL 1.25 ISO	0.8	0.8
1.5	11	1/4	11 ER 1.5 ISO	11 EL 1.5 ISO	0.8	1.0	11 IR 1.5 ISO	11 IL 1.5 ISO	0.8	1.0
1.75	11	1/4	11 ER 1.75 ISO	11 EL 1.75 ISO	0.8	1.1	11 IR 1.75 ISO	11 IL 1.75 ISO	0.8	1.1
2.0	11	1/4	11 ER 2.0 ISO	11 EL 2.0 ISO	0.8	1.1	11 IR 2.0 ISO	11 IL 2.0 ISO	0.8	0.9
2.5	11	1/4					11 IR 2.5 ISO	11 IL 2.5 ISO	0.8	1.2
0.35	16	3/8	16 ER 0.35 ISO	16 EL 0.35 ISO	0.8	0.4	16 IR 0.35 ISO	16 IL 0.35 ISO	0.8	0.3
0.4	16	3/8	16 ER 0.4 ISO	16 EL 0.4 ISO	0.7	0.4	16 IR 0.4 ISO	16 IL 0.4 ISO	0.8	0.4
0.45	16	3/8	16 ER 0.45 ISO	16 EL 0.45 ISO	0.7	0.4	16 IR 0.45 ISO	16 IL 0.45 ISO	0.8	0.4
0.5	16	3/8	16 ER 0.5 ISO	16 EL 0.5 ISO	0.6	0.6	16 IR 0.5 ISO	16 IL 0.5 ISO	0.6	0.6
0.6	16	3/8	16 ER 0.6 ISO	16 EL 0.6 ISO	0.6	0.6	16 IR 0.6 ISO	16 IL 0.6 ISO	0.6	0.6
0.7	16	3/8	16 ER 0.7 ISO	16 EL 0.7 ISO	0.6	0.6	16 IR 0.7 ISO	16 IL 0.7 ISO	0.6	0.6
0.75	16	3/8	16 ER 0.75 ISO	16 EL 0.75 ISO	0.6	0.6	16 IR 0.75 ISO	16 IL 0.75 ISO	0.6	0.6
0.8	16	3/8	16 ER 0.8 ISO	16 EL 0.8 ISO	0.6	0.6	16 IR 0.8 ISO	16 IL 0.8 ISO	0.6	0.6
1.0	16	3/8	16 ER 1.0 ISO	16 EL 1.0 ISO	0.7	0.7	16 IR 1.0 ISO	16 IL 1.0 ISO	0.6	0.7
1.25	16	3/8	16 ER 1.25 ISO	16 EL 1.25 ISO	0.8	0.9	16 IR 1.25 ISO	16 IL 1.25 ISO	0.8	0.9
1.5	16	3/8	16 ER 1.5 ISO	16 EL 1.5 ISO	0.8	1.0	16 IR 1.5 ISO	16 IL 1.5 ISO	0.8	1.0
1.75	16	3/8	16 ER 1.75 ISO	16 EL 1.75 ISO	0.9	1.2	16 IR 1.75 ISO	16 IL 1.75 ISO	0.9	1.2
2.0	16	3/8	16 ER 2.0 ISO	16 EL 2.0 ISO	1.0	1.3	16 IR 2.0 ISO	16 IL 2.0 ISO	1.0	1.3
2.5	16	3/8	16 ER 2.5 ISO	16 EL 2.5 ISO	1.1	1.5	16 IR 2.5 ISO	16 IL 2.5 ISO	1.1	1.5
3.0	16	3/8	16 ER 3.0 ISO	16 EL 3.0 ISO	1.2	1.6	16 IR 3.0 ISO	16 IL 3.0 ISO	1.1	1.5
3.5	16	3/8	16 ER 3.5 ISO	16 EL 3.5 ISO	1.2	1.7	16 IR 3.5 ISO	16 IL 3.5 ISO	1.2	1.7

* Available only in BXC and BMA grades

ISO - metric

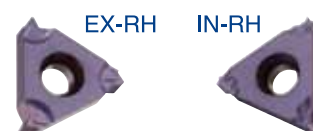
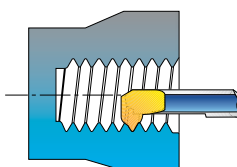


Pitch mm	L	I.C. in	EXTERNAL		X	Y	INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand			Ordering Code Right Hand	Ordering Code Left Hand		
3.5	22	1/2	22 ER 3.5 ISO	22 EL 3.5 ISO	1.6	2.3	22 IR 3.5 ISO	22 IL 3.5 ISO	1.6	2.3
4.0	22	1/2	22 ER 4.0 ISO	22 EL 4.0 ISO	1.6	2.3	22 IR 4.0 ISO	22 IL 4.0 ISO	1.6	2.3
4.5	22	1/2	22 ER 4.5 ISO	22 EL 4.5 ISO	1.7	2.4	22 IR 4.5 ISO	22 IL 4.5 ISO	1.6	2.4
5.0	22	1/2	22 ER 5.0 ISO	22 EL 5.0 ISO	1.7	2.5	22 IR 5.0 ISO	22 IL 5.0 ISO	1.6	2.3
5.5	22	1/2	22 ER 5.5 ISO	22 EL 5.5 ISO	1.7	2.6	22 IR 5.5 ISO	22 IL 5.5 ISO	1.6	2.3
6.0	22	1/2	**22 ER 6.0 ISO	**22 EL 6.0 ISO	1.9	2.7	22 IR 6.0 ISO	22 IL 6.0 ISO	1.6	2.4
5.5	22U	1/2U	22U ER/L 5.5 ISO		2.3	11.0	22U IR/L 5.5 ISO		2.4	11.0
6.0	22U	1/2U	22U ER/L 6.0 ISO		2.6	11.0	22U IR/L 6.0 ISO		2.1	11.0
5.5	27	5/8	27 ER 5.5 ISO	27 EL 5.5 ISO	1.9	2.7	27 IR 5.5 ISO	27 IL 5.5 ISO	1.6	2.3
6.0	27	5/8	27 ER 6.0 ISO	27 EL 6.0 ISO	2.0	2.9	27 IR 6.0 ISO	27 IL 6.0 ISO	1.8	2.5
8.0	27U	5/8U	27U ER/L 8.0 ISO		2.4	13.7	27U IR/L 8.0 ISO		2.4	13.7
12.0	33U	3/4U	33U ER/L 12.0 ISO		2.5	16.5	33U IR/L 12.0 ISO		3.5	16.9

Order example: 22 IR 3.5 ISO BMA

For small bore threading see page 83

** Special holder required



Type B

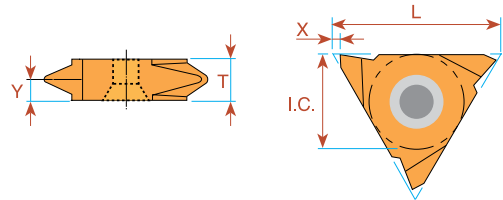
Ground Profile with Sintered Chip-breaker

Pitch mm	L	I.C. in	EXTERNAL	X	Y	INTERNAL	X	Y
			Ordering Code Right Hand			Ordering Code Right Hand		
0.5	11	1/4				11 IR B 0.5 ISO	0.6	0.6
0.75	11	1/4				11 IR B 0.75 ISO	0.6	0.6
0.8	11	1/4				11 IR B 0.8 ISO	0.6	0.6
1.0	11	1/4				11 IR B 1.0 ISO	0.6	0.6
1.25	11	1/4				11 IR B 1.25 ISO	0.8	0.9
1.5	11	1/4				11 IR B 1.5 ISO	0.8	0.9
1.75	11	1/4				11 IR B 1.75 ISO	0.8	0.9
2.0	11	1/4				11 IR B 2.0 ISO	0.8	0.9
0.8	16	3/8	16 ER B 0.8 ISO	0.6	0.6	16 IR B 1.0 ISO	0.6	0.7
1.0	16	3/8	16 ER B 1.0 ISO	0.7	0.7		0.8	0.9
1.25	16	3/8	16 ER B 1.25 ISO	0.8	0.9		0.8	1.0
1.5	16	3/8	16 ER B 1.5 ISO	0.8	1.0		0.9	1.2
1.75	16	3/8	16 ER B 1.75 ISO	1.0	1.3		1.1	1.5
2.0	16	3/8	16 ER B 2.0 ISO	1.1	1.5		1.2	1.6
2.5	16	3/8	16 ER B 2.5 ISO	1.2	1.6			
3.0	16	3/8	16 ER B 3.0 ISO					

Order example: 16 IR B 1.5 ISO BMA

For Carbide Grade and Cutting Speed see page 60-61

ISO - metric Vertical



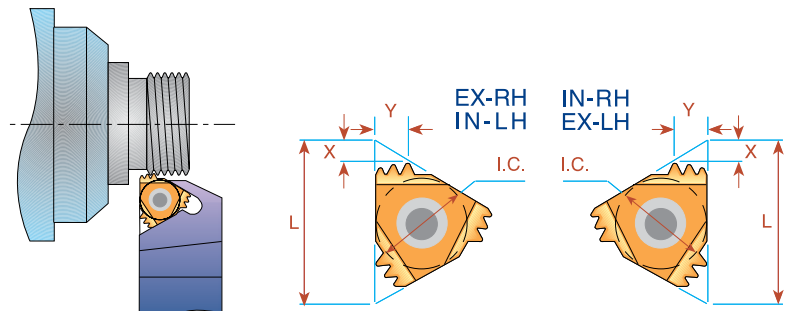
Pitch mm	L	I.C. in	EXTERNAL		INTERNAL		X	Y	T
			Ordering Code Right Hand	Ordering Code Left Hand	Ordering Code Right Hand	Ordering Code Left Hand			
0.5	16	3/8	16V ER 0.5 ISO	16V EL 0.5 ISO			1.0	0.6	3.6
0.75	16	3/8	16V ER 0.75 ISO	16V EL 0.75 ISO			1.0	0.6	3.6
0.8	16	3/8	16V ER 0.8 ISO	16V EL 0.8 ISO			1.0	0.6	3.6
1.0	16	3/8	16V ER 1.0 ISO	16V EL 1.0 ISO			1.0	0.7	3.6
1.25	16	3/8	16V ER 1.25 ISO	16V EL 1.25 ISO			1.0	0.9	3.6
1.5	16	3/8	16V ER 1.5 ISO	16V EL 1.5 ISO			1.0	0.9	3.6
1.75	16	3/8	16V ER 1.75 ISO	16V EL 1.75 ISO			1.0	1.2	3.6
2.0	16	3/8	16V ER 2.0 ISO	16V EL 2.0 ISO			1.0	1.3	3.6
2.5	16	3/8	16V ER 2.5 ISO	16V EL 2.5 ISO			1.0	1.5	3.6
3.0	16	3/8	16V ER 3.0 ISO	16V EL 3.0 ISO			1.0	1.7	3.6
* 8.0	27	5/8	27V ER 8.0 ISO	27V EL 8.0 ISO	27V IR 8.0 ISO	27 IL 8.0 ISO	1.8	5.2	10.4
** 10.0	27	5/8	27V ER 10.0 ISO	27V EL 10.0 ISO	27V IR 10.0 ISO	27 IL 10.0 ISO	1.8	5.2	10.4

Order example: 16V ER 1.5 ISO BMA

* Minimum bore: Ø60 mm

** Minimum bore: Ø72 mm

Multitooth



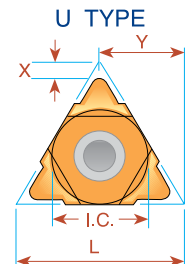
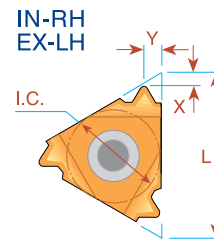
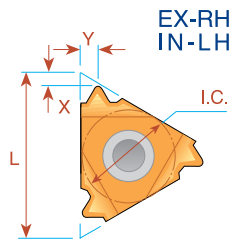
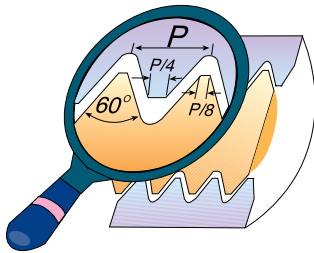
Pitch mm	L	I.C. in	Number of Teeth	EXTERNAL	Anvil	INTERNAL	Anvil	X	Y
				Ordering Code		Ordering Code			
1.0	16	3/8	3	16 ER 1.0 ISO 3M	AE16M	16 IR 1.0 ISO 3M	AI16M	1.7	2.5
1.5	16	3/8	2	16 ER 1.5 ISO 2M	AE16M	16 IR 1.5 ISO 2M	AI16M	1.5	2.3
1.5	22	1/2	3	22 ER 1.5 ISO 3M	AE22M	22 IR 1.5 ISO 3M	AI22M	2.3	3.7
2.0	22	1/2	2	22 ER 2.0 ISO 2M	AE22M	22 IR 2.0 ISO 2M	AI22M	2.0	3.0
2.0	22	1/2	3	22 ER 2.0 ISO 3M	AE22M	22 IR 2.0 ISO 3M	AI22M	3.1	5.0
3.0	27	5/8	2	27 ER 3.0 ISO 2M	AE27M	27 IR 3.0 ISO 2M	AI27M	2.9	4.6

Order example: 22 IR 2.0 ISO 2M BMA

For recommended number of passes see page 62

For Carbide Grade and Cutting Speed see page 60-61

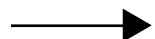
UN - Unified UNC, UNF, UNEF, UNS



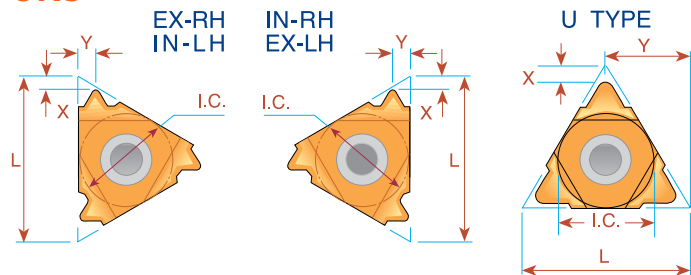
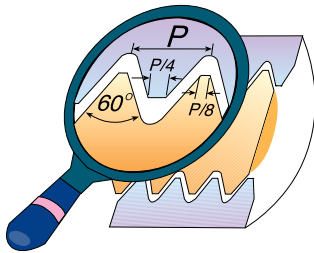
Pitch TPI	L	I.C. in	EXTERNAL			INTERNAL		
			Ordering Code		X Y	Ordering Code		X Y
			Right Hand	Left Hand		Right Hand	Left Hand	
32	6	5/32	ULTRA MINIATURE →			*06 IR 32 UN	*06 IL 32 UN	0.8 0.5
28	6	5/32				*06 IR 28 UN	*06 IL 28 UN	0.8 0.6
24	6	5/32				*06 IR 24 UN	*06 IL 24 UN	0.7 0.6
20	6	5/32				*06 IR 20 UN	*06 IL 20 UN	0.6 0.6
18	6	5/32				*06 IR 18 UN	*06 IL 18 UN	0.6 0.7
32	8	3/16	MINIATURE →			*08 IR 32 UN	*08 IL 32 UN	0.6 0.5
28	8	3/16				*08 IR 28 UN	*08 IL 28 UN	0.6 0.6
24	8	3/16				*08 IR 24 UN	*08 IL 24 UN	0.6 0.6
20	8	3/16				*08 IR 20 UN	*08 IL 20 UN	0.6 0.7
18	8	3/16				*08 IR 18 UN	*08 IL 18 UN	0.6 0.7
16	8	3/16				*08 IR 16 UN	*08 IL 16 UN	0.6 0.7
14	8	3/16				*08 IR 14 UN	*08 IL 14 UN	0.6 0.8
13	8	3/16				**08 IR 13 UN		0.8 0.9
13	8U	3/16U	"U" MINIATURE →			*08U IR/L 13 UN		1.0 4.0
12	8U	3/16U				*08U IR/L 12 UN		0.9 4.0
11	8U	3/16U				*08U IR/L 11 UN		0.9 4.0
72	11	1/4	11 ER 72 UN	11 EL 72 UN	0.8 0.4	11 IR 72 UN	11 IL 72 UN	0.8 0.3
64	11	1/4	11 ER 64 UN	11 EL 64 UN	0.8 0.4	11 IR 64 UN	11 IL 64 UN	0.8 0.4
56	11	1/4	11 ER 56 UN	11 EL 56 UN	0.7 0.4	11 IR 56 UN	11 IL 56 UN	0.7 0.4
48	11	1/4	11 ER 48 UN	11 EL 48 UN	0.6 0.6	11 IR 48 UN	11 IL 48 UN	0.6 0.6
44	11	1/4	11 ER 44 UN	11 EL 44 UN	0.6 0.6	11 IR 44 UN	11 IL 44 UN	0.6 0.6
40	11	1/4	11 ER 40 UN	11 EL 40 UN	0.6 0.6	11 IR 40 UN	11 IL 40 UN	0.6 0.6
36	11	1/4	11 ER 36 UN	11 EL 36 UN	0.6 0.6	11 IR 36 UN	11 IL 36 UN	0.6 0.6
32	11	1/4	11 ER 32 UN	11 EL 32 UN	0.6 0.6	11 IR 32 UN	11 IL 32 UN	0.6 0.6
28	11	1/4	11 ER 28 UN	11 EL 28 UN	0.6 0.7	11 IR 28 UN	11 IL 28 UN	0.6 0.7
27	11	1/4	11 ER 27 UN	11 EL 27 UN	0.7 0.8	11 IR 27 UN	11 IL 27 UN	0.7 0.8
24	11	1/4	11 ER 24 UN	11 EL 24 UN	0.7 0.8	11 IR 24 UN	11 IL 24 UN	0.7 0.8
20	11	1/4	11 ER 20 UN	11 EL 20 UN	0.8 0.9	11 IR 20 UN	11 IL 20 UN	0.8 0.9
18	11	1/4	11 ER 18 UN	11 EL 18 UN	0.8 1.0	11 IR 18 UN	11 IL 18 UN	0.8 1.0
16	11	1/4	11 ER 16 UN	11 EL 16 UN	0.9 1.1	11 IR 16 UN	11 IL 16 UN	0.9 1.1
14	11	1/4	11 ER 14 UN	11 EL 14 UN	0.9 1.1	11 IR 14 UN	11 IL 14 UN	0.9 1.1
13	11	1/4				11 IR 13 UN	11 IL 13 UN	0.8 1.0
12	11	1/4				11 IR 12 UN	11 IL 12 UN	0.9 1.1
11	11	1/4				11 IR 11 UN	11 IL 11 UN	0.8 1.1
72	16	3/8	16 ER 72 UN	16 EL 72 UN	0.8 0.4	16 IR 72 UN	16 IL 72 UN	0.8 0.3
64	16	3/8	16 ER 64 UN	16 EL 64 UN	0.8 0.4	16 IR 64 UN	16 IL 64 UN	0.8 0.4
56	16	3/8	16 ER 56 UN	16 EL 56 UN	0.7 0.4	16 IR 56 UN	16 IL 56 UN	0.7 0.4
48	16	3/8	16 ER 48 UN	16 EL 48 UN	0.6 0.6	16 IR 48 UN	16 IL 48 UN	0.6 0.6
44	16	3/8	16 ER 44 UN	16 EL 44 UN	0.6 0.6	16 IR 44 UN	16 IL 44 UN	0.6 0.6
40	16	3/8	16 ER 40 UN	16 EL 40 UN	0.6 0.6	16 IR 40 UN	16 IL 40 UN	0.6 0.6
36	16	3/8	16 ER 36 UN	16 EL 36 UN	0.6 0.6	16 IR 36 UN	16 IL 36 UN	0.6 0.6

* Available only in BXC and BMA grades

** To be used with Holder SIR 0009 K08 on page 47



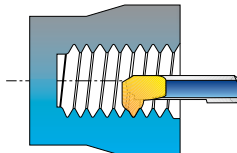
UN - Unified UNC, UNF, UNEF, UNS



Pitch TPI	L	I.C. in	EXTERNAL				INTERNAL				X	Y
			Ordering Code		X	Y	Ordering Code		X	Y		
			Right Hand	Left Hand			Right Hand	Left Hand				
32	16	3/8	16 ER 32 UN	16 EL 32 UN	0.6	0.6	16 IR 32 UN	16 IL 32 UN	0.6	0.6		
28	16	3/8	16 ER 28 UN	16 EL 28 UN	0.6	0.7	16 IR 28 UN	16 IL 28 UN	0.6	0.7		
27	16	3/8	16 ER 27 UN	16 EL 27 UN	0.7	0.8	16 IR 27 UN	16 IL 27 UN	0.7	0.8		
24	16	3/8	16 ER 24 UN	16 EL 24 UN	0.7	0.8	16 IR 24 UN	16 IL 24 UN	0.7	0.8		
20	16	3/8	16 ER 20 UN	16 EL 20 UN	0.8	0.9	16 IR 20 UN	16 IL 20 UN	0.8	0.9		
18	16	3/8	16 ER 18 UN	16 EL 18 UN	0.8	1.0	16 IR 18 UN	16 IL 18 UN	0.8	1.0		
16	16	3/8	16 ER 16 UN	16 EL 16 UN	0.9	1.1	16 IR 16 UN	16 IL 16 UN	0.9	1.1		
14	16	3/8	16 ER 14 UN	16 EL 14 UN	1.0	1.2	16 IR 14 UN	16 IL 14 UN	0.9	1.2		
13	16	3/8	16 ER 13 UN	16 EL 13 UN	1.0	1.3	16 IR 13 UN	16 IL 13 UN	1.0	1.3		
12	16	3/8	16 ER 12 UN	16 EL 12 UN	1.1	1.4	16 IR 12 UN	16 IL 12 UN	1.1	1.4		
11.5	16	3/8	16 ER 11.5 UN	16 EL 11.5 UN	1.1	1.5	16 IR 11.5 UN	16 IL 11.5 UN	1.1	1.5		
11	16	3/8	16 ER 11 UN	16 EL 11 UN	1.1	1.5	16 IR 11 UN	16 IL 11 UN	1.1	1.5		
10	16	3/8	16 ER 10 UN	16 EL 10 UN	1.1	1.5	16 IR 10 UN	16 IL 10 UN	1.1	1.5		
9	16	3/8	16 ER 9 UN	16 EL 9 UN	1.2	1.7	16 IR 9 UN	16 IL 9 UN	1.2	1.7		
8	16	3/8	16 ER 8 UN	16 EL 8 UN	1.2	1.6	16 IR 8 UN	16 IL 8 UN	1.1	1.5		
7	22	1/2	22 ER 7 UN	22 EL 7 UN	1.6	2.3	22 IR 7 UN	22 IL 7 UN	1.6	2.3		
6	22	1/2	22 ER 6 UN	22 EL 6 UN	1.6	2.3	22 IR 6 UN	22 IL 6 UN	1.6	2.3		
5	22	1/2	22 ER 5 UN	22 EL 5 UN	1.7	2.5	22 IR 5 UN	22 IL 5 UN	1.6	2.3		
4.5	22U	1/2U	22U ER/L 4.5 UN		2.0	11.0	22U IR/L 4.5 UN		2.4	11.0		
4	22U	1/2U	22U ER/L 4 UN		2.0	11.0	22U IR/L 4 UN		2.4	11.0		
4.5	27	5/8	27 ER 4.5 UN	27 EL 4.5 UN	1.9	2.7	27 IR 4.5 UN	27 IL 4.5 UN	1.7	2.4		
4	27	5/8	27 ER 4 UN	27 EL 4 UN	2.1	3.0	27 IR 4 UN	27 IL 4 UN	1.8	2.7		
3	27U	5/8U	27U ER/L 3 UN		2.5	13.7	27U IR/L 3 UN		2.7	13.7		
2	33U	3/4U	33U ER/L 2 UN		2.8	16.5	27U IR/L 2 UN		3.6	16.9		

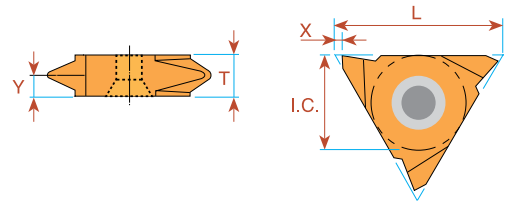
Order example: 22ER 7 UN BMA

For small bore threading see page 83



For Carbide Grade and Cutting Speed see page 60-61

UN - Unified Vertical

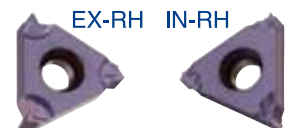


Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y	T
			Ordering Code Right Hand	Ordering Code Left Hand	Ordering Code Right Hand	Ordering Code Left Hand			
32	16	3/8	16V ER 32 UN	16V EL 32 UN			1.0	0.6	3.6
28	16	3/8	16V ER 28 UN	16V EL 28 UN			1.0	0.7	3.6
24	16	3/8	16V ER 24 UN	16V EL 24 UN			1.0	0.8	3.6
20	16	3/8	16V ER 20 UN	16V EL 20 UN			1.0	0.9	3.6
18	16	3/8	16V ER 18 UN	16V EL 18 UN			1.0	1.0	3.6
16	16	3/8	16V ER 16 UN	16V EL 16 UN			1.0	1.1	3.6
14	16	3/8	16V ER 14 UN	16V EL 14 UN			1.0	1.2	3.6
12	16	3/8	16V ER 12 UN	16V EL 12 UN			1.0	1.4	3.6
10	16	3/8	16V ER 10 UN	16V EL 10 UN			1.0	1.5	3.6
8	16	3/8	16V ER 8 UN	16V EL 8 UN			1.0	1.6	3.6
7	22	1/2	22V ER 7 UN	22V EL 7 UN			1.2	2.3	4.8
* 3	27	5/8	27V ER 3 UN	27V EL 3 UN	27V IR 3 UN	27 IL 3 UN	1.8	5.2	10.4

Order example: 22V ER 7UN MXC

* Minimum bore: Ø65 mm

UN - Unified Type B UNC, UNF, UNEF, UNS

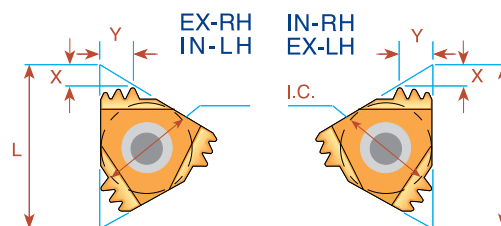
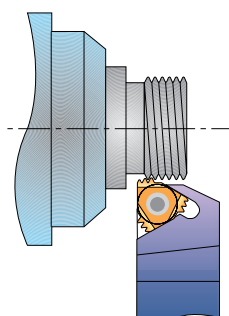


Ground Profile with Sintered Chip-breaker

Pitch TPI	L	I.C. in	EXTERNAL	X	Y	INTERNAL	X	Y
			Ordering Code Right Hand			Ordering Code Right Hand		
32	11	1/4				11 IR B 32 UN	0.6	0.6
28	11	1/4				11 IR B 28 UN	0.6	0.6
24	11	1/4				11 IR B 24 UN	0.6	0.6
20	11	1/4				11 IR B 20 UN	0.8	0.9
18	11	1/4				11 IR B 18 UN	0.8	0.9
16	11	1/4				11 IR B 16 UN	0.8	0.9
14	11	1/4				11 IR B 14 UN	0.8	0.9
12	11	1/4				11 IR B 12 UN	0.8	0.9
24	16	3/8	16 ER B 24 UN	0.7	0.8	16 IR B 24 UN	0.7	0.8
20	16	3/8	16 ER B 20 UN	0.8	0.9	16 IR B 20 UN	0.8	0.9
18	16	3/8	16 ER B 18 UN	0.8	1.0	16 IR B 18 UN	0.8	1.0
16	16	3/8	16 ER B 16 UN	0.9	1.1	16 IR B 16 UN	0.9	1.1
14	16	3/8	16 ER B 14 UN	1.0	1.2	16 IR B 14 UN	0.9	1.2
13	16	3/8	16 ER B 13 UN	1.0	1.3			
12	16	3/8	16 ER B 12 UN	1.1	1.4	16 IR B 12 UN	1.1	1.4
11	16	3/8	16 ER B 11 UN	1.1	1.5			
10	16	3/8	16 ER B 10 UN	1.1	1.5	16 IR B 10 UN	1.1	1.5
9	16	3/8	16 ER B 9 UN	1.2	1.7			
8	16	3/8	16 ER B 8 UN	1.2	1.6	16 IR B 8 UN	1.1	1.1

Order example: 16 IR B 12 UN BMA

Multitooth



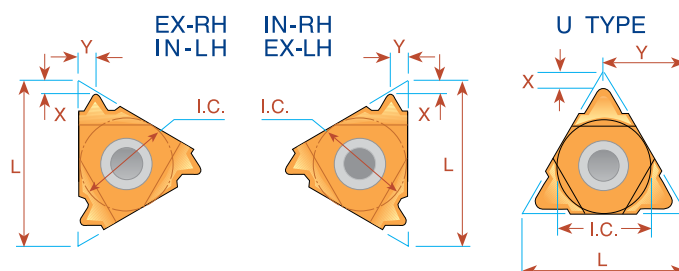
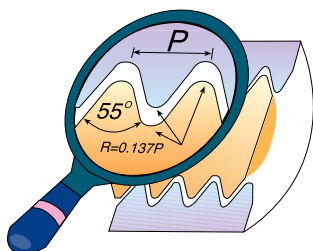
Pitch TPI	L	I.C. in	Number of Teeth	EXTERNAL Ordering Code	Anvil	INTERNAL Ordering Code	Anvil	X	Y
24	16	3/8	2	16 ER 24 UN 2M	AE16M	16 IR 24 UN 2M	AI16M	1.1	1.7
20	16	3/8	2	16 ER 20 UN 2M	AE16M	16 IR 20 UN 2M	AI16M	1.4	2.0
18	16	3/8	2	16 ER 18 UN 2M	AE16M	16 IR 18 UN 2M	AI16M	1.5	2.2
16	16	3/8	2	16 ER 16 UN 2M	AE16M	16 IR 16 UN 2M	AI16M	1.5	2.3
14	16	3/8	2	16 ER 14 UN 2M	AE16M	16 IR 14 UN 2M	AI16M	1.7	2.7
12	16	3/8	2	16 ER 12 UN 2M	AE16M	16 IR 12 UN 2M	AI16M	2.0	3.1
16	22	1/2	3	22 ER 16 UN 3M	AE22M	22 IR 16 UN 3M	AI22M	2.5	4.0
13	22	1/2	3	22 ER 13 UN 3M	AE22M	-		3.0	4.9
12	22	1/2	2	22 ER 12 UN 2M	AE22M	22 IR 12 UN 2M	AI22M	2.2	3.4
12	22	1/2	3	22 ER 12 UN 3M	AE22M	22 IR 12 UN 3M	AI22M	3.3	5.3
8	27	5/8	2	27 ER 8 UN 2M	AE27M	27 IR 8 UN 2M	AI27M	3.1	4.9

Order example: 22 IR 16 UN 3M BMA

For recommended number of passes see page 62

For Carbide Grade and Cutting Speed see page 60-61

Whitworth - 55° BSW, BSF, BSP, BSB

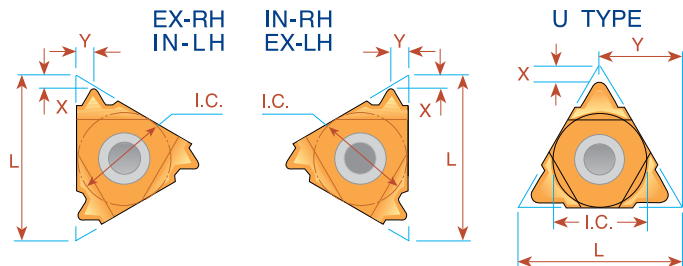
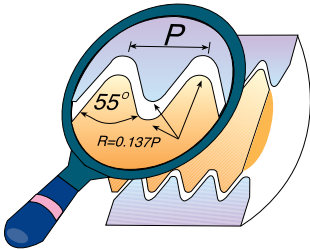


Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Right Hand	Left Hand	Right Hand	Left Hand		
26	6	5/32	ULTRA MINIATURE →		*06 IR 26 W	*06 IL 26 W	0.7	0.6
22	6	5/32			*06 IR 22 W	*06 IL 22 W	0.6	0.6
20	6	5/32			*06 IR 20 W	*06 IL 20 W	0.6	0.7
18	6	5/32			*06 IR 18 W	*06 IL 18 W	0.6	0.7
28	8	3/16	MINIATURE →		*08 IR 28 W	*08 IL 28 W	0.6	0.6
24	8	3/16			*08 IR 24 W	*08 IL 24 W	0.6	0.6
20	8	3/16			*08 IR 20 W	*08 IL 20 W	0.6	0.7
19	8	3/16			*08 IR 19 W	*08 IL 19 W	0.6	0.7
18	8	3/16			*08 IR 18 W	*08 IL 18 W	0.6	0.7
16	8	3/16			*08 IR 16 W	*08 IL 16 W	0.6	0.7
14	8U	3/16U	"U" MINIATURE →		*08U IR/L 14 W		1.0	4.0
12	8U	3/16U			*08U IR/L 12 W		0.9	4.0
11	8U	3/16U			*08U IR/L 11 W		0.9	4.0
72	11	1/4	11 ER 72 W	11 EL 72 W	11 IR 72 W	11 IL 72 W	0.7	0.4
60	11	1/4	11 ER 60 W	11 EL 60 W	11 IR 60 W	11 IL 60 W	0.7	0.4
56	11	1/4	11 ER 56 W	11 EL 56 W	11 IR 56 W	11 IL 56 W	0.7	0.4
48	11	1/4	11 ER 48 W	11 EL 48 W	11 IR 48 W	11 IL 48 W	0.6	0.6
40	11	1/4	11 ER 40 W	11 EL 40 W	11 IR 40 W	11 IL 40 W	0.6	0.6
36	11	1/4	11 ER 36 W	11 EL 36 W	11 IR 36 W	11 IL 36 W	0.6	0.6
32	11	1/4	11 ER 32 W	11 EL 32 W	11 IR 32 W	11 IL 32 W	0.6	0.6
28	11	1/4	11 ER 28 W	11 EL 28 W	11 IR 28 W	11 IL 28 W	0.6	0.7
26	11	1/4	11 ER 26 W	11 EL 26 W	11 IR 26 W	11 IL 26 W	0.7	0.7
24	11	1/4	11 ER 24 W	11 EL 24 W	11 IR 24 W	11 IL 24 W	0.7	0.8
22	11	1/4	11 ER 22 W	11 EL 22 W	11 IR 22 W	11 IL 22 W	0.8	0.9
20	11	1/4	11 ER 20 W	11 EL 20 W	11 IR 20 W	11 IL 20 W	0.8	0.9
19	11	1/4	11 ER 19 W	11 EL 19 W	11 IR 19 W	11 IL 19 W	0.8	1.0
18	11	1/4	11 ER 18 W	11 EL 18 W	11 IR 18 W	11 IL 18 W	0.8	1.0
16	11	1/4	11 ER 16 W	11 EL 16 W	11 IR 16 W	11 IL 16 W	0.9	1.1
14	11	1/4	11 ER 14 W	11 EL 14 W	11 IR 14 W	11 IL 14 W	0.9	1.1
12	11	1/4			11 IR 12 W	11 IL 12 W	0.1	1.1
11	11	1/4			(1) 11 IR 11 W	(1) 11 IL 11 W	0.9	1.2
72	16	3/8	16 ER 72 W	16 EL 72 W	16 IR 72 W	16 IL 72 W	0.7	0.4
60	16	3/8	16 ER 60 W	16 EL 60 W	16 IR 60 W	16 IL 60 W	0.7	0.4
56	16	3/8	16 ER 56 W	16 EL 56 W	16 IR 56 W	16 IL 56 W	0.7	0.4
48	16	3/8	16 ER 48 W	16 EL 48 W	16 IR 48 W	16 IL 48 W	0.6	0.6
40	16	3/8	16 ER 40 W	16 EL 40 W	16 IR 40 W	16 IL 40 W	0.6	0.6
36	16	3/8	16 ER 36 W	16 EL 36 W	16 IR 36 W	16 IL 36 W	0.6	0.6
32	16	3/8	16 ER 32 W	16 EL 32 W	16 IR 32 W	16 IL 32 W	0.6	0.6
28	16	3/8	16 ER 28 W	16 EL 28 W	16 IR 28 W	16 IL 28 W	0.6	0.7
26	16	3/8	16 ER 26 W	16 EL 26 W	16 IR 26 W	16 IL 26 W	0.7	0.7
24	16	3/8	16 ER 24 W	16 EL 24 W	16 IR 24 W	16 IL 24 W	0.7	0.8

* Available only in BXC and BMA grades

(1) Special holder is required or standard holder can be amended by customer.

Whitworth - 55° BSW, BSF, BSP, BSB



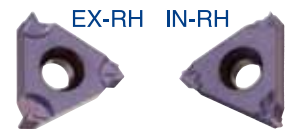
Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand	Ordering Code Right Hand	Ordering Code Left Hand		
22	16	3/8	16 ER 22 W	16 EL 22 W	16 IR 22 W	16 IL 22 W	0.8	0.9
20	16	3/8	16 ER 20 W	16 EL 20 W	16 IR 20 W	16 IL 20 W	0.8	0.9
19	16	3/8	16 ER 19 W	16 EL 19 W	16 IR 19 W	16 IL 19 W	0.8	1.0
18	16	3/8	16 ER 18 W	16 EL 18 W	16 IR 18 W	16 IL 18 W	0.8	1.0
16	16	3/8	16 ER 16 W	16 EL 16 W	16 IR 16 W	16 IL 16 W	0.9	1.1
14	16	3/8	16 ER 14 W	16 EL 14 W	16 IR 14 W	16 IL 14 W	1.0	1.2
12	16	3/8	16 ER 12 W	16 EL 12 W	16 IR 12 W	16 IL 12 W	1.1	1.4
11	16	3/8	16 ER 11 W	16 EL 11 W	16 IR 11 W	16 IL 11 W	1.1	1.5
10	16	3/8	16 ER 10 W	16 EL 10 W	16 IR 10 W	16 IL 10 W	1.1	1.5
9	16	3/8	16 ER 9 W	16 EL 9 W	16 IR 9 W	16 IL 9 W	1.2	1.7
8	16	3/8	16 ER 8 W	16 EL 8 W	16 IR 8 W	16 IL 8 W	1.2	1.5
7	22	1/2	22 ER 7 W	22 EL 7 W	22 IR 7 W	22 IL 7 W	1.6	2.3
6	22	1/2	22 ER 6 W	22 EL 6 W	22 IR 6 W	22 IL 6 W	1.6	2.3
5	22	1/2	22 ER 5 W	22 EL 5 W	22 IR 5 W	22 IL 5 W	1.7	2.4
4.5	22U	1/2U	22U E/R/L 4.5 W				2.3	11.0
4	22U	1/2U	22U E/R/L 4 W				2.8	11.0
4.5	27	5/8	27 ER 4.5 W	27 EL 4.5 W	27 IR 4.5 W	27 IL 4.5 W	1.8	2.6
4	27	5/8	27 ER 4 W	27 EL 4 W	27 IR 4 W	27 IL 4 W	2.0	2.9
3.5	27U	5/8U	27U E/R/L 3.5 W				2.1	13.7
3.25	27U	5/8U	27U E/R/L 3.25 W				2.0	13.7
3	27U	5/8U	27U E/R/L 3 W				2.3	13.7
2.75	27U	5/8U	27U E/R/L 2.75 W				2.4	13.7

Order example: 16 IR 18 W BMA

Whitworth - 55° BSW, BSF, BSP, BSB

Type B

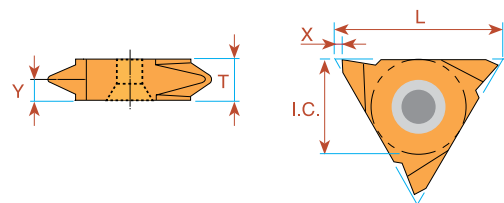
Ground Profile with Sintered Chip-breaker



Pitch TPI	L	I.C. in	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y
28	11	1/4		11 IR B 28 W	0.6	0.6
24	11	1/4		11 IR B 24 W	0.6	0.6
20	11	1/4		11 IR B 20 W	0.8	0.9
19	11	1/4		11 IR B 19 W	0.8	0.9
18	11	1/4		11 IR B 18 W	0.8	0.9
16	11	1/4		11 IR B 16 W	0.8	0.9
14	11	1/4		11 IR B 14 W	0.8	0.9
19	16	3/8	16 ER B 19 W	16 IR B 19 W	0.8	1.0
16	16	3/8	16 ER B 16 W	16 IR B 16 W	0.9	1.1
14	16	3/8	16 ER B 14 W	16 IR B 14 W	1.0	1.2
11	16	3/8	16 ER B 11 W	16 IR B 11 W	1.1	1.5
10	16	3/8	16 ER B 10 W	16 IR B 10 W	1.1	1.5

Order example: 16 IR B 10 W BMA

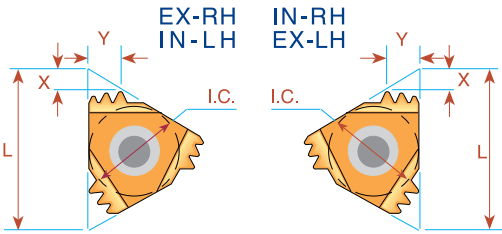
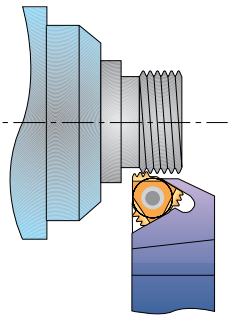
Vertical



Pitch TPI	L	I.C. in	EXTERNAL Ordering Code Right Hand	EXTERNAL Ordering Code Left Hand	X	Y	T
20	16	3/8	16V ER 20 W	16V EL 20 W	1.0	0.9	3.6
19	16	3/8	16V ER 19 W	16V EL 19 W	1.0	0.9	3.6
18	16	3/8	16V ER 18 W	16V EL 18 W	1.0	1.0	3.6
16	16	3/8	16V ER 16 W	16V EL 16 W	1.0	1.0	3.6
14	16	3/8	16V ER 14 W	16V EL 14 W	1.0	1.2	3.6
12	16	3/8	16V ER 12 W	16V EL 12 W	1.0	1.4	3.6
11	16	3/8	16V ER 11 W	16V EL 11 W	1.0	1.5	3.6

Order example: 16V ER 14 W MXC

Multitooth



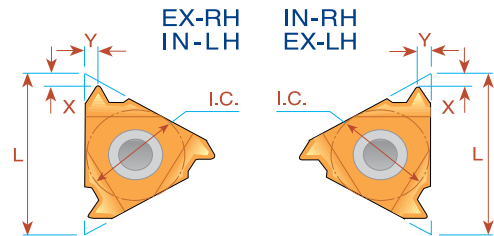
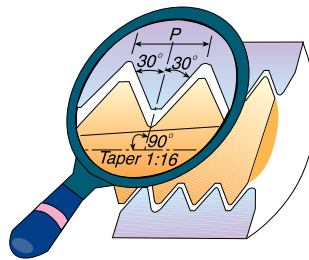
Pitch TPI	L	I.C. in	Number of Teeth	EXTERNAL	Anvil	INTERNAL	Anvil	X	Y
				Ordering Code		Ordering Code			
14	16	3/8	2	16 ER 14 W 2M	AE16M	16 IR 14 W 2M	AI16M	1.7	2.7
14	22	1/2	3	22 ER 14 W 3M	AE22M	22 IR 14 W 3M	AI22M	2.8	4.5
11	22	1/2	2	22 ER 11 W 2M	AE22M	22 IR 11 W 2M	AI22M	2.3	3.4

Order example: 16 ER 14 W 2M MXC

For recommended number of passes see page 62

For Carbide Grade and Cutting Speed see page 60-61

NPT



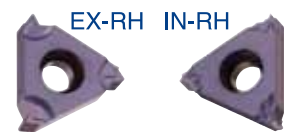
Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand	Ordering Code Right Hand	Ordering Code Left Hand		
27	6	5/32	<i>ULTRA MINIATURE</i> →		*06 IR 27 NPT	*06 IL 27 NPT	0.6	0.6
27	8	3/16			*08 IR 27 NPT	*08 IL 27 NPT	0.6	0.6
18	8	3/16	<i>MINIATURE</i> →		*08 IR 18 NPT	*08 IL 18 NPT	0.6	0.6
27	11	1/4	11 ER 27 NPT	11 EL 27 NPT	11 IR 27 NPT	11 IL 27 NPT	0.7	0.8
18	11	1/4	11 ER 18 NPT	11 EL 18 NPT	11 IR 18 NPT	11 IL 18 NPT	0.8	1.0
14	11	1/4	11 ER 14 NPT	11 EL 14 NPT	11 IR 14 NPT	11 IL 14 NPT	0.8	1.0
27	16	3/8	16 ER 27 NPT	16 EL 27 NPT	16 IR 27 NPT	16 IL 27 NPT	0.7	0.8
18	16	3/8	16 ER 18 NPT	16 EL 18 NPT	16 IR 18 NPT	16 IL 18 NPT	0.8	1.0
14	16	3/8	16 ER 14 NPT	16 EL 14 NPT	16 IR 14 NPT	16 IL 14 NPT	0.9	1.2
11.5	16	3/8	16 ER 11.5 NPT	16 EL 11.5 NPT	16 IR 11.5 NPT	16 IL 11.5 NPT	1.1	1.5
8	16	3/8	16 ER 8 NPT	16 EL 8 NPT	16 IR 8 NPT	16 IL 8 NPT	1.3	1.8

Order example: 16 ER 14 NPT MXC

* Available only in BXC and BMA grades

Type B

Ground Profile with Sintered Chip-breaker

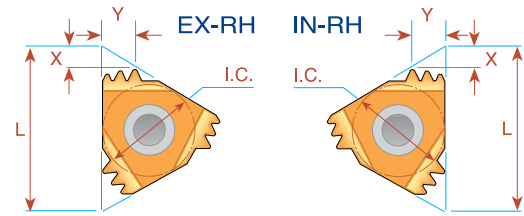
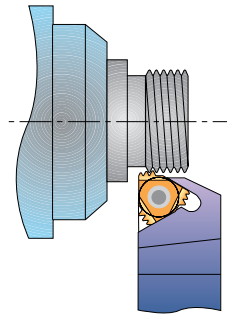


Pitch TPI	L	I.C. in	EXTERNAL	INTERNAL	X	Y
			Ordering Code Right Hand	Ordering Code Right Hand		
18	11	1/4		11 IR B 18 NPT	0.8	0.9
18	16	3/8	16 ER B 18 NPT	16 IR B 18 NPT	0.8	1.0
14	16	3/8	16 ER B 14 NPT	16 IR B 14 NPT	0.9	1.2
11.5	16	3/8	16 ER B 11.5 NPT	16 IR B 11.5 NPT	1.1	1.5
8	16	3/8	16 ER B 8 NPT	16 IR B 8 NPT	1.3	1.8

Order example: 16 IR B 11.5 NPT BMA

For Carbide Grade and Cutting Speed see page 60-61

NPT Multitooth

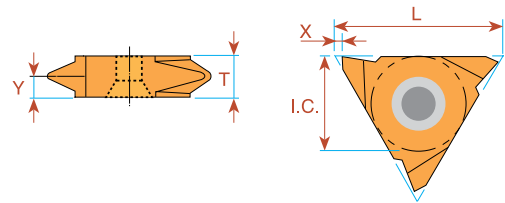


Pitch TPI	L	I.C. in	Number of Teeth	EXTERNAL Ordering Code	Anvil	INTERNAL Ordering Code	Anvil	X	Y
14	16	3/8	2	16 ER 14 NPT 2M	AE16M	16 IR 14 NPT 2M	AI16M	1.7	2.8
11.5	22	1/2	2	22 ER 11.5 NPT 2M	AE22M	22 IR 11.5 NPT 2M	AI22M	2.3	3.5
11.5	27	5/8	3	27 ER 11.5 NPT 3M	AE27M	27 IR 11.5 NPT 3M	AI27M	3.3	5.5
8	27	5/8	2	27 ER 8 NPT 2M	AE27M	27 IR 8 NPT 2M	AI27M	3.1	5.0

Order example: 22 ER 11.5 NPT 2M MXC

For recommended number of passes see page 62

NPT Vertical

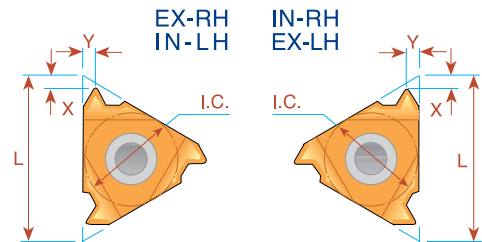
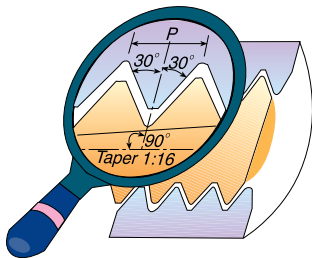


Pitch TPI	L	I.C. in	EXTERNAL Ordering Code Right Hand	EXTERNAL Ordering Code Left Hand	X	Y	T
27	16	3/8	16V ER 27 NPT	16V EL 27 NPT	1.0	0.8	3.6
18	16	3/8	16V ER 18 NPT	16V EL 18 NPT	1.0	1.0	3.6
14	16	3/8	16V ER 14 NPT	16V EL 14 NPT	1.0	1.2	3.6
11.5	16	3/8	16V ER 11.5 NPT	16V EL 11.5 NPT	1.0	1.5	3.6

Order example: 16V ER 14 NPT BMA

For Carbide Grade and Cutting Speed see page 60-61

NPTF - Dryseal



Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand	Ordering Code Right Hand	Ordering Code Left Hand		
27	6	5/32	<i>ULTRA MINIATURE</i> →		*06 IR 27 NPTF	*06 IL 27 NPTF	0.7	0.6
27	8	3/16	<i>MINIATURE</i> →		*08 IR 27 NPTF	*08 IL 27 NPTF	0.6	0.6
18	8	3/16			*08 IR 18 NPTF	*08 IL 18 NPTF	0.6	0.6
27	11	1/4	11 ER 27 NPTF	11 EL 27 NPTF	11 IR 27 NPTF	11 IL 27 NPTF	0.7	0.7
18	11	1/4	11 ER 18 NPTF	11 EL 18 NPTF	11 IR 18 NPTF	11 IL 18 NPTF	0.8	1.0
14	11	1/4	11 ER 14 NPTF	11 EL 14 NPTF	11 IR 14 NPTF	11 IL 14 NPTF	0.8	1.0
27	16	3/8	16 ER 27 NPTF	16 EL 27 NPTF	16 IR 27 NPTF	16 IL 27 NPTF	0.7	0.7
18	16	3/8	16 ER 18 NPTF	16 EL 18 NPTF	16 IR 18 NPTF	16 IL 18 NPTF	0.8	1.0
14	16	3/8	16 ER 14 NPTF	16 EL 14 NPTF	16 IR 14 NPTF	16 IL 14 NPTF	0.9	1.2
11.5	16	3/8	16 ER 11.5 NPTF	16 EL 11.5 NPTF	16 IR 11.5 NPTF	16 IL 11.5 NPTF	1.1	1.5
8	16	3/8	16 ER 8 NPTF	16 EL 8 NPTF	16 IR 8 NPTF	16 IL 8 NPTF	1.3	1.8

Order example: 11 ER 27 NPTF MXC

* Available only in BXC and BMA grades

Type B

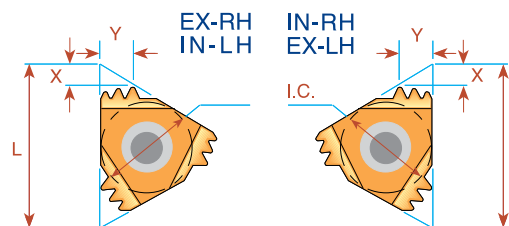
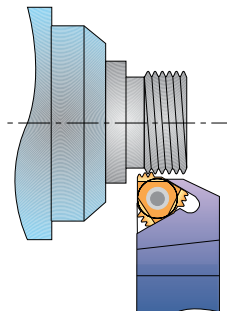
Ground Profile with Sintered Chip-breaker

Pitch TPI	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
18	11	1/4	11 IR B 18 NPTF	0.8	0.9



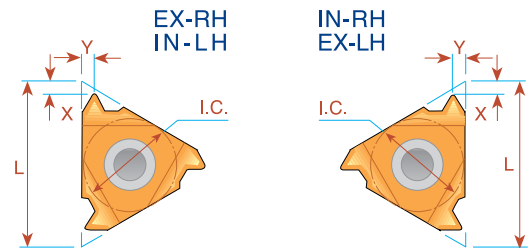
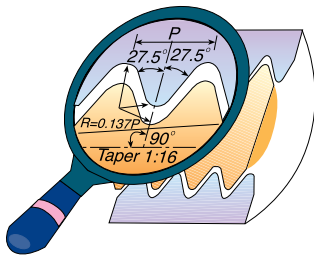
For Carbide Grade and Cutting Speed see page 60-61

Multitooth



Pitch TPI	L	I.C. in	Number of Teeth	EXTERNAL Ordering Code	Anvil	INTERNAL Ordering Code	Anvil	X	Y
11.5	22	1/2	2	22 ER 11.5 NPTF 2M	AE22M	22 IR 11.5 NPTF 2M	AI22M	2.3	3.5

BSPT



Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand	Ordering Code Right Hand	Ordering Code Left Hand		
28	6	5/32	<i>ULTRA MINIATURE</i> →		*06 IR 28 BSPT	*06 IL 28 BSPT	0.7	0.6
28	8	3/16			*08 IR 28 BSPT	*08 IL 28 BSPT	0.6	0.6
19	8	3/16	<i>MINIATURE</i> →		*08 IR 19 BSPT	*08 IL 19 BSPT	0.6	0.6
28	11	1/4			11 IR 28 BSPT	11 IL 28 BSPT	0.6	0.6
19	11	1/4			11 IR 19 BSPT	11 IL 19 BSPT	0.8	0.9
14	11	1/4			11 IR 14 BSPT	11 IL 14 BSPT	0.9	1.0
11	11	1/4			⁽¹⁾ 11 IR 11 BSPT	⁽¹⁾ 11 IL 11 BSPT	0.9	1.2
28	16	3/8	16 ER 28 BSPT	16 EL 28 BSPT	16 IR 28 BSPT	16 IL 28 BSPT	0.6	0.6
19	16	3/8	16 ER 19 BSPT	16 EL 19 BSPT	16 IR 19 BSPT	16 IL 19 BSPT	0.8	0.9
14	16	3/8	16 ER 14 BSPT	16 EL 14 BSPT	16 IR 14 BSPT	16 IL 14 BSPT	1.0	1.2
11	16	3/8	16 ER 11 BSPT	16 EL 11 BSPT	16 IR 11 BSPT	16 IL 11 BSPT	1.1	1.5

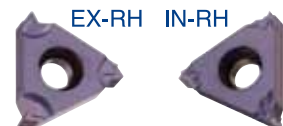
Order example: 11 IR 14 BSPT BMA

* Available only in BXC and BMA grades

(1) Special holder is required or standard holder can be amended by customer.

Type B

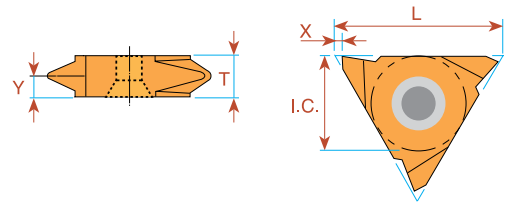
Ground Profile with Sintered Chip-breaker



Pitch TPI	L	I.C. in	EXTERNAL	INTERNAL	X	Y
			Ordering Code Right Hand	Ordering Code Right Hand		
19	11	1/4		11 IR B 19 BSPT	0.8	0.9
19	16	3/8	16 ER B 19 BSPT		1.0	1.1
14	16	3/8	16 ER B 14 BSPT	16 IR B 14 BSPT	1.2	1.0
11	16	3/8	16 ER B 11 BSPT	16 IR B 11 BSPT	1.5	1.1

Order example: 16 ER B 11 BSPT BMA

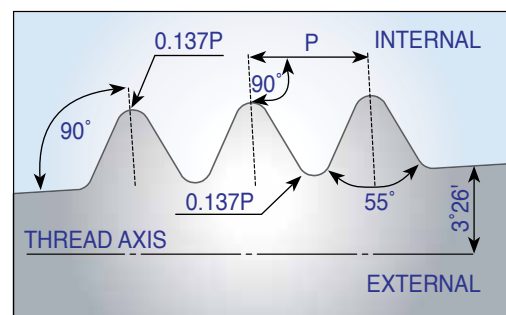
BSPT Vertical



Pitch TPI	L	I.C. in	EXTERNAL Ordering Code Right Hand	EXTERNAL Ordering Code Left Hand	X	Y	T
28	16	3/8	16V ER 28 BSPT	16V EL 28 BSPT	1.0	0.6	3.6
19	16	3/8	16V ER 19 BSPT	16V EL 19 BSPT	1.0	0.9	3.6
14	16	3/8	16V ER 14 BSPT	16V EL 14 BSPT	1.0	1.2	3.6
11	16	3/8	16V ER 11 BSPT	16V EL 11 BSPT	1.0	1.5	3.6

Order example: 16V ER 19 BSPT BMA

DIN 477



Pitch TPI	L	I.C. in	Taper Ratio	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y	Thread Designation
14	16	3/8	3/25	16 ER 14 DIN477		1.0	1.2	W19.8x1/14 keg(Ext.)
14	11	1/4	3/25		*11 IR 14 DIN477	0.9	1.0	W19.8x1/14 keg(Int.)
14	16	3/8	3/25	16 ER 14 DIN477	**16 IR 14 DIN477	1.0	1.2	W28.8x1/14 keg
14	16	3/8	3/25	16 ER 14 DIN477	***16 IR 14 DIN477	1.0	1.2	W31.3x1/14 keg

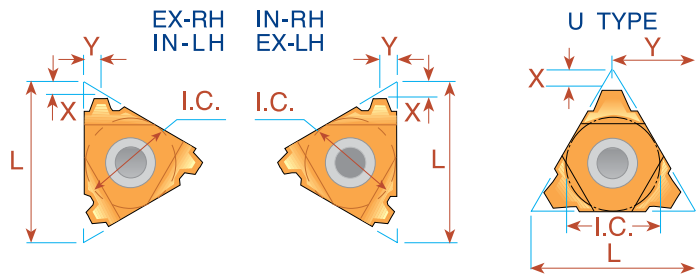
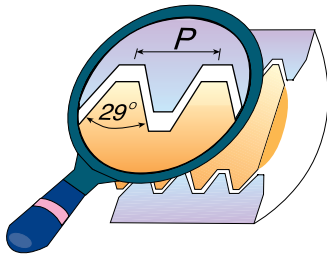
* Holder to use: SIR0010H11/SIR0010K11

** Holder to use: SIR0016P16

*** Holder to use: SIR0020P16

For Carbide Grade and Cutting Speed see page 60-61

Acme



Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Right Hand	Left Hand	Right Hand	Left Hand		
16	8	3/16	<i>MINIATURE</i> →		**08 IR 16 ACME	**08 IL 16 ACME	0.6	0.6
14	8U	3/16U	<i>"U" MINIATURE</i> →		*08U IR/L 14 ACME		0.8	4.0
12	8U	3/16U			*08U IR/L 12 ACME		0.8	4.0
10	8U	3/16U			*08U IR/L 10 ACME		0.8	4.0
16	11	1/4	11 ER 16 ACME	11 EL 16 ACME	11 IR 16 ACME	11 IL 16 ACME	0.9	1.0
16	16	3/8	16 ER 16 ACME	16 EL 16 ACME	16 IR 16 ACME	16 IL 16 ACME	0.9	1.0
14	16	3/8	16 ER 14 ACME	16 EL 14 ACME	16 IR 14 ACME	16 IL 14 ACME	1.0	1.2
12	16	3/8	16 ER 12 ACME	16 EL 12 ACME	16 IR 12 ACME	16 IL 12 ACME	1.1	1.2
10	16	3/8	16 ER 10 ACME	16 EL 10 ACME	16 IR 10 ACME	16 IL 10 ACME	1.3	1.3
8	16	3/8	16 ER 8 ACME	16 EL 8 ACME	16 IR 8 ACME	16 IL 8 ACME	1.5	1.5
6	16	3/8	⁽¹⁾ 16 ER 6 ACME	⁽¹⁾ 16 EL 6 ACME	⁽¹⁾ 16 IR 6 ACME	⁽¹⁾ 16 IL 6 ACME	1.7	1.8
6	22	1/2	22 ER 6 ACME	22 EL 6 ACME	22 IR 6 ACME	22 IL 6 ACME	1.8	2.1
5	22	1/2	22 ER 5 ACME	22 EL 5 ACME	22 IR 5 ACME	22 IL 5 ACME	2.0	2.3
4	22	1/2	⁽¹⁾ 22 ER 4 ACME	⁽¹⁾ 22 EL 4 ACME	⁽¹⁾ 22 IR 4 ACME	⁽¹⁾ 22 IL 4 ACME	2.1	2.2
4	22U	1/2U	22U ER/L 4 ACME		22U IR/L 4 ACME		2.3	11.0
4	27	5/8	27 ER 4 ACME	27 EL 4 ACME	27 IR 4 ACME	27 IL 4 ACME	2.3	2.7
3	27U	5/8U	27U ER/L 3 ACME		27U IR/L 3 ACME		2.8	13.7
2	33U	3/4U	33U ER/L 2 ACME		33U IR/L 2 ACME		4.3	16.9

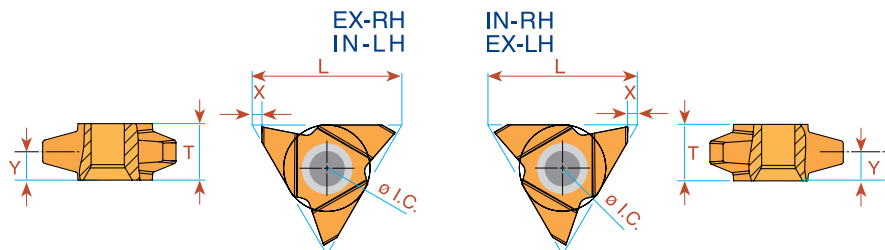
Order example: 16 ER 16 ACME MXC

* Available only in BXC and BMA grades

** One cutting edge

(1) Special holder is required or standard holder can be amended by customer.

Acme Vertical



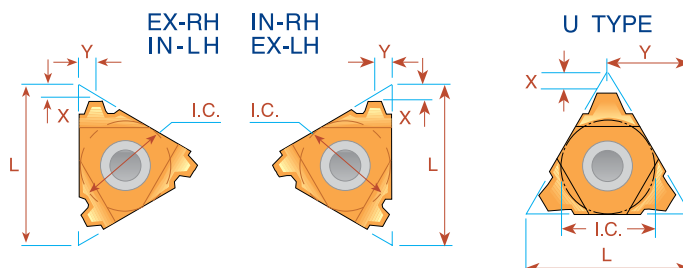
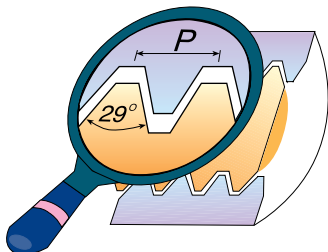
Pitch TPI	L	I.C. in	EXTERNAL		X	Y	T	INTERNAL		X	Y	T
			Right Hand	Left Hand				Right Hand	Left Hand			
* 3.5	27	5/8	27V ER 3.5 ACME	_____	1.8	5.0	10.4	27V IR 3.5 ACME	_____	1.8	4.0	10.4
* 3	27	5/8	27V ER 3 ACME	_____	1.8	5.0	10.4	27V IR 3 ACME	_____	1.8	4.6	10.4
** 2	27	5/8	27V ER 2 ACME	27V EL 2 ACME	1.8	5.0	10.4	27V IR 2 ACME	27V IL 2 ACME	1.8	5.0	10.4

Order example: 27V ER 2 ACME BMA

* Minimum bore: Ø55 mm ** Minimum bore: Ø76 mm

For Carbide Grade and Cutting Speed see page 60-61

Stub Acme



Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand	Ordering Code Right Hand	Ordering Code Left Hand		
16	8	3/16	<i>MINIATURE</i> →		**08 IR 16 STACME	**08 IL 16 STACME	0.6	0.6
14	8U	3/16U	<i>"U" MINIATURE</i> →		*08U IR/L 14 STACME		0.8	4.0
12	8U	3/16U			*08U IR/L 12 STACME		0.9	4.0
10	8U	3/16U			*08U IR/L 10 STACME		1.0	4.0
16	11	1/4	11 ER 16 STACME	11 EL 16 STACME			1.0	1.0
16	16	3/8	16 ER 16 STACME	16 EL 16 STACME	16 IR 16 STACME	16 IL 16 STACME	1.0	1.0
14	16	3/8	16 ER 14 STACME	16 EL 14 STACME	16 IR 14 STACME	16 IL 14 STACME	1.1	1.1
12	16	3/8	16 ER 12 STACME	16 EL 12 STACME	16 IR 12 STACME	16 IL 12 STACME	1.2	1.2
10	16	3/8	16 ER 10 STACME	16 EL 10 STACME	16 IR 10 STACME	16 IL 10 STACME	1.3	1.3
8	16	3/8	16 ER 8 STACME	16 EL 8 STACME	16 IR 8 STACME	16 IL 8 STACME	1.5	1.5
6	16	3/8	16 ER 6 STACME	16 EL 6 STACME	16 IR 6 STACME	16 IL 6 STACME	1.8	1.8
5	22	1/2	22 ER 5 STACME	22 EL 5 STACME	22 IR 5 STACME	22 IL 5 STACME	2.0	2.3
4	22	1/2	22 ER 4 STACME	22 EL 4 STACME	22 IR 4 STACME	22 IL 4 STACME	2.3	2.4
4	22U	1/2U	22U ER/L 4 STACME		22U IR/L 4 STACME		2.5	11.0
3	22U	1/2U	22U ER/L 3 STACME		22U IR/L 3 STACME		3.3	11.0
4	27	5/8	27 ER 4 STACME	27 EL 4 STACME	27 IR 4 STACME	27 IL 4 STACME	2.3	2.4
3	27	5/8	27 ER 3 STACME	27 EL 3 STACME	27 IR 3 STACME	27 IL 3 STACME	2.8	2.9
2	33U	3/4U	33U ER/L 2 STACME		33U IR/L 2 STACME		5.0	16.9

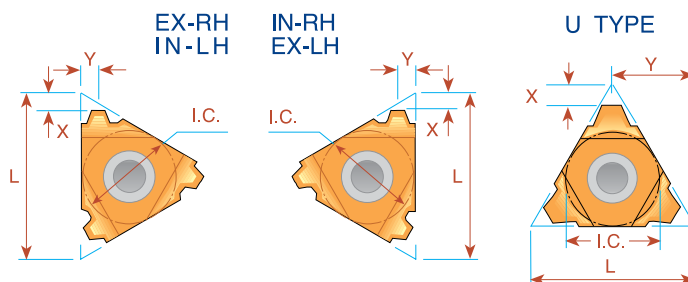
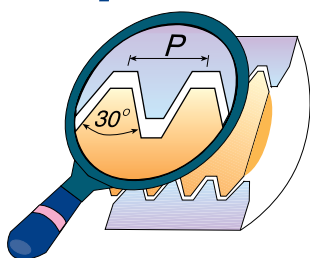
Order example: 22 IR 5 STACME MXC

* Available only in BXC and BMA grades

** One cutting edge

For Carbide Grade and Cutting Speed see page 60-61

Trapez - DIN 103



Pitch mm	L	I.C. in	EXTERNAL Ordering Code		INTERNAL Ordering Code		X	Y
			Right Hand	Left Hand	Right Hand	Left Hand		
1.5	8	3/16	MINIATURE		**08 IR 1.5 TR	**08 IL 1.5 TR	0.6	0.6
2.0	8U	3/16U	"U" MINIATURE		*08U IR/L 2 TR		0.9	4.0
1.5	16	3/8	16 ER 1.5 TR	16 EL 1.5 TR			1.0	1.1
2.0	16	3/8	16 ER 2 TR	16 EL 2 TR	16 IR 2 TR	16 IL 2 TR	1.0	1.3
3.0	16	3/8	16 ER 3 TR	16 EL 3 TR	16 IR 3 TR	16 IL 3 TR	1.3	1.5
4.0	16	3/8	⁽¹⁾ 16 ER 4 TR	⁽¹⁾ 16 EL 4 TR	⁽²⁾ 16 IR 4 TR	⁽²⁾ 16 IL 4 TR	1.3	1.5
5.0	16	3/8U			***16U IR/L 5 TR		2.3	8.2
4.0	22	1/2	22 ER 4 TR	22 EL 4 TR	22 IR 4 TR	22 IL 4 TR	1.8	1.9
5.0	22	1/2	22 ER 5 TR	22 EL 5 TR	22 IR 5 TR	22 IL 5 TR	2.0	2.4
6.0	22	1/2	⁽¹⁾ 22 ER 6 TR	⁽¹⁾ 22 EL 6 TR	⁽¹⁾ 22 IR 6 TR	⁽¹⁾ 22 IL 6 TR	2.0	2.4
6.0	22U	1/2U	22U ER/L 6 TR		22U IR/L 6 TR		2.0	11.0
7.0	22U	1/2U	22U ER/L 7 TR		22U IR/L 7 TR		2.3	11.0
⁽³⁾ 7.0	22U	1/2U			(3) 22U IR/L 7 TR40		2.6	11.0
8.0	22U	1/2U	22U ER/L 8 TR		22U IR/L 8 TR		2.5	11.0
6.0	27	5/8	27 ER 6 TR	27 EL 6 TR	27 IR 6 TR	27 IL 6 TR	2.3	2.7
7.0	27	5/8	27 ER 7 TR	27 EL 7 TR	27 IR 7 TR	27 IL 7 TR	2.2	2.6
8.0	27U	5/8U	27U ER/L 8 TR		27U IR/L 8 TR		2.5	13.7
9.0	27U	5/8U	27U ER/L 9 TR		27U IR/L 9 TR		3.0	13.7
10.0	27U	5/8U	**27U ER/L 10 TR		**27U IR/L 10 TR		3.2	13.7
12.0	33U	3/4U	33U ER/L 12 TR		33U IR/L 12 TR		3.9	16.9

Order example: 22 IR 5 TR MXC

* Available only in BXC and BMA grades

** One cutting edge

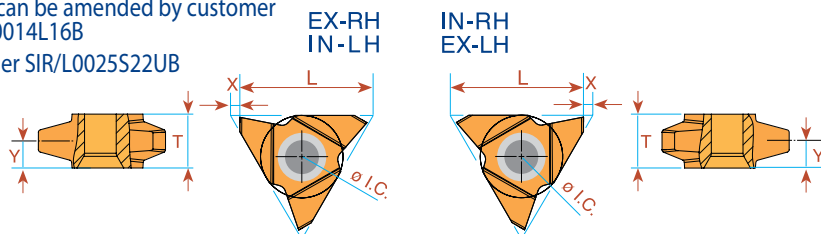
*** To be used only with holder SIR/L0014M16UB on page 47

(1) Special holder is required or standard holder can be amended by customer.

(2) Special holder is required or standard holder can be amended by customer or to used with holders: SIR/L0012L16B; SIR/L0014L16B

(3) Only for Tr 40 x 7.0. To be used only with holder SIR/L0025S22UB

Trapez - DIN 103 Vertical



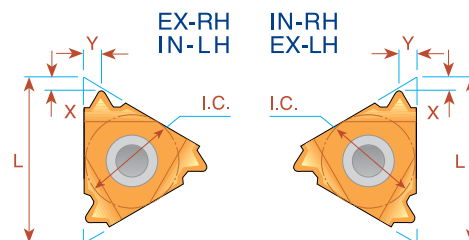
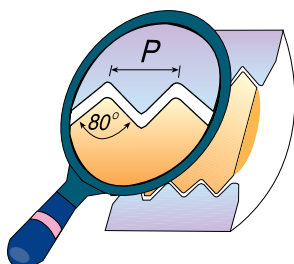
Pitch mm	L	I.C. in	EXTERNAL Ordering Code		INTERNAL Ordering Code		X	Y	T
			Right Hand	Left Hand	Right Hand	Left Hand			
* 9	27	5/8	27V ER 9 TR	27V EL 9 TR	27V IR 9 TR	27V IL 9 TR	1.8	5.2	10.4
* 10	27	5/8	27V ER 10 TR	27V EL 10 TR	27V IR 10 TR	27V IL 10 TR	1.8	5.2	10.4
** 12	27	5/8	27V ER 12 TR	27V EL 12 TR	27V IR 12 TR	27V IL 12 TR	1.8	5.2	10.4

Order example: 27V ER 10 TR BMA

* Minimum bore: Ø65 mm ** Minimum bore: Ø73 mm

For Carbide Grade and Cutting Speed see page 60-61

PG - DIN 40430

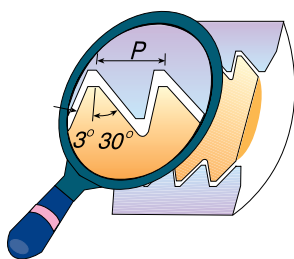


Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Right Hand	Standard	Right Hand	Standard		
20	8	3/16	MINIATURE →		*08 IR 20 PG	(PG 7)	0.6	0.7
18	11	1/4			11 IR 18 PG	(PG 9)	0.8	0.9
20	16	3/8	16 ER 20 PG	(PG 7)			0.7	0.8
18	16	3/8	16 ER 18 PG	(PG 9, 11, 13.5, 16)	16 IR 18 PG	(PG 11, 13.5, 16)	0.8	0.9
16	16	3/8	16 ER 16 PG	(PG 21, 29, 36, 42, 48)	16 IR 16 PG	(PG 21, 29, 36, 42, 48)	0.8	1.0

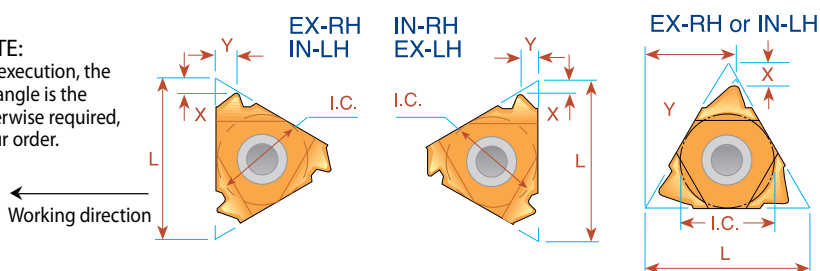
Order example: 16 ER 16 PG BMA

* Available only in BXC and BMA grades

Sagengewinde- DIN 513



IMPORTANT NOTE:
In Carmex standard execution, the flank with the large angle is the leading edge. If otherwise required, please specify in your order.



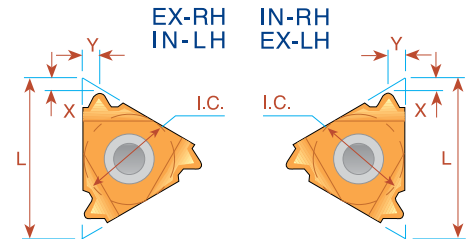
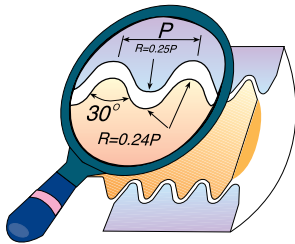
Pitch mm	L	I.C. in	EXTERNAL		X	Y	INTERNAL		X	Y
			Right Hand	Left Hand			Right Hand	Left Hand		
2.0	16	3/8	16 ER 2 SAGE	16 EL 2 SAGE	1.1	1.6	16 IR 2 SAGE	16 IL 2 SAGE	1.2	1.7
3.0	22	1/2	22 ER 3 SAGE	22 EL 3 SAGE	1.5	2.4	22 IR 3 SAGE	22 IL 3 SAGE	1.9	2.9
4.0	22	1/2	22 ER 4 SAGE	22 EL 4 SAGE	1.9	3.1	22 IR 4 SAGE	22 IL 4 SAGE	2.3	3.5
*5.0	22U	1/2U	22U ER 5 SAGE	22U EL 5 SAGE	1.2	11.6	22U IR 5 SAGE	22U IL 5 SAGE	1.9	11.7
*6.0	22U	1/2U	22U ER 6 SAGE	22U EL 6 SAGE	1.2	11.7	22U IR 6 SAGE	22U IL 6 SAGE	2.1	11.9

Order example: 22 IR 4 SAGE BMA

* Requires a special anvil AER 22U-1.5 SAGE 5/6, AEL 22U-1.5 SAGE 5/6, AIR 22U-1.5 SAGE 5/6, AIL 22U-1.5 SAGE 5/6.

For Carbide Grade and Cutting Speed see page 60-61

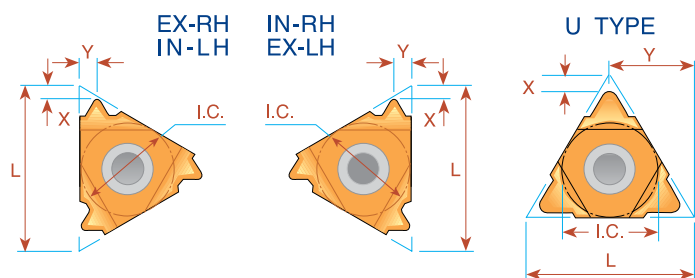
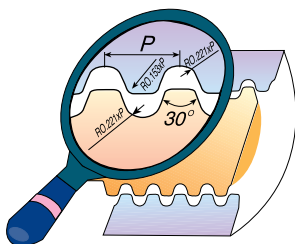
Round - DIN 405



Pitch TPI	L	I.C. in	EXTERNAL		X	Y	INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand			Ordering Code Right Hand	Ordering Code Left Hand		
10	16	3/8	16 ER 10 RD	16 EL 10 RD	1.1	1.2	16 IR 10 RD	16 IL 10 RD	1.1	1.2
8	16	3/8	16 ER 8 RD	16 EL 8 RD	1.4	1.3	16 IR 8 RD	16 IL 8 RD	1.4	1.4
6	16	3/8	16 ER 6 RD	16 EL 6 RD	1.5	1.7	16 IR 6 RD	16 IL 6 RD	1.4	1.5
6	22	1/2	22 ER 6 RD	22 EL 6 RD	1.5	1.7	22 IR 6 RD	22 IL 6 RD	1.5	1.7
4	22	1/2	22 ER 4 RD	22 EL 4 RD	2.2	2.3	22 IR 4 RD	22 IL 4 RD	2.2	2.3
4	27	5/8	27 ER 4 RD	27 EL 4 RD	2.2	2.3	27 IR 4 RD	27 IL 4 RD	2.2	2.3

Order example: 27 IL 4 RD BMA

Round - DIN 20400



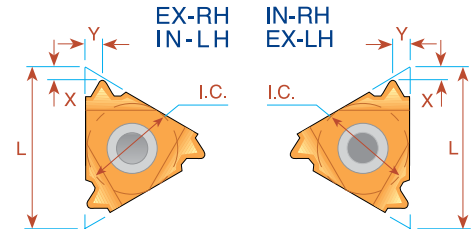
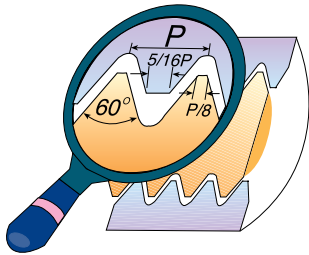
Pitch mm	L	I.C. in	EXTERNAL	INTERNAL	X	Y
			Ordering Code Right Hand	Ordering Code Right Hand		
4.0	22	1/2	22 ER 4.0 RD 20400	22 IR 4.0 RD 20400	1.4	1.4
5.0	22	1/2	22 ER 5.0 RD 20400	22 IR 5.0 RD 20400	1.7	1.8
6.0	22	1/2	22 ER 6.0 RD 20400	22 IR 6.0 RD 20400	1.7	2.0
8.0	27U	5/8U	*27U - 8.0 RD 20400		3.0	13.7
10.0	27U	5/8U	*27U - 10.0 RD 20400		3.4	13.7

Order example: 22 ER 4.0 RD 20400 MXC

* Same insert for Internal and External Right Hand Thread

For Carbide Grade and Cutting Speed see page 60-61

UNJ UNJC, UNJF, UNJEF, UNJS



Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Ordering Code		Ordering Code			
			Right Hand	Left Hand	Right Hand	Left Hand		
48	11	1/4	11 ER 48 UNJ	11 EL 48 UNJ	11 IR 48 UNJ	11 IL 48 UNJ	0.6	0.6
44	11	1/4	11 ER 44 UNJ	11 EL 44 UNJ	11 IR 44 UNJ	11 IL 44 UNJ	0.6	0.6
40	11	1/4	11 ER 40 UNJ	11 EL 40 UNJ	11 IR 40 UNJ	11 IL 40 UNJ	0.6	0.6
36	11	1/4	11 ER 36 UNJ	11 EL 36 UNJ	11 IR 36 UNJ	11 IL 36 UNJ	0.6	0.6
32	11	1/4	11 ER 32 UNJ	11 EL 32 UNJ	11 IR 32 UNJ	11 IL 32 UNJ	0.6	0.6
28	11	1/4	11 ER 28 UNJ	11 EL 28 UNJ	11 IR 28 UNJ	11 IL 28 UNJ	0.6	0.6
24	11	1/4	11 ER 24 UNJ	11 EL 24 UNJ	11 IR 24 UNJ	11 IL 24 UNJ	0.7	0.8
20	11	1/4	11 ER 20 UNJ	11 EL 20 UNJ	11 IR 20 UNJ	11 IL 20 UNJ	0.8	0.9
18	11	1/4	11 ER 18 UNJ	11 EL 18 UNJ	11 IR 18 UNJ	11 IL 18 UNJ	0.8	1.0
16	11	1/4	11 ER 16 UNJ	11 EL 16 UNJ	11 IR 16 UNJ	11 IL 16 UNJ	0.8	1.0
14	11	1/4	11 ER 14 UNJ	11 EL 14 UNJ	11 IR 14 UNJ	11 IL 14 UNJ	0.9	1.0
48	16	3/8	16 ER 48 UNJ	16 EL 48 UNJ	16 IR 48 UNJ	16 IL 48 UNJ	0.6	0.6
44	16	3/8	16 ER 44 UNJ	16 EL 44 UNJ	16 IR 44 UNJ	16 IL 44 UNJ	0.6	0.6
40	16	3/8	16 ER 40 UNJ	16 EL 40 UNJ	16 IR 40 UNJ	16 IL 40 UNJ	0.6	0.6
36	16	3/8	16 ER 36 UNJ	16 EL 36 UNJ	16 IR 36 UNJ	16 IL 36 UNJ	0.6	0.6
32	16	3/8	16 ER 32 UNJ	16 EL 32 UNJ	16 IR 32 UNJ	16 IL 32 UNJ	0.6	0.6
28	16	3/8	16 ER 28 UNJ	16 EL 28 UNJ	16 IR 28 UNJ	16 IL 28 UNJ	0.6	0.6
24	16	3/8	16 ER 24 UNJ	16 EL 24 UNJ	16 IR 24 UNJ	16 IL 24 UNJ	0.7	0.8
20	16	3/8	16 ER 20 UNJ	16 EL 20 UNJ	16 IR 20 UNJ	16 IL 20 UNJ	0.8	0.9
18	16	3/8	16 ER 18 UNJ	16 EL 18 UNJ	16 IR 18 UNJ	16 IL 18 UNJ	0.8	1.0
16	16	3/8	16 ER 16 UNJ	16 EL 16 UNJ	16 IR 16 UNJ	16 IL 16 UNJ	0.8	1.0
14	16	3/8	16 ER 14 UNJ	16 EL 14 UNJ	16 IR 14 UNJ	16 IL 14 UNJ	1.0	1.2
13	16	3/8	16 ER 13 UNJ	16 EL 13 UNJ	16 IR 13 UNJ	16 IL 13 UNJ	1.0	1.3
12	16	3/8	16 ER 12 UNJ	16 EL 12 UNJ	16 IR 12 UNJ	16 IL 12 UNJ	1.1	1.4
11	16	3/8	16 ER 11 UNJ	16 EL 11 UNJ	16 IR 11 UNJ	16 IL 11 UNJ	1.1	1.5
10	16	3/8	16 ER 10 UNJ	16 EL 10 UNJ	16 IR 10 UNJ	16 IL 10 UNJ	1.1	1.5
9	16	3/8	16 ER 9 UNJ	16 EL 9 UNJ	16 IR 9 UNJ	16 IL 9 UNJ	1.2	1.6
8	16	3/8	16 ER 8 UNJ	16 EL 8 UNJ	16 IR 8 UNJ	16 IL 8 UNJ	1.2	1.6

Order example: 16 IR 16 UNJ MXC

For Carbide Grade and Cutting Speed see page 60-61

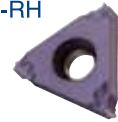
UNJ UNJC, UNJF, UNJEF, UNJS

Type B

Ground Profile with Sintered Chip-breaker

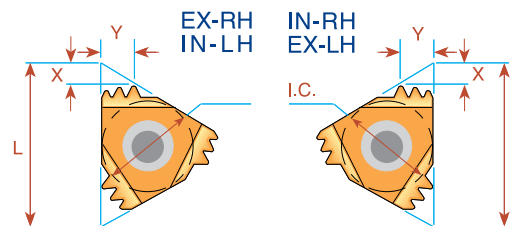
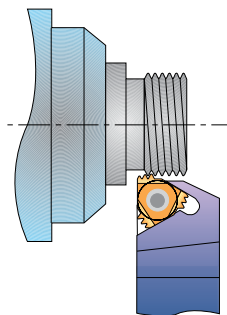
Pitch TPI	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
32	11	1/4	11 IR B 32 UNJ	0.6	0.6
28	11	1/4	11 IR B 28 UNJ	0.6	0.6
24	11	1/4	11 IR B 24 UNJ	0.6	0.6
20	11	1/4	11 IR B 20 UNJ	0.8	0.9
18	11	1/4	11 IR B 18 UNJ	0.8	0.9
16	11	1/4	11 IR B 16 UNJ	0.8	0.9
14	11	1/4	11 IR B 14 UNJ	0.8	0.9

IN-RH



Order example: 11 IR B 20 UNJ BMA

Multitooth

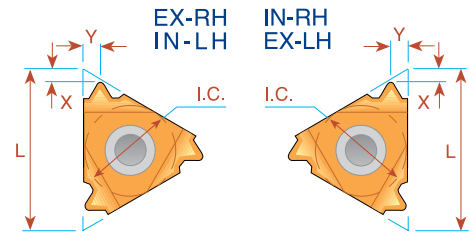
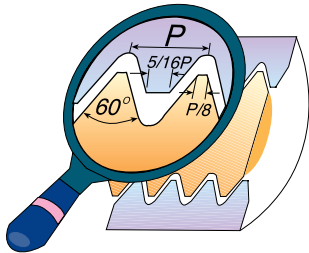


Pitch TPI	L	I.C. in	Number of Teeth	EXTERNAL Ordering Code	Anvil	INTERNAL Ordering Code	Anvil	X	Y
16	16	3/8	2	16 ER 16 UNJ 2M	AE16M	-	-	1.6	2.4
16	22	1/2	3	22 ER 16 UNJ 2M	AE22M	-	-	2.3	3.8

Order example: 22 ER 16 UNJ 2M BMA

For Carbide Grade and Cutting Speed see page 60-61

MJ - ISO 5855



Pitch mm	L	I.C. in	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y
1.0	11	1/4		11 IR 1.0 MJ	0.7	0.8
1.25	11	1/4		11 IR 1.25 MJ	0.8	0.9
1.5	11	1/4		11 IR 1.5 MJ	0.8	1.0
2.0	11	1/4		11 IR 2.0 MJ	0.9	1.0
1.0	16	3/8	16 ER 1.0 MJ	16 IR 1.0 MJ	0.7	0.8
1.25	16	3/8	16 ER 1.25 MJ	16 IR 1.25 MJ	0.8	0.9
1.5	16	3/8	16 ER 1.5 MJ	16 IR 1.5 MJ	0.8	1.0
2.0	16	3/8	16 ER 2.0 MJ	16 IR 2.0 MJ	1.0	1.3

Order example: 16 ER 1.5 MJ BMA

Type B

Ground Profile with Sintered Chip-breaker

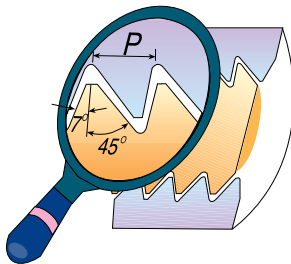
Pitch mm	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
1.0	11	1/4	11 IR B 1.0 MJ	0.6	0.6
1.5			11 IR B 1.5 MJ	0.8	0.9



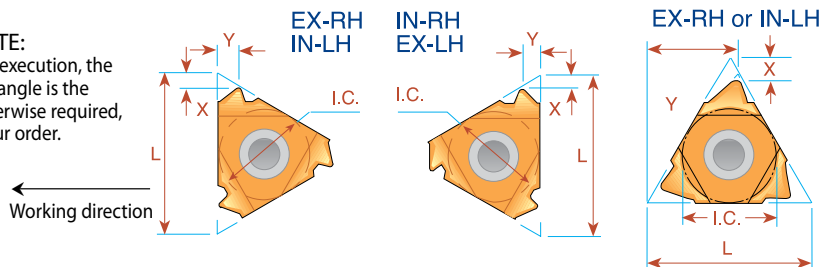
Order example: 11 IR B 1.5 MJ BMA

For Carbide Grade and Cutting Speed see page 60-61

American Buttress



IMPORTANT NOTE:
In Carmex standard execution, the flank with the large angle is the leading edge. If otherwise required, please specify in your order.

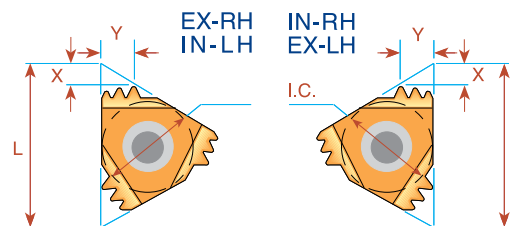
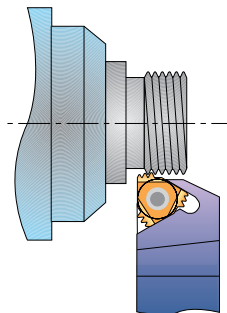


Pitch TPI	L	I.C. in	EXTERNAL		INTERNAL		X	Y
			Ordering Code Right Hand	Ordering Code Left Hand	Ordering Code Right Hand	Ordering Code Left Hand		
20	11	1/4	11 ER 20 ABUT	11 EL 20 ABUT	11 IR 20 ABUT	11 IL 20 ABUT	1.0	1.3
16	11	1/4	11 ER 16 ABUT	11 EL 16 ABUT	11 IR 16 ABUT	11 IL 16 ABUT	1.0	1.5
20	16	3/8	16 ER 20 ABUT	16 EL 20 ABUT	16 IR 20 ABUT	16 IL 20 ABUT	1.0	1.3
16	16	3/8	16 ER 16 ABUT	16 EL 16 ABUT	16 IR 16 ABUT	16 IL 16 ABUT	1.0	1.5
12	16	3/8	16 ER 12 ABUT	16 EL 12 ABUT	16 IR 12 ABUT	16 IL 12 ABUT	1.4	2.0
10	16	3/8	16 ER 10 ABUT	16 EL 10 ABUT	16 IR 10 ABUT	16 IL 10 ABUT	1.5	2.3
8	22	1/2	22 ER 8 ABUT	22 EL 8 ABUT	22 IR 8 ABUT	22 IL 8 ABUT	2.1	3.3
6	22	1/2	22 ER 6 ABUT	22 EL 6 ABUT	22 IR 6 ABUT	22 IL 6 ABUT	2.1	3.4
4	22U	1/2U	22U ER 4 ABUT	22U EL 4 ABUT	22U IR 4 ABUT	22U IL 4 ABUT	2.3	9.5
3	27U	5/8U	27U ER 3 ABUT	27U EL 3 ABUT	27U IR 3 ABUT	27U IL 3 ABUT	3.1	11.7

Order example: 16 IL 12 ABUT MXC

Most applications requires anvil change in toolholder see page 65

Multitooth

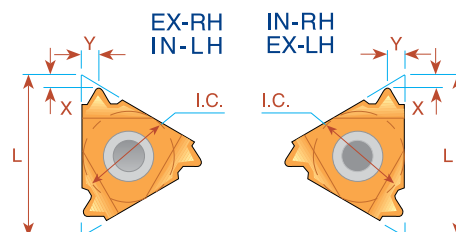
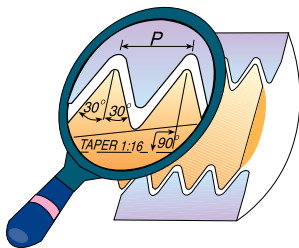


Pitch TPI	L	I.C. in	Number of Teeth	EXTERNAL	Anvil	INTERNAL	Anvil	X	Y
				Ordering Code		Ordering Code			
12	22	1/2	2	22 ER 12 ABUT 2M	AE22M	22 IR 16 ABUT 2M	AI22M	2.5	4.0

Order example: 22 IR 16 ABUT 2M BMA

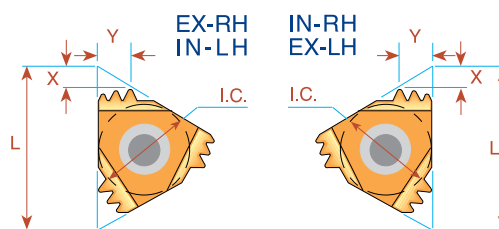
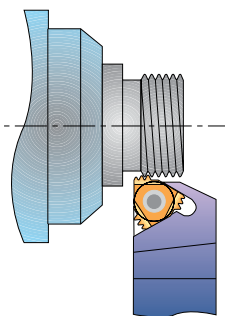
For Carbide Grade and Cutting Speed see page 60-61

OIL Threads API Round



Pitch TPI	L	I.C. in	Taper IPF	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y
10	16	3/8	0.75	16 ER 10 API RD	16 IR 10 API RD	1.5	1.4
8	16	3/8	0.75	16 ER 8 API RD	16 IR 8 API RD	1.3	1.6

Multitooth



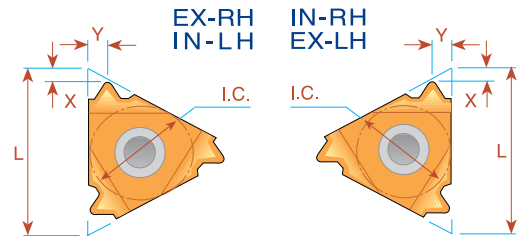
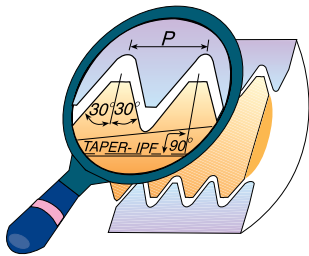
Pitch TPI	L	I.C. in	Number of Teeth	EXTERNAL Ordering Code	Anvil	INTERNAL Ordering Code	Anvil	X	Y
10	22	1/2	2	22 ER 10API RD 2M	AE22M	22 IR 10API RD 2M	AI22M	2.4	3.7
10	27	5/8	3	27 ER 10API RD 3M	AE27M	27 IR 10API RD 3M	AI27M	3.8	6.2
8	27	5/8	2	27 ER 8API RD 2M	AE27M	27 IR 8API RD 2M	AI27M	3.0	4.5

Order example: 27 IR 10 API RD 3M MXC

For recommended number of passes see page 62

For Carbide Grade and Cutting Speed see page 60-61

OIL Threads



V-0.040

Pitch TPI	L	I.C. in	Taper IPF	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y	Connection No. or Size
5	22	1/2	3	22 ER 5 API 403	22 IR 5 API 403	1.8	2.5	2 3/8-4 1/2 REG

V-0.038R

Pitch TPI	L	I.C. in	Taper IPF	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y	Connection No. or Size
4	27	5/8	2	27 ER 4 API 382	27 IR 4 API 382	2.1	2.8	NC23-NC50
4	27	5/8	3	27 ER 4 API 383	27 IR 4 API 383	2.1	2.8	NC56-NC77

V-0.050

Pitch TPI	L	I.C. in	Taper IPF	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y	Connection No. or Size
4	27	5/8	2	27 ER 4 API 502	27 IR 4 API 502	2.0	3.0	65/8 REG
4	27	5/8	3	27 ER 4 API 503	27 IR 4 API 503	2.0	3.0	5 1/2, 7 5/8, 8 5/8 REG

V-0.055

Macaroni Tubing (MT)

American Macaroni Tubing (AMT)

American Mining Macaroni Tubing (AMMT)

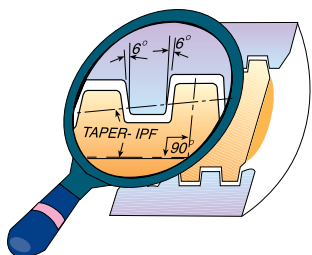
Pitch TPI	L	I.C. in	Taper IPF	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y	Connection No. or Size
6	22	1/2	1.5	22 ER 6 API 551.5	-	2.0	1.7	NC10, NC12, NC13, NC16
6	16	3/8	1.5	-	16 IR 6 API 551.5	2.0	1.7	NC10, NC12, NC13 *
6	22	1/2	1.5	-	22 IR 6 API 551.5	2.0	1.7	NC16 **

* For NC10, NC12 use holder SIR0016P16CB
For NC13 use holders SIR0020P16/SIR0020P16B/SIR0020S16CB

** For NC16 use holder SIR0025R22

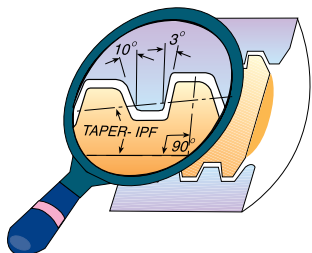
For Carbide Grade and Cutting Speed see page 60-61

OIL Threads Extreme - Line Casing



Pitch TPI	L	I.C. in	Taper IPF	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y	Connection No. or Size
6	22	1/2	1.50	22 ER 6 EL 1.5	22 IR 6 EL 1.5	1.9	1.9	5-7 5/8
5	22	1/2	1.25	22 ER 5 EL 1.25	22 IR 5 EL 1.25	2.4	2.3	8 5/8-10 3/4

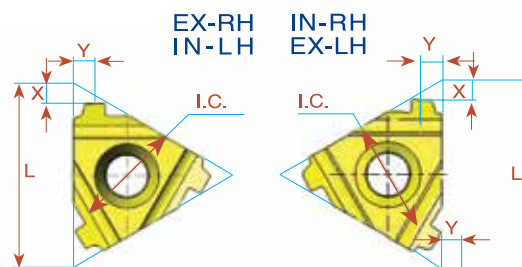
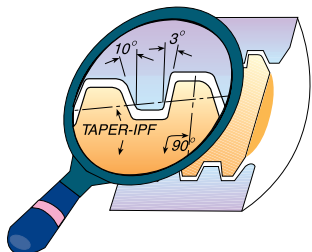
Buttress Casing



Pitch TPI	L	I.C. in	Taper IPF	EXTERNAL Ordering Code Right Hand	INTERNAL Ordering Code Right Hand	X	Y	Connection No. or Size
5	22	1/2	0.75	22 ER 5 BUT 0.75	22 IR 5 BUT 0.75	2.2	2.4	4 1/2-13 3/8
5	22	1/2	1.00	22 ER 5 BUT 1.0	22 IR 5 BUT 1.0	2.3	2.4	16-20

Order example: 22 ER 5 BUT 0.75 MXC

VAM

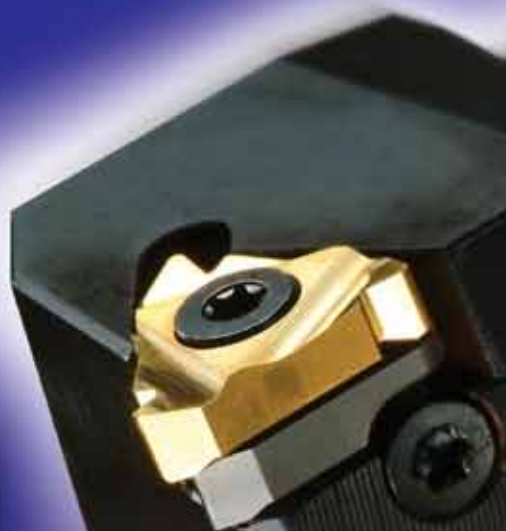


Pitch TPI	L	I.C. in	Taper IPF	EXTERNAL Ordering Code Right Hand	X	Y	INTERNAL Ordering Code Right Hand	X	Y	Connection No. or Size
8	16	3/8	0.75	16 ER 8 VAM	1.7	1.8	16 IR 8 VAM	1.7	1.8	2 3/8" - 2 7/8"
6	22	1/2	0.75	22 ER 6 VAM	2.4	2.4	22 IR 6 VAM	2.5	2.5	3 1/2" - 4 1/2"
5	22	1/2	0.75	22 ER 5 VAM	2.4	2.7	22 IR 5 VAM	2.4	2.5	5" - 13 3/8"

Order example: 16 ER 8 VAM BMA

For Carbide Grade and Cutting Speed see page 60-61

Thread Turning Toolholders and Kits



Contents:

Product Identification	38
External Toolholders	39
External Toolholders with Top Clamp	40
Vertical Toolholders	40
Slim Throat Toolholders	40
Internal Toolholders	41
Internal Toolholders with Coolant Bore	42
Internal Toolholders with Top Clamp	42
Toolholders with 3.5° Helix Angle	42
Carbide Shank Boring Bars	43
Drophead Toolholders	43
Vertical Toolholders	44

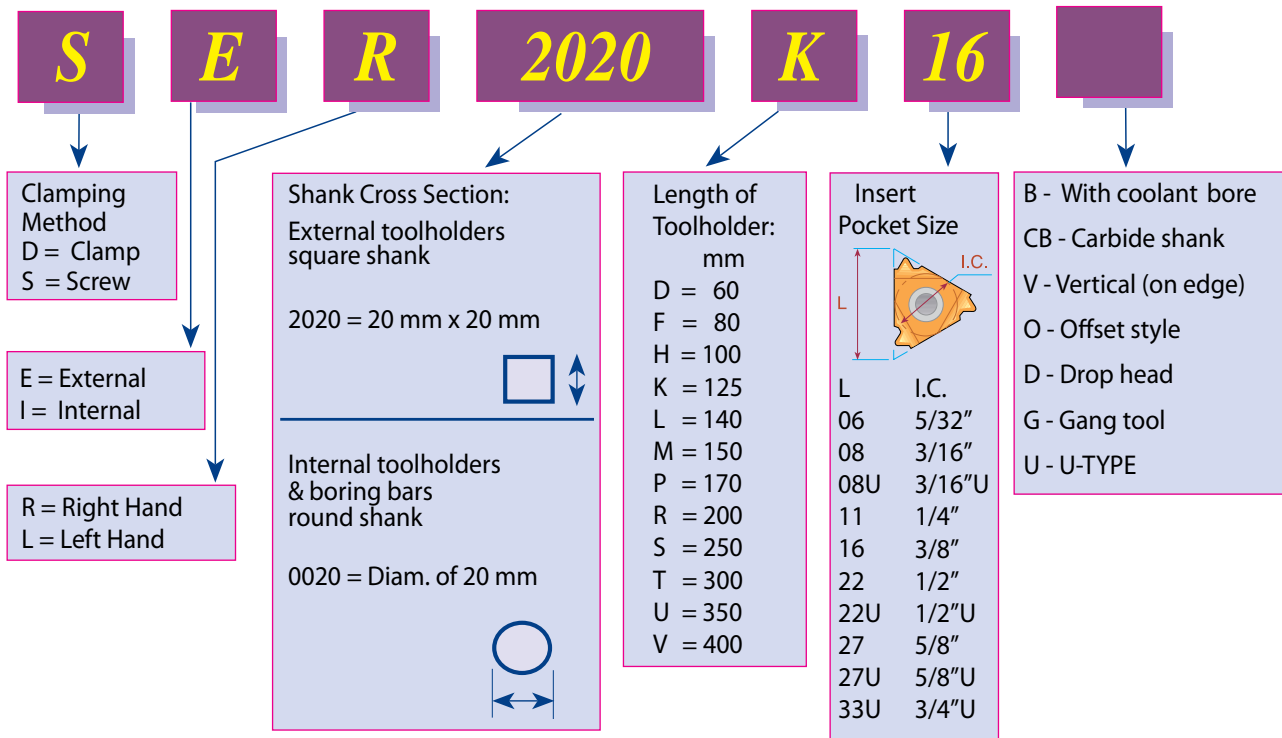
Page:

Contents:

Gang Toolholders	44
Quick Change	45-46
External Toolholders	45
Internal Toolholders	46
Special Thread Turning Application	47
Anvils and Anvil Kits	48-49
Standard Kits	50
Miniature & Ultra-miniature Kits	50
Inserts' Kits	51
Threading & Boring Combination Kit	52

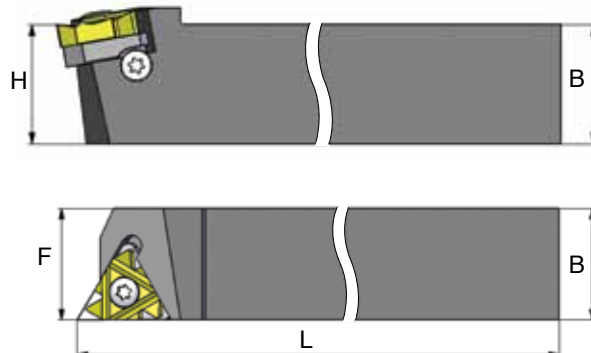
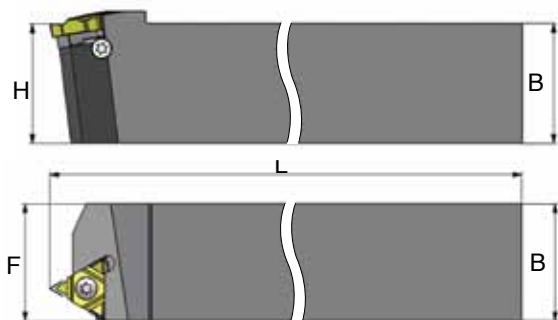
Product Identification

Threading Toolholders Ordering Codes



External Toolholders

U-TYPE



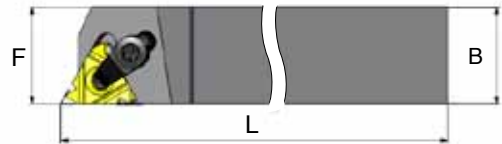
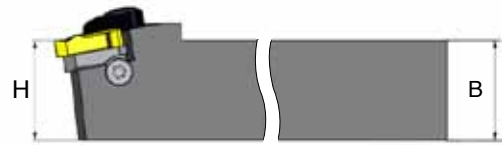
Ordering Code Right Hand	 L	B=H	L	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SER 8 8 H11	11	8	100	11	S11	-	K11	-	-
*SER 10 10 H11	11	10	100	11	S11	-	K11	-	-
*SER 10 10 M11	11	10	150	11	S11	-	K11	-	-
*SER 12 12 K11	11	12	125	12	S11	-	K11	-	-
*SER 12 12 M11	11	12	150	12	S11	-	K11	-	-
SER 12 12 F16	16	12	80	16	S16	A16	K16	AE16	AI16
SER 16 16 H16	16	16	100	16	S16	A16	K16	AE16	AI16
SER 20 20 K16	16	20	125	20	S16	A16	K16	AE16	AI16
SER 25 25 M16	16	25	150	25	S16	A16	K16	AE16	AI16
SER 32 32 P16	16	32	170	32	S16	A16	K16	AE16	AI16
SER 25 25 M22	22	25	150	25	S22	A22	K22	AE22	AI22
SER 32 32 P22	22	32	170	32	S22	A22	K22	AE22	AI22
SER 40 40 R22	22	40	200	40	S22	A22	K22	AE22	AI22
SER 25 25 M22U	22U	25	150	28	S22	A22	K22	AE22U	AI22U
SER 32 32 P22U	22U	32	170	32	S22	A22	K22	AE22U	AI22U
SER 40 40 R22U	22U	40	200	40	S22	A22	K22	AE22U	AI22U
SER 25 25 M27	27	25	150	32	S27	A27	K27	AE27	AI27
SER 32 32 P27	27	32	170	32	S27	A27	K27	AE27	AI27
SER 40 40 R27	27	40	200	40	S27	A27	K27	AE27	AI27
SER 25 25 M27U	27U	25	150	32	S27	A27	K27	AE27U	AI27U
SER 32 32 P27U	27U	32	170	32	S27	A27	K27	AE27U	AI27U
SER 40 40 R27U	27U	40	200	40	S27	A27	K27	AE27U	AI27U
*SER 25 25 M33U	33U	25	150	32	S33	-	K33	-	-
*SER 32 32 P33U	33U	32	170	32	S33	-	K33	-	-

*Toolholders with no anvil

For **LEFT HAND** toolholders specify **SEL** instead of **SER**

Toolholders are made with a **1.5° Helix Angle**. For other Helix Angles please see helix angle chart (page 65) in the technical section of this catalog.

External toolholders with top clamp



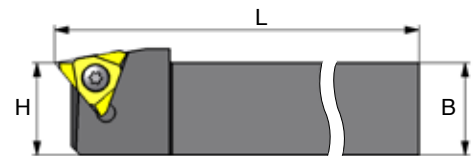
Ordering Code Right Hand	 L	B=H	L	F	Insert Screw	Clamp	Anvil Screw	Torx Key	RH Anvil	LH Anvil
DER 2020 K16	16	20	125	20	S16	C16	A16S	K16	AE16	AI16
DER 2525 M16	16	25	150	25	S16	C16	A16S	K16	AE16	AI16
*DER 2525 M22	22	25	150	25	S22	C22	A22	K22	AE22	AI22

For **LEFT HAND** toolholders specify **DEL** instead of **DER**

Toolholders are made with a **1.5° Helix Angle**. For other Helix Angles please see helix angle chart in the technical section of this catalog.

Two clamping methods can be used: screw or top clamp.

*Use K21 torx key for C22 clamp

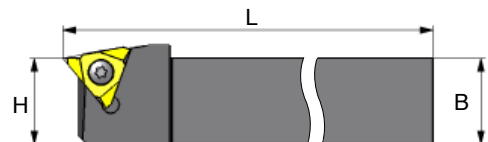


Vertical toolholders



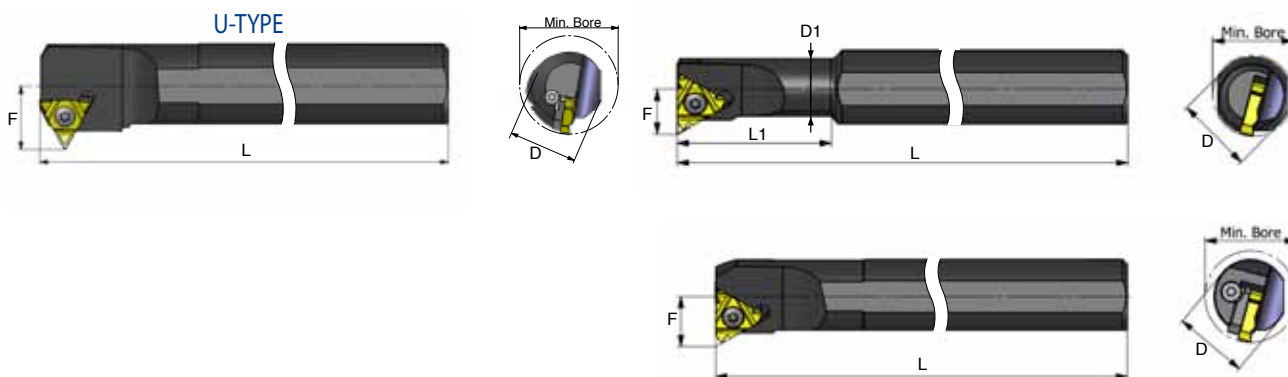
Ordering Code Right Hand	 B=H	L	F	Insert Screw	Torx Key
SER 2020 K16V	16	125	22	S16S	K16
SER 2525 M16V	16	150	27	S16S	K16
SER 2525 M22V	22	150	27.5	S22S	K22
SER 3232 P27V-T10	27	170	36	S27	K27

Slim Throat toolholders



Ordering Code Right Hand	 B=H	L	F	Insert Screw	Torx Key
SER 1616 H16VS	16	100	18	S16S	K16
SER 2020 K16VS	16	125	22	S16S	K16
SER 2525 M16VS	16	150	27	S16S	K16

Internal Toolholders



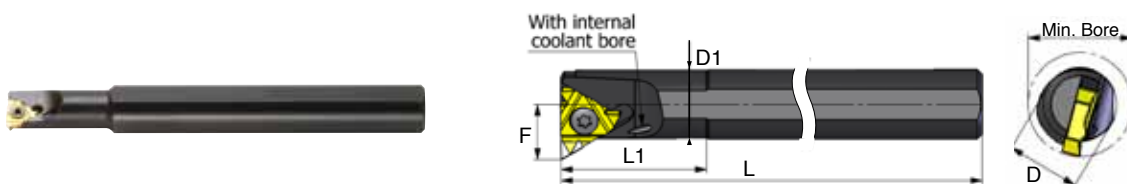
Ordering Code Right Hand	 L	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SIR 0005 H06	6	12	5.1	6.0	100	12	4.3	S06	-	K06	-	-
*SIR 0007 K08	8	16	6.6	7.8	125	18	5.3	S08	-	K08	-	-
*SIR 0008 K08U	8U	16	7.3	9.0	125	21	6.6	S08	-	K08	-	-
*SIR 0010 H11	11	10	10	12	100	-	7.4	S11	-	K11	-	-
*SIR 0010 K11	11	16	10	12	125	25	7.4	S11	-	K11	-	-
*SIR 0013 L11	11	16	13	15	140	32	8.9	S11	-	K11	-	-
*SIR 0013 M16	16	16	13	16	150	32	10.2	S16S	-	K16	-	-
*SIR 0016 P16	16	20	16	19	170	40	11.7	S16S	-	K16	-	-
SIR 0020 P16	16	20	20	24	170	-	13.7	S16	A16	K16	AI16	AE16
SIR 0025 R16	16	25	25	29	200	-	16.2	S16	A16	K16	AI16	AE16
SIR 0032 S16	16	32	32	36	250	-	19.7	S16	A16	K16	AI16	AE16
SIR 0040 T16	16	40	40	44	300	-	23.7	S16	A16	K16	AI16	AE16
*SIR 0020 P22	22	20	20	24	170	-	15.6	S22S	-	K22	-	-
SIR 0025 R22	22	25	25	29	200	-	18.1	S22	A22	K22	AI22	AE22
SIR 0032 S22	22	32	32	38	250	-	21.6	S22	A22	K22	AI22	AE22
SIR 0040 T22	22	40	40	46	300	-	25.6	S22	A22	K22	AI22	AE22
SIR 0050 U22	22	50	50	56	350	-	30.6	S22	A22	K22	AI22	AE22
SIR 0032 S22U	22U	32	32	38	250	-	24.4	S22	A22	K22	AI22U	AE22U
SIR 0040 T22U	22U	40	40	46	300	-	28.1	S22	A22	K22	AI22U	AE22U
SIR 0032 S27	27	32	32	40	250	-	22.6	S27	A27	K27	AI27	AE27
SIR 0040 T27	27	40	40	48	300	-	26.6	S27	A27	K27	AI27	AE27
SIR 0050 U27	27	50	50	58	350	-	31.6	S27	A27	K27	AI27	AE27
SIR 0060 V27	27	60	60	68	400	-	36.6	S27	A27	K27	AI27	AE27
SIR 0032 S27U	27U	32	32	40	250	-	25.8	S27	A27	K27	AI27U	AE27U
SIR 0040 T27U	27U	40	40	48	300	-	29.4	S27	A27	K27	AI27U	AE27U
SIR 0050 U27U	27U	50	50	58	350	-	34.4	S27	A27	K27	AI27U	AE27U
SIR 0060 V27U	27U	60	60	68	400	-	39.7	S27	A27	K27	AI27U	AE27U
*SIR 0050 U33U	33U	50	50	62	350	-	37.5	S33	-	K33	-	-

*Toolholders with no anvil

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

Toolholders are made with a **1.5° Helix Angle**. For other Helix Angles please see helix angle chart (page 65) in the technical section of this catalog.

Internal toolholders with coolant bore



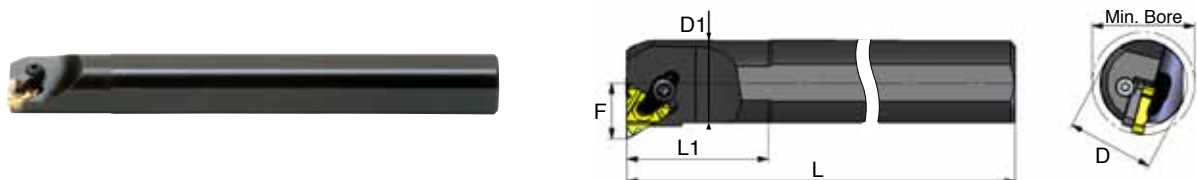
Ordering Code Right Hand	 L	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SIR 0010 K11B	11	16	10	12	125	25	7.4	S11	-	K11	-	-
*SIR 0013 M16B	16	16	13	16	150	32	10.2	S16S	-	K16	-	-
*SIR 0016 P16B	16	20	16	19	170	40	11.7	S16S	-	K16	-	-
SIR 0020 P16B	16	20	20	24	170	-	13.7	S16	A16	K16	AI16	AE16
SIR 0025 R16B	16	25	25	29	200	-	16.2	S16	A16	K16	AI16	AE16
SIR 0025 R22B	22	25	25	29	200	-	18.1	S22	A22	K22	AI22	AE22

*Toolholders without anvil

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

Toolholders are made with a **1.5° Helix Angle**. For other Helix Angles please see helix angle chart (page 65) in the technical section of this catalog.

Internal toolholders with top clamp



Ordering Code Right Hand	 L	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Clamp	Anvil Screw	Torx Key	RH Anvil	LH Anvil
DIR 0020 P16	16	20	20	24	170	-	13.7	S16	C16	A16S	K16	AI16	AE16
DIR 0025 R16	16	25	25	29	200	-	16.2	S16	C16	A16S	K16	AI16	AE16
DIR 0032 S16	16	32	32	36	250	-	19.7	S16	C16	A16S	K16	AI16	AE16
* DIR 0025 R22	22	25	25	29	200	-	18.1	S22	C22	A22	K22	AI22	AE22

For **LEFT HAND** toolholders specify **DIL** instead of **DIR**

Two clamping methods can be used: screw or top clamp.

*Use K21 torx key for C22 clamp

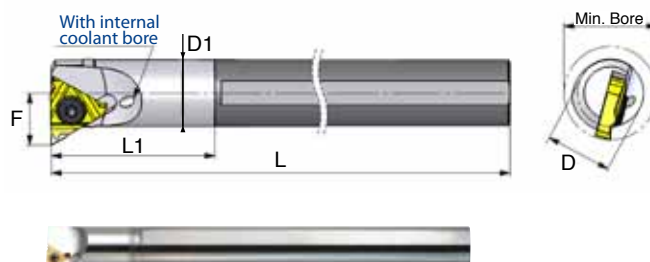
Toolholders with 3.5° Helix Angle

Ordering Code Right Hand	 L	D	D1	Min Bore Diam. mm	L	L1	F	Insert Screw	Torx Key
SIR 0016 P16B-3.5	16	20	16	19	170	40	13.7	S16S	K16
SIR 0020 P22B-3.5	22	20	20	24	170	-	15.6	S22S	K22

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

Carbide Shank Threading Bars With coolant bore

Carbide Shank Threading Bars are used when chatter and deflection are expected due to long overhang in deep small bores.

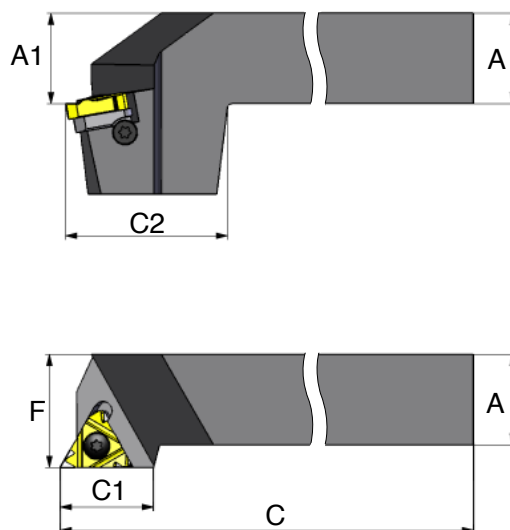


Ordering Code Right Hand	 L	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SIR 0005 H06CB	6	6	5.1	6.0	100	26	4.3	S06	-	K06	-	-
SIR 0007 K08CB	8	8	6.6	7.8	125	31	5.3	S08	-	K08	-	-
SIR 0008 K08UCB	8U	8	7.3	90	125	35	6.6	S08	-	K08	-	-
SIR 0010 M11CB	11	10	10	12	150	-	7.4	S11	-	K11	-	-
SIR 0012 P11CB	11	12	12	15	170	-	8.4	S11	-	K11	-	-
SIR 0016 R16CB	16	16	16	19	200	-	11.7	S16S	-	K16	-	-
*SIR 0020 S16CB	16	20	20	24	250	-	13.7	S16	A16	K16	AI16	AE16
*SIR 0025 S16CB	16	25	25	29	250	-	16.2	S16	A16	K16	AI16	AE16
SIR 0020 S22CB	22	20	20	24.5	250	-	15.6	S22	-	K22	-	-

*Carbide shank Threading bars with anvil

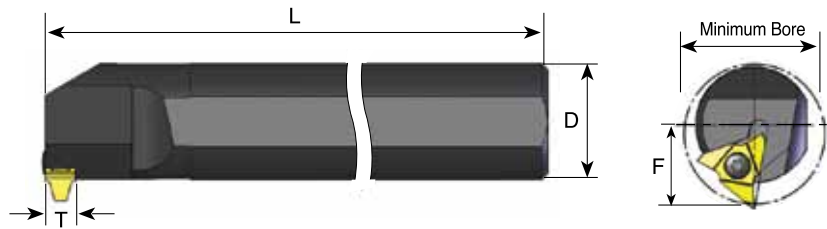
For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

Drophead Toolholders



Ordering Code Right Hand	 L	A	A1	C	C1	F	C2	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SER 2020 K16D	16	20	20	125	21.0	25	38	S16	A16	K16	AE16	AI16
SER 2525 M16D	16	25	25	150	21.0	32	38	S16	A16	K16	AE16	AI16
SER 2525 M22D	22	25	25	150	21.0	32	38	S22	A22	K22	AE22	AI22

Vertical Toolholders



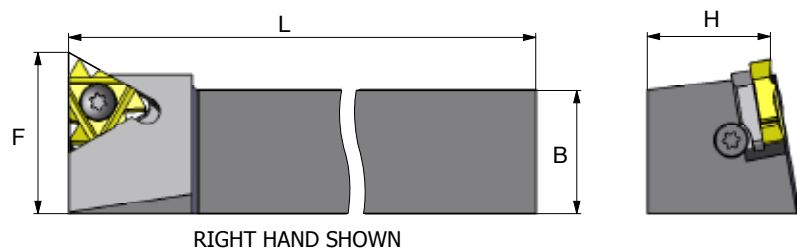
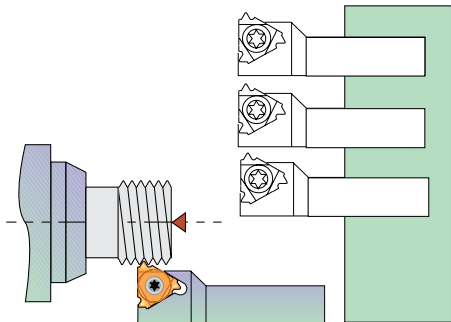
Ordering Code Right Hand	 L	D	* Min Bore Diam.	L	F	Insert Screw	Torx Key
SIR 0040T27V-T10	27	40	48	300	29	S27	K27
SIR 0050U27V-T10	27	50	58	350	34	S27	K27

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

* To be compare with given minimum bore profile.

Gang Toolholders

Gang Toolholders are External Holders, used in small automatic machines with a gang tool post.



Ordering Code Right Hand	 L	B=H	L	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SER 8 8 H11G	11	8	100	12.0	S11	-	K11	-	-
*SER 10 10 H11G	11	10	100	14.0	S11	-	K11	-	-
SER 16 16 K16G	16	16	125	21.7	S16	A16	K16	AE16	AI16
SER 20 20 K16G	16	20	125	26.2	S16	A16	K16	AE16	AI16

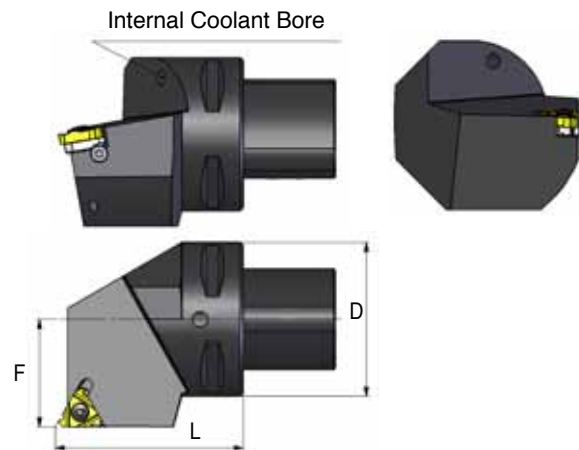
*Toolholders with no anvil

For **LEFT HAND** toolholders specify **SEL** instead of **SER**

Quick Change Polygon Threading Toolholders

- Polygon shank
- ISO standard (26623) compliant for toolholding systems
- Polygon taper ensures automatic radial centering and even pressure around the coupling
- Enable quick tool changes ISO standard coupling system with a 1.4 degree tapered polygon shank design
- Interchangeable with leading manufacturers

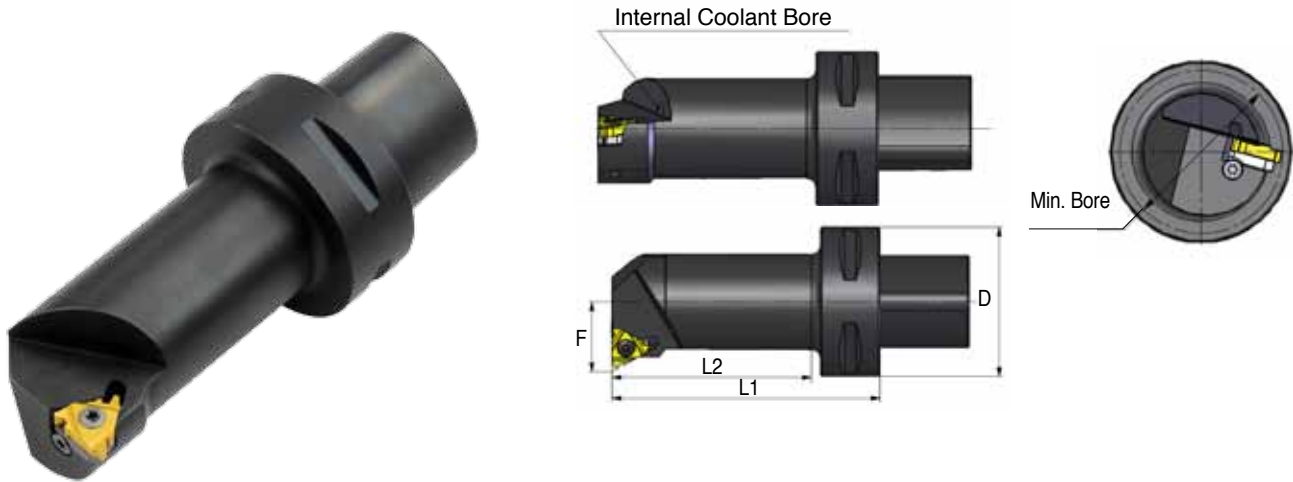
External Toolholders



Equivalent to...	Ordering Code		D	F	L	Insert Screw	Anvil Screw	Torx key	RH Anvil	LH Anvil
C4	P40-SER 27050-16	16	40	27	50	S16	A16	K16	AE16	AI16
C5	P50-SER 35060-16	16	50	35	60	S16	A16	K16	AE16	AI16
C6	P63-SER 45065-16	16	63	45	65	S16	A16	K16	AE16	AI16
C4	P40-SER 27050-22	22	40	27	50	S22	A22	K22	AE22	AI22
C5	P50-SER 35060-22	22	50	35	60	S22	A22	K22	AE22	AI22
C6	P63-SER 45065-22	22	63	45	65	S22	A22	K22	AE22	AI22
C8	P80-SER 55080-22	22	80	55	80	S22	A22	K22	AE22	AI22

For **LEFT HAND** toolholders specify **SEL** instead of **SER**

Internal Toolholders

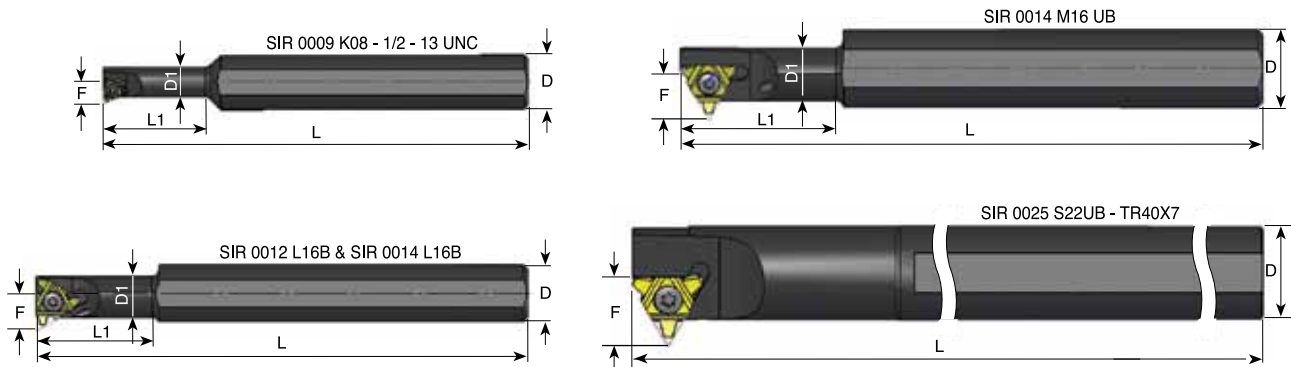


Equivalent to...	Ordering Code		D	F	Min. Bore Dia.	L1	L2	Insert Screw	Anvil Screw	Torx key	RH Anvil	LH Anvil
C4	* P40-SIR 12060-16	16	40	11.7	20	60	37	S16	-	K16	-	-
	P40-SIR 14060-16	16	40	13.5	25	60	38	S16	A16	K16	AI16	AE16
	P40-SIR 17070-16	16	40	16.0	29	70	48	S16	A16	K16	AI16	AE16
	P40-SIR 22090-16	16	40	19.5	36	90	69	S16	A16	K16	AI16	AE16
	P40-SIR 27080-16	16	40	23.5	44	80	60	S16	A16	K16	AI16	AE16
C5	* P50-SIR 12060-16	16	50	11.7	20	60	35	S16	-	K16	-	-
	P50-SIR 14060-16	16	50	13.5	25	60	36	S16	A16	K16	AI16	AE16
	P50-SIR 17070-16	16	50	16.0	29	70	47	S16	A16	K16	AI16	AE16
	P50-SIR 22090-16	16	50	19.5	36	90	68	S16	A16	K16	AI16	AE16
	P50-SIR 27105-16	16	50	23.5	44	105	84	S16	A16	K16	AI16	AE16
C6	P63-SIR 14070-16	16	63	13.5	25	70	42	S16	A16	K16	AI16	AE16
	P63-SIR 17075-16	16	63	16.0	29	75	48	S16	A16	K16	AI16	AE16
	P63-SIR 22090-16	16	63	19.5	36	90	64	S16	A16	K16	AI16	AE16
	P63-SIR 27105-16	16	63	23.5	44	105	80	S16	A16	K16	AI16	AE16
C4	* P40-SIR 15065-22	22	40	15.4	25	65	42	S22	-	K22	-	-
	P40-SIR 19070-22	22	40	17.9	29	70	48	S22	A22	K22	AI22	AE22
	P40-SIR 22090-22	22	40	21.4	38	90	69	S22	A22	K22	AI22	AE22
	P40-SIR 27080-22	22	40	25.4	46	80	60	S22	A22	K22	AI22	AE22
C5	* P50-SIR 15065-22	22	50	15.4	25	65	41	S22	-	K22	-	-
	P50-SIR 19070-22	22	50	17.9	29	70	47	S22	A22	K22	AI22	AE22
	P50-SIR 22090-22	22	50	21.4	38	90	68	S22	A22	K22	AI22	AE22
	P50-SIR 27105-22	22	50	25.4	46	105	84	S22	A22	K22	AI22	AE22
C6	P63-SIR 19075-22	22	63	17.9	29	75	48	S22	A22	K22	AI22	AE22
	P63-SIR 22090-22	22	63	21.4	38	90	64	S22	A22	K22	AI22	AE22
	P63-SIR 27105-22	22	63	25.4	46	105	80	S22	A22	K22	AI22	AE22

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

* Holders without anvil

Special Thread Turning Applications



Ordering Code Right Hand		D	D1	L	L1	F	Thread	Insert Screw	Torx Key
*SIR 0009 K08	8	16	8.7	125	30	6.5	1/2 - 13UNC	S08	K08
SIR 0012 L16B	16	20	11.5	140	33	10.5	TR18x4	S16S	K16
SIR 0014 L16B	16	20	12.5	140	36	21.1	TR20x4	S16S	K16
SIR 0014 M16UB	16	20	13.5	150	40	13.2	TR22x5	S16S	K16
SIR 0025 S22UB	22	25	-	250	-	19.5	TR40x7	S22S	K22

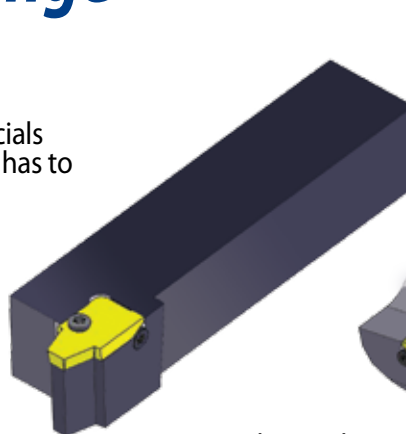
For LH holders call Carmex

* Only right hand available

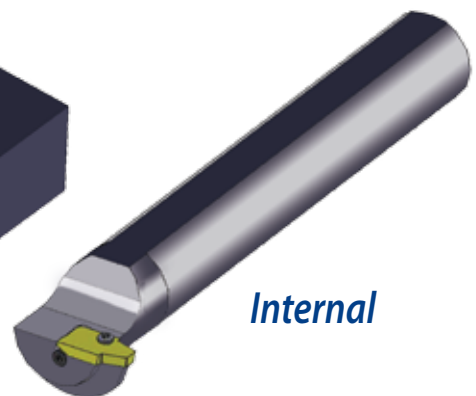
Large Profile Range

- Pitch Range: 14mm up to 24 mm.
- Tools and inserts are offered as specials (non catalog), because each holder has to be modified to fit the profile shape.
- Rigid Clamping

External



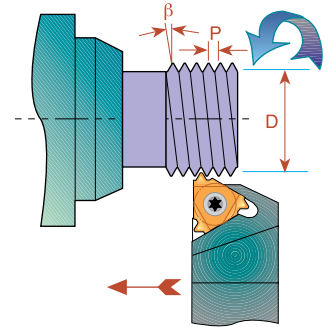
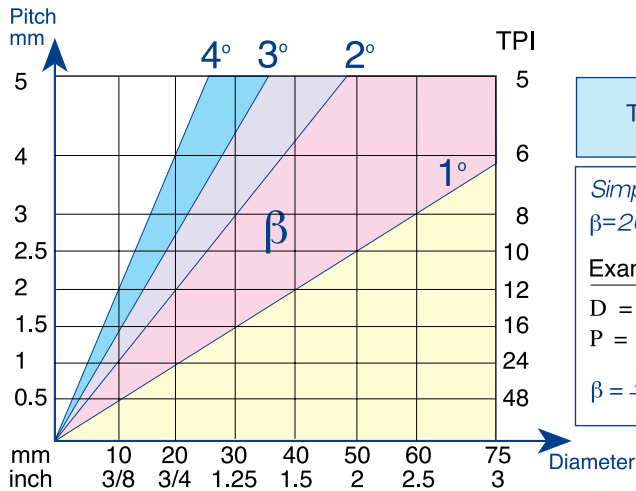
Internal



- Tailor made profiles according to customer's request

Available Profile	Round (DIN 20400)	Trapez (DIN 103)	Acme, Stub Acme	American Buttress
Pitch	16 mm	14-24 mm	1.0 - 1.5 TPI	1.5 - 2.0 TPI

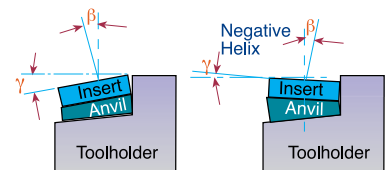
Thread Helix Angle



Standard and Slanted Anvils

CARMEX Toolholder Pockets have a built in 1.5° helix angle. This angle may be adjusted to better match the thread helix angle by simply changing the anvil.

Negative helix is usually used when threading RH thread with LH Holder or LH thread with RH Holder.



L	IC	Pocket Angle γ	4.5°	3.5°	2.5°	1.5° Standard	0.5°	-0.5°	-1.5°
16	3/8	EX-RH OR IN-LH	AE16+4.5	AE16+3.5	AE16+2.5	AE16	AE16+0.5	AE16-0.5	AE16-1.5
16	3/8	EX-LH OR IN-RH	AI 16+4.5	AI 16+3.5	AI 16+2.5	AI 16	AI 16+0.5	AI 16-0.5	AI 16-1.5
22	1/2	EX-RH OR IN-LH	AE22+4.5	AE22+3.5	AE22+2.5	AE22	AE22+0.5	AE22-0.5	AE22-1.5
22	1/2	EX-LH OR IN-RH	AI 22+4.5	AI 22+3.5	AI 22+2.5	AI 22	AI 22+0.5	AI 22-0.5	AI 22-1.5
22U	1/2U	EX-RH OR IN-LH	AE22U+4.5	AE22U+3.5	AE22U+2.5	AE22U	AE22U+0.5	AE22U-0.5	AE22U-1.5
22U	1/2U	EX-LH OR IN-RH	AI 22U+4.5	AI 22U+3.5	AI 22U+2.5	AI 22U	AI 22U+0.5	AI 22U-0.5	AI 22U-1.5
27	5/8	EX-RH OR IN-LH	AE27+4.5	AE27+3.5	AE27+2.5	AE27	AE27+0.5	AE27-0.5	AE27-1.5
27	5/8	EX-LH OR IN-RH	AI 27+4.5	AI 27+3.5	AI 27+2.5	AI 27	AI 27+0.5	AI 27-0.5	AI 27-1.5
27U	5/8U	EX-RH OR IN-LH	AE27U+4.5	AE27U+3.5	AE27U+2.5	AE27U	AE27U+0.5	AE27U-0.5	AE27U-1.5
27U	5/8U	EX-LH OR IN-RH	AI 27U+4.5	AI 27U+3.5	AI 27U+2.5	AI 27U	AI 27U+0.5	AI 27U-0.5	AI 27U-1.5

Anvil Kits

5 AE and 5 AI anvils with various helix angles



AE (FOR EX.RH. & IN.LH.)



AI (FOR IN.RH. & EX.LH.)



Ordering Code	Contents				
KA16	AE16+4.5 AI 16+4.5	AE16+3.5 AI 16+3.5	AE16+2.5 AI 16+2.5	AE16+0.5 AI 16+0.5	AE16-1.5 AI 16-1.5
KA22	AE22+4.5 AI 22+4.5	AE22+3.5 AI 22+3.5	AE22+2.5 AI 22+2.5	AE22+0.5 AI 22+0.5	AE22-1.5 AI 22-1.5
KA22U	AE22U+4.5 AI 22U+4.5	AE22U+3.5 AI 22U+3.5	AE22U+2.5 AI 22U+2.5	AE22U+0.5 AI 22U+0.5	AE22U-1.5 AI 22U-1.5
KA27	AE27+4.5 AI 27+4.5		AE27+2.5 AI 27+2.5		AE27-1.5 AI 27-1.5
KA27U	AE27U+4.5 AI 27U+4.5		AE27U+2.5 AI 27U+2.5		AE27U-1.5 AI 27U-1.5

Standard Kits

Threading Kits are a versatile solution for users that cut a variety of thread types in limited quantity and do not want to sacrifice thread quality.

External ISO Kit Ordering Code:KEG

INSERTS

16 ER A60 P25C
16 ER G60 P25C
16 ER 0.75 ISO P25C
16 ER 1.0 ISO P25C
16 ER 1.25 ISO P25C
16 ER 1.5 ISO P25C
16 ER 1.75 ISO P25C
16 ER 2.0 ISO P25C
16 ER 2.5 ISO P25C
16 ER 3.0 ISO P25C

TOOLHOLDERS

SER 2020 K16
KEY
K16
SCREW
S16

Internal ISO Kit Ordering Code:KIG

INSERTS

16 IR A60 P25C
16 IR G60 P25C
16 IR 0.75 ISO P25C
16 IR 1.0 ISO P25C
16 IR 1.25 ISO P25C
16 IR 1.5 ISO P25C
16 IR 1.75 ISO P25C
16 IR 2.0 ISO P25C
16 IR 2.5 ISO P25C
16 IR 3.0 ISO P25C

TOOLHOLDERS

SIR 0020 K16
KEY
K16
SCREW
S16



If a larger toolholders with a 25 mm shank is required, add to the kit 25. For example: KIG - 25

Miniature & Ultra-Miniature Kits

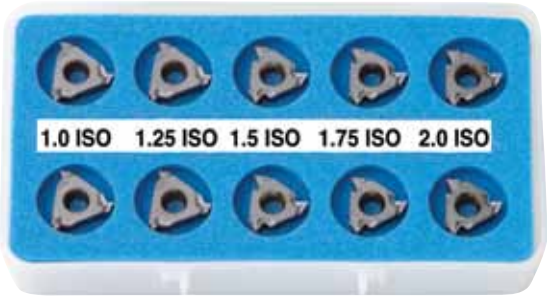


Ordering Code	Type	No. of Inserts	Inserts	Contents Boring Bar	Key
KU60M - BXC	ULTRA	10	06 IR A60 BXC	SIR 0005 H06	K6
KM60M - BXC	MINI	10	08 IR A60 BXC	SIR 0007 K08	K8

Inserts' Kits

Type B Kits

Type B threading inserts.
A combination of ground profile and
sintered chip-breaker threading inserts.
BMA Grade: Sub-Micron carbide grade
with TiAlN multi-layer Coating.



EXTERNAL ISO KIT KEMB - BMA

16 ER B 1.0 ISO BMA-2 Pcs
16 ER B 1.25 ISO BMA-2 Pcs
16 ER B 1.5 ISO BMA-2 Pcs
16 ER B 1.75 ISO BMA-2 Pcs
16 ER B 2.0 ISO BMA-2 Pcs



EX-RH

INTERNAL ISO KIT KIMB - BMA

16 IR B 1.0 ISO BMA-2 Pcs
16 IR B 1.25 ISO BMA-2 Pcs
16 IR B 1.5 ISO BMA-2 Pcs
16 IR B 1.75 ISO BMA-2 Pcs
16 IR B 2.0 ISO BMA-2 Pcs



IN-RH

Standard Inserts' Kits

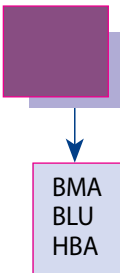
EXTERNAL ISO KIT

16 ER 1.0 ISO-2 Pcs
16 ER 1.25 ISO-2 Pcs
16 ER 1.5 ISO-2 Pcs
16 ER 1.75 ISO-2 Pcs
16 ER 2.0 ISO-2 Pcs

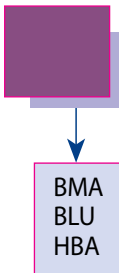
INTERNAL ISO KIT

16 IR 1.0 ISO-2 Pcs
16 IR 1.25 ISO-2 Pcs
16 IR 1.5 ISO-2 Pcs
16 IR 1.75 ISO-2 Pcs
16 IR 2.0 ISO-2 Pcs

Ordering Code: KEM



Ordering Code: KIM



Threading & Boring Combination Kit

A practical and convenient combination kit for **Ultra Miniature** Threading and Boring. It enables Boring and Threading of mini bores as small as **6 mm diameter (1/4")** with just one deep reaching CARBIDE shank ultra mini Boring Bar.



Ordering Code	Contents			
	Threading Insert	Turning Inserts	Boring Bar	Key
KC6TM	06 IR A60 BXC 10Pcs	06 IR TURN BMA 10Pcs	SIR 0005 H06CB	K6

BMA - Coated carbide grade for medium to high cutting speeds

BXC - Coated carbide grade for low cutting speed - 40 to 90 m/min

CB - Carbide shank boring bar with coolant bore

Double Sided Thread Turning Inserts



A unique line of 2 sided inserts including 6 cutting edges, a cost saving tool.

Advantages of DSI-Thread Turning Inserts

- Increased productivity thanks to the six cutting edges.
- U-Style inserts for a wide range of full or partial profile standard threads.
- Same insert for right hand or left hand thread.
- Saving on tooling costs.
- Unique anti-vibration anvil designed for clamping the insert and supporting the cutting edge.
- Simple insert's mounting and cutting edge indexing.
- Heavy duty toolholders designed specially for this line.

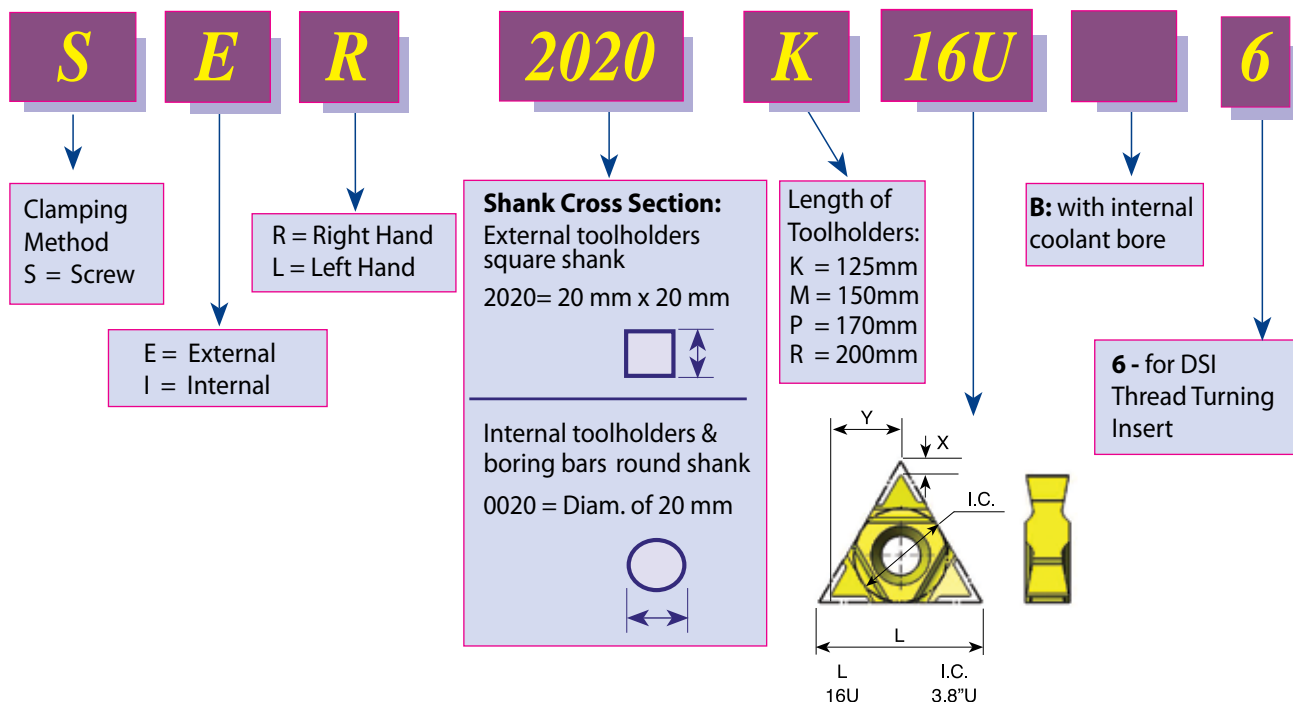
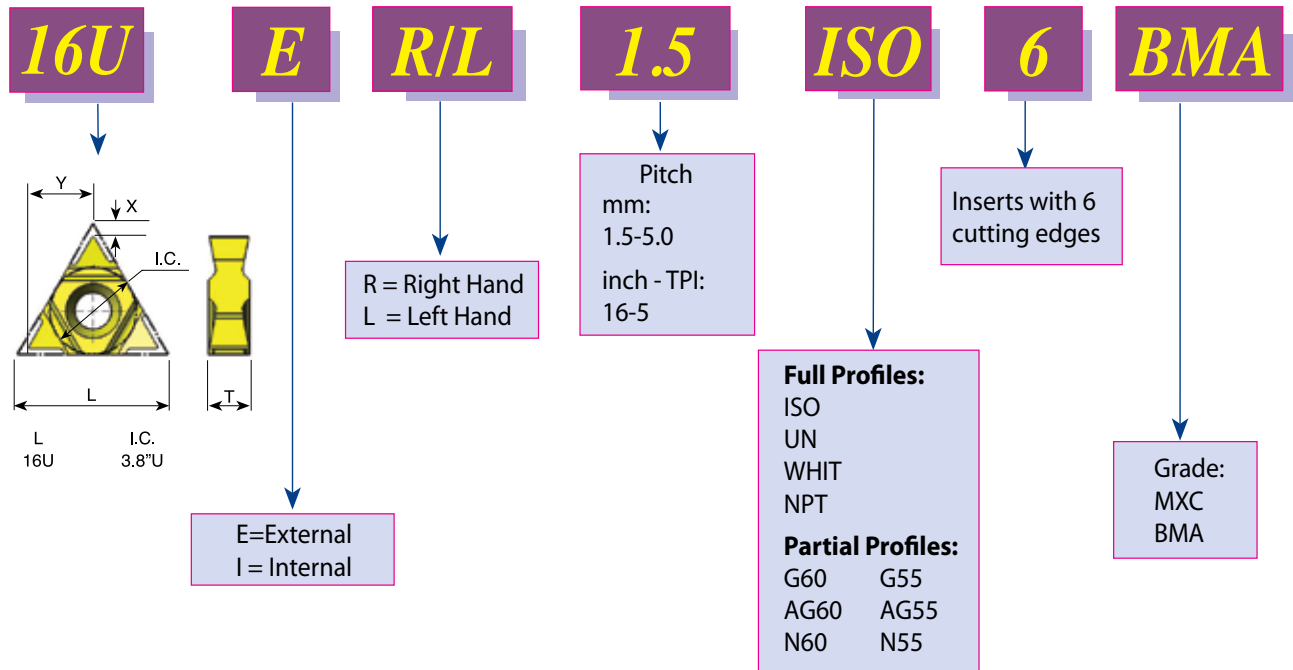
Contents:

Page:

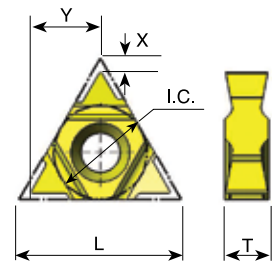
Product Identification	54
Partial Profile 60°	55
Partial Profile 55°	55
ISO	56
UN	56
Whitworth 55°	57
NPT	57
Thread Turning Toolholder - External	58
Thread Turning Toolholder - Internal	58

Product Identification

DSI Ordering Code



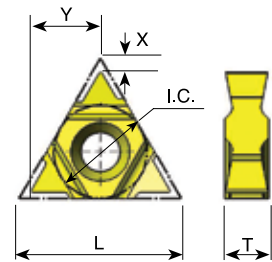
Partial Profile 60°



Pitch Range mm	Pitch Range TPI	L	I.C. in	EXTERNAL Ordering Code	INTERNAL Ordering Code	X	Y	T
1.75 - 3.0	14-8	16U	3/8U	16U ER/L G60-6	16U IR/L G60-6	1.4	7.1	4.5
0.5 - 3.0	48-8	16U	3/8U	16U ER/L AG60-6	16U IR/L AG60-6	1.4	7.1	4.5
3.5 - 5.0	7-5	16U	3/8U	16U ER/L N60-6	16U IR/L N60-6	1.2	7.3	4.5

Available grades: BMA or MXC

Partial Profile 55°

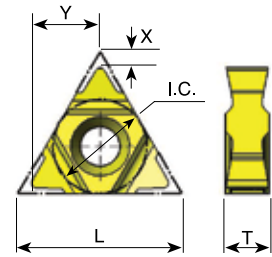


Pitch Range mm	Pitch Range TPI	L	I.C. in	EXTERNAL Ordering Code	INTERNAL Ordering Code	X	Y	T
1.75 - 3.0	14-8	16U	3/8U	16U ER/L G55-6	16U IR/L G55-6	1.4	7.1	4.5
0.5 - 3.0	48-8	16U	3/8U	16U ER/L AG55-6	16U IR/L AG55-6	1.4	7.1	4.5
3.5 - 5.0	7-5	16U	3/8U	16U ER/L N55-6	16U IR/L N55-6	1.2	7.3	4.5

Available grades: BMA or MXC

For Carbide Grade and Cutting Speed see page 60-61

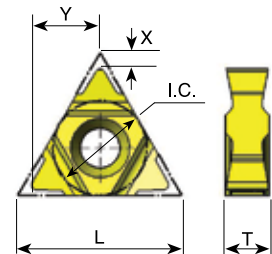
ISO



Pitch mm	L	I.C. in	EXTERNAL Ordering Code	INTERNAL Ordering Code	X	Y	T
1.5	16U	3/8U	16U ER/L 1.5 ISO-6	16U IR/L 1.5 ISO-6	1.6	6.9	4.5
1.75	16U	3/8U	16U ER/L 1.75 ISO-6	16U IR/L 1.75 ISO-6	1.6	6.9	4.5
2.0	16U	3/8U	16U ER/L 2.0 ISO-6	16U IR/L 2.0 ISO-6	1.6	6.9	4.5
2.5	16U	3/8U	16U ER/L 2.5 ISO-6	16U IR/L 2.5 ISO-6	1.6	6.9	4.5
3.0	16U	3/8U	16U ER/L 3.0 ISO-6	16U IR/L 3.0 ISO-6	1.6	6.9	4.5
3.5	16U	3/8U	16U ER/L 3.5 ISO-6	16U IR/L 3.5 ISO-6	1.6	6.9	4.5
4.0	16U	3/8U	16U ER/L 4.0 ISO-6	16U IR/L 4.0 ISO-6	1.6	6.9	4.5
4.5	16U	3/8U	16U ER/L 4.5 ISO-6	16U IR/L 4.5 ISO-6	1.6	6.9	4.5
5.0	16U	3/8U	16U ER/L 5.0 ISO-6	16U IR/L 5.0 ISO-6	1.6	6.9	4.5

Available grades: BMA or MXC

UN - Unified **UNC, UNF, UNEF, UNS**

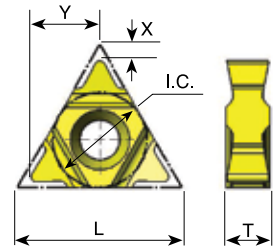


Pitch TPI	L	I.C. in	EXTERNAL Ordering Code	INTERNAL Ordering Code	X	Y	T
16	16U	3/8U	16U ER/L 16 UN-6	16U IR/L 16 UN-6	1.6	6.9	4.5
14	16U	3/8U	16U ER/L 14 UN-6	16U IR/L 14 UN-6	1.6	6.9	4.5
13	16U	3/8U	16U ER/L 13 UN-6	16U IR/L 13 UN-6	1.6	6.9	4.5
12	16U	3/8U	16U ER/L 12 UN-6	16U IR/L 12 UN-6	1.6	6.9	4.5
11.5	16U	3/8U	16U ER/L 11.5 UN-6	16U IR/L 11.5 UN-6	1.6	6.9	4.5
11	16U	3/8U	16U ER/L 11 UN-6	16U IR/L 11 UN-6	1.6	6.9	4.5
10	16U	3/8U	16U ER/L 10 UN-6	16U IR/L 10 UN-6	1.6	6.9	4.5
9	16U	3/8U	16U ER/L 9 UN-6	16U IR/L 9 UN-6	1.6	6.9	4.5
8	16U	3/8U	16U ER/L 8 UN-6	16U IR/L 8 UN-6	1.6	6.9	4.5
7	16U	3/8U	16U ER/L 7 UN-6	16U IR/L 7 UN-6	1.6	6.9	4.5
6	16U	3/8U	16U ER/L 6 UN-6	16U IR/L 6 UN-6	1.6	6.9	4.5
5	16U	3/8U	16U ER/L 5 UN-6	16U IR/L 5 UN-6	1.6	6.9	4.5

Available grades: BMA or MXC

For Carbide Grade and Cutting Speed see page 60-61

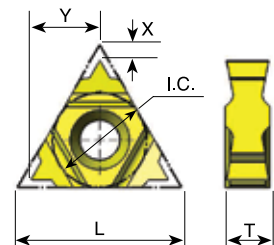
Whitworth 55° BSW, BSF, BSP, BSB



Pitch TPI	L	I.C. in	EXTERNAL Ordering Code	INTERNAL Ordering Code	X	Y	T
16	16U	3/8U	16U ER/L 16 W-6	16U IR/L 16 W-6	1.6	6.9	4.5
14	16U	3/8U	16U ER/L 14 W-6	16U IR/L 14 W-6	1.6	6.9	4.5
12	16U	3/8U	16U ER/L 12 W-6	16U IR/L 12 W-6	1.6	6.9	4.5
11	16U	3/8U	16U ER/L 11 W-6	16U IR/L 11 W-6	1.6	6.9	4.5
10	16U	3/8U	16U ER/L 10 W-6	16U IR/L 10 W-6	1.6	6.9	4.5
9	16U	3/8U	16U ER/L 9 W-6	16U IR/L 9 W-6	1.6	6.9	4.5
8	16U	3/8U	16U ER/L 8 W-6	16U IR/L 8 W-6	1.6	6.9	4.5
7	16U	3/8U	16U ER/L 7 W-6	16U IR/L 7 W-6	1.6	6.9	4.5
6	16U	3/8U	16U ER/L 6 W-6	16U IR/L 6 W-6	1.6	6.9	4.5
5	16U	3/8U	16U ER/L 5 W-6	16U IR/L 5 W-6	1.4	7.2	4.5

Available grades: BMA or MXC

NPT



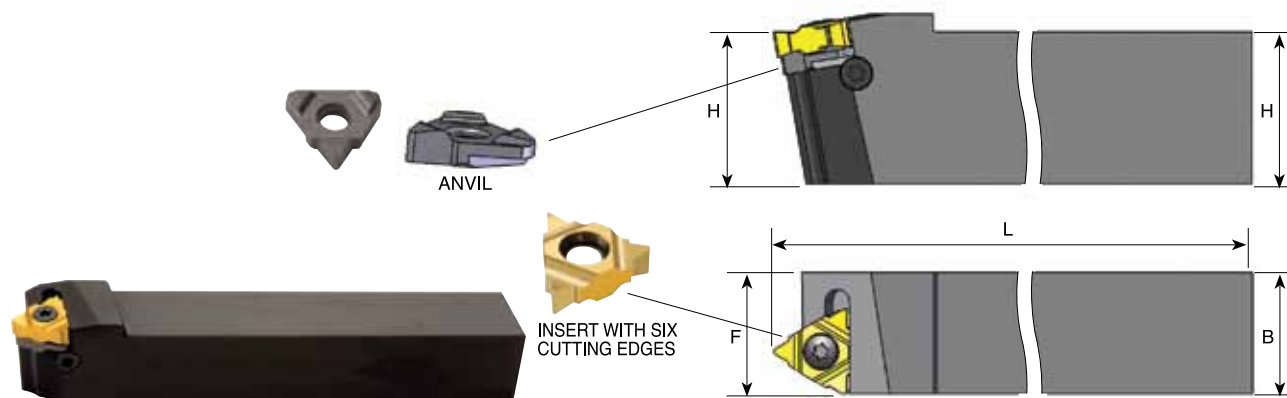
Pitch TPI	L	I.C. in	EXTERNAL Ordering Code	INTERNAL Ordering Code	X	Y	T
14	16U	3/8U	16U ER/L 14 NPT-6	16U IR/L 14 NPT-6	1.6	6.9	4.5
11.5	16U	3/8U	16U ER/L 11.5 NPT-6	16U IR/L 11.5 NPT-6	1.6	6.9	4.5
8	16U	3/8U	16U ER/L 8 NPT-6	16U IR/L 8 NPT-6	1.6	6.9	4.5

Available grades: BMA or MXC

For Carbide Grade and Cutting Speed see page 60-61

Heavy Duty Thread Turning Toolholders

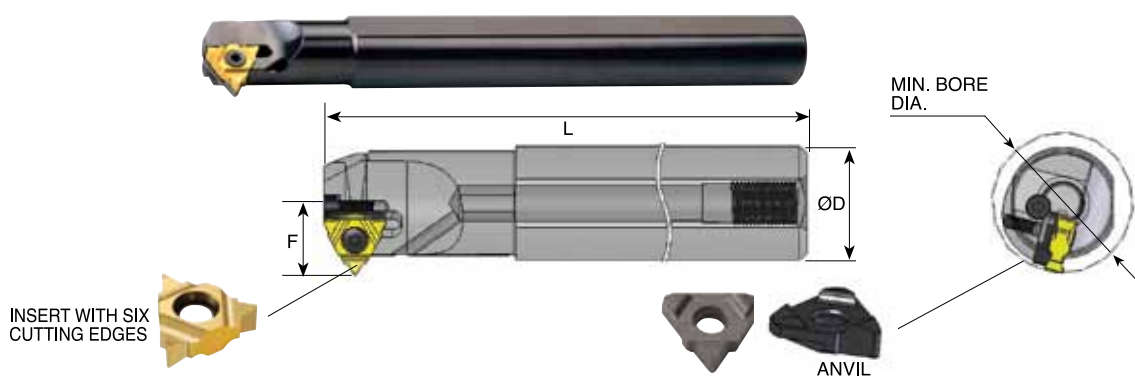
External



Ordering Code Right Hand	H	B	L	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SER 2020 K16U-6	20	20	125	20	S16	A16	K16	AER 16U-6	AEL 16U-6
SER 2520 M16U-6	25	20	150	20	S16	A16	K16	AER 16U-6	AEL 16U-6

For **LEFT HAND** toolholders specify **SEL** instead of **SER**

Internal with coolant bore



Ordering Code Right Hand	ØD	Min. bore dia.	L	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SIR 0020 P16UB-6	20	24	170	14.9	S16	A16	K16	AIR 16U-6	AIL 16U-6
SIR 0025 R16UB-6	25	29	200	17.4	S16	A16	K16	AIR 16U-6	AIL 16U-6

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

Thread Turning Technical Section



Contents:	Page:	Contents:	Page:
Carbide Grade Selection	60	Anvil Change Recommendation	65
Type B inserts	60	Thread Turning Step by Step	66-67
Recommended Cutting Speed	61	Troubleshooting	67
Conversion of Cutting Speed to Rotational Speed	62	Threading Inserts Standards	68
Number of Threading Passes Selection	62		
Number of Threading Passes Selection for Single Point Inserts	63		
Thread Turning Methods	63		
Important Points about Carmex Threading Inserts	64		
Flank Clearance Angle	64		

Carbide Grade Selection

Choose the Carmex grade specifically formulated for your application from the following list:

Coated Grades

HBA (H10-H25) (S10-S25)	Extra-fine sub-micron grade with high toughness, for optimized performance on hardened steels and cast iron up to 62HRC, titanium alloys and super alloys (hastelloy, inconel and nickel based alloys).
BLU (M10-M20) (K05-K20) (N10-N20) (S10-S20)	PVD triple layer coated sub-micron grade for stainless steels, cast iron, titanium, non ferrous metals and most of the high temperature alloys.
BMA (P20-P40) (K20-K30)	PVD TiAlN coated sub-micrograin grade for stainless steels and exotic materials at medium to high cutting speeds.
P25C (P15-P35)	PVD TiN coated grade for treated and hard alloy steels (25 HRC & up) at medium to low cutting speeds.
MXC (K10-K20) (P10-P25)	PVD TiN coated micrograin for free cutting untreated alloy steels (below 30 HRC), for stainless steels and cast iron.
BXC (P30-P50) (K25-K40)	PVD TiN coated grade for low cutting speed. Works well with wide range of stainless steels.

Uncoated Grades

P30* (P20-P30)	Carbide grade for carbon and cast steels, works well at medium to low cutting speeds.
K20* (K10-K30)	Carbide grade for non ferrous metals, aluminum and cast iron.

* Upon request

Note: Due to our unique and specialized production techniques, Carmex coated inserts provide superior cutting performance and exceptionally long tool life.

Grade availability per inserts size

Grade	HBA	BLU	BMA	P25C	MXC	BXC	P30	K20
Insert sizes	11, 16, 22, 27	11, 16, 22	06, 08, 11, 16, 22, 27, 33U,	11, 16, 22, 27, 33U	11, 16, 22, 27, 33U	06, 08	11, 16, 22, 27, 33U	06, 08, 11, 16, 22, 27, 33U
			Type-B 11, 16					

Type B - Threading Inserts

A combination of ground profile, and sintered chip-breaker threading inserts. Unlike most other manufacturers inserts, this combination ensures a consistent high quality thread, with precise shape and dimensions. Two different unique styles of chip-breaker were designed to suit the different specific requirements of Internal threads and External threads. All of Carmex Type B inserts are made of BMA Sub-Micrograin grade.

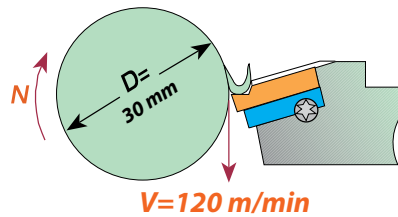


Recommended cutting speed (m/min) for thread turning inserts

ISO Standard	Material		Condition								
				HBA	BLU	BMA	P25C	MXC	BXC	K20	P30
P	Non-Alloy Steel and Cast Steel, Free Cutting Steel	<0.25%C	Annealed		110-210	120-180	100-180	100-180	70-150		50-130
		≥0.25%C	Annealed								
		<0.55%C	Quenched & Tempered								
		≥0.55%C	Annealed								
			Quenched & Tempered								
	Low Alloy Steel and Cast Steel (less than 5% alloying elements)		Annealed		90-140	80-130	70-120	70-120	60-90		50-80
			Quenched & Tempered								
High Alloy Steel, Cast Steel, and Tool Steel		Annealed		70-90	60-80	50-60	55-70	50-60		40-50	
		Quenched & Tempered									
M	Stainless Steel and Cast Steel		Ferritic / Martensitic		110-160	90-130	60-90	60-90	50-80	50-80	
			Martensitic								
			Austenitic								
K	Cast Iron Nodular (GGG)		Ferritic / Pearlitic		120-150	100-130		80-110	60-90		
			Pearlitic								
	Grey Cast Iron (GG)		Ferritic		140-150	120-130		90-100	65-85		
			Pearlitic								
	Malleable Cast Iron		Ferritic		110-140	100-130		80-100	60-85		
Pearlitic											
N	Aluminum-Wrought Alloy		Not Cureable		700-1000			600-800	450-600	600-800	350-500
			Cured								
	Aluminum-Cast, Alloyed	<=12% Si	Not Cureable		280-750			200-550	150-350	200-550	110-300
			Cured								
		>12% Si	High Temperature								
	Copper Alloys	>1% Pb	Free Cutting		190-350			150-250	110-180	150-250	90-150
			Brass								
			Electrolytic Copper								
	Non Metallic		Duroplastics, Fiber Plastics					200-300	150-210	100-200	110-150
Hard Rubber											
S	High Temp. Alloys, Super Alloys	Fe based	Annealed	20-80	30-65	25-60					
			Cured								
		Ni or Co based	Annealed								
			Cured								
			Cast								
	Titanium Alloys		Alpha +Beta Alloys Cured	30-60	40-50	35-45				35-45	
H	Hardened Steel		Hardened 45-50 HRc	30-60	40-50	35-45					
			Hardened 51-55 HRc								
			Hardened 56-62 HRc								
	Chilled Cast Iron		Cast	20-50	30-40	25-35					
	Cast Iron		Hardened	20-40	20-30	15-25					

Conversion of Cutting Speed to Rotational Speed

Conversion of a selected cutting speed to rotational speed is calculated by the following formula:



Example

$$N = \frac{V \times 1000}{\pi \times D} = \frac{120 \times 1000}{3.14 \times 30} = 1274 \text{ RPM}$$

Number of passes and depth of cut per pass for multitooth insert

	Pitch mm	Insert Size		No. of Teeth	Ordering Code	No. of Passes	Depth of Cut per pass			
		L	I.C. (in)				1	2	3	4
ISO External	1.00	16	3/8	3	16 ER 1.0 ISO 3M	2	0.38	0.25		
	1.50	16	3/8	2	16 ER 1.5 ISO 2M	3	0.42	0.30	0.20	
	1.50	22	1/2	3	22 ER 1.5 ISO 3M	2	0.55	0.37		
	2.00	22	1/2	2	22 ER 2.0 ISO 2M	3	0.57	0.40	0.28	
	2.00	22	1/2	3	22 ER 2.0 ISO 3M	2	0.76	0.49		
	3.00	27	5/8	2	27 ER 3.0 ISO 2M	4	0.59	0.51	0.42	0.32
ISO Internal	1.00	16	3/8	3	16 IR 1.0 ISO 3M	2	0.33	0.25		
	1.50	16	3/8	2	16 IR 1.5 ISO 2M	3	0.38	0.29	0.20	
	1.50	22	1/2	3	22 IR 1.5 ISO 3M	2	0.50	0.37		
	2.00	22	1/2	2	22 IR 2.0 ISO 2M	3	0.52	0.37	0.26	
	2.00	22	1/2	3	22 IR 2.0 ISO 3M	2	0.70	0.45		
	3.00	27	5/8	2	27 IR 3.0 ISO 2M	4	0.58	0.46	0.39	0.30
UN External	16	16	3/8	2	16 ER 16 UN 2M	3	0.44	0.31	0.22	
	16	22	1/2	3	22 ER 16 UN 3M	2	0.58	0.39		
	12	22	1/2	2	22 ER 12 UN 2M	3	0.59	0.42	0.30	
	12	22	1/2	3	22 ER 12 UN 3M	2	0.78	0.52		
	8	27	5/8	2	27 ER 8 UN 2M	4	0.62	0.54	0.45	0.35
UN Internal	16	16	3/8	2	16 IR 16 UN 2M	3	0.42	0.28	0.22	
	16	22	1/2	3	22 IR 16 UN 3M	2	0.55	0.37		
	12	22	1/2	2	22 IR 12 UN 2M	3	0.53	0.38	0.31	
	12	22	1/2	3	22 IR 12 UN 3M	2	0.74	0.48		
	8	27	5/8	2	27 IR 8 UN 2M	4	0.63	0.50	0.40	0.30
Whitworth 55° External	14	16	3/8	2	16 ER 14 W 2M	3	0.52	0.37	0.27	
	14	22	1/2	3	22 ER 14 W 3M	2	0.70	0.46		
	11	22	1/2	2	22 ER 11 W 2M	3	0.67	0.47	0.34	
Whitworth 55° Internal	14	16	3/8	2	16 IR 14 W 2M	3	0.52	0.37	0.27	
	14	22	1/2	3	22 IR 14 W 3M	2	0.70	0.46		
	11	22	1/2	2	22 IR 11 W 2M	2	0.67	0.47	0.34	
NPT External	14	16	3/8	2	16 ER 14 NPT 2M	3				
	11.5	22	1/2	2	22 ER 11.5 NPT 2M	4	0.54	0.47	0.37	0.30
	11.5	27	5/8	3	27 ER 11.5 NPT 3M	4	0.76	0.54	0.38	
	8	27	5/8	2	27 ER 8 NPT 2M	4	0.81	0.60	0.55	0.45
NPT Internal	14	16	3/8	2	16 IR 14 NPT 2M	3				
	11.5	22	1/2	2	22 IR 11.5 NPT 2M	4	0.54	0.47	0.37	0.30
	11.5	27	5/8	3	27 IR 11.5 NPT 3M	4	0.76	0.54	0.38	
	8	27	5/8	2	27 IR 8 NPT 2M	4	0.81	0.60	0.55	0.45
API Round External	10	22	1/2	2	22 ER 10 APIRD 2M	3	0.60	0.50	0.31	
	10	27	5/8	3	27 ER 10 APIRD 3M	2	1.00	0.41		
	8	27	5/8	2	27 ER 8 APIRD 2M	3	0.80	0.60	0.41	
API Round Internal	10	22	1/2	2	22 IR 10 APIRD 2M	3	0.60	0.50	0.31	
	10	27	5/8	3	27 IR 10 APIRD 3M	2	1.00	0.41		
	8	27	5/8	2	27 IR 8 APIRD 2M	3	0.80	0.60	0.41	

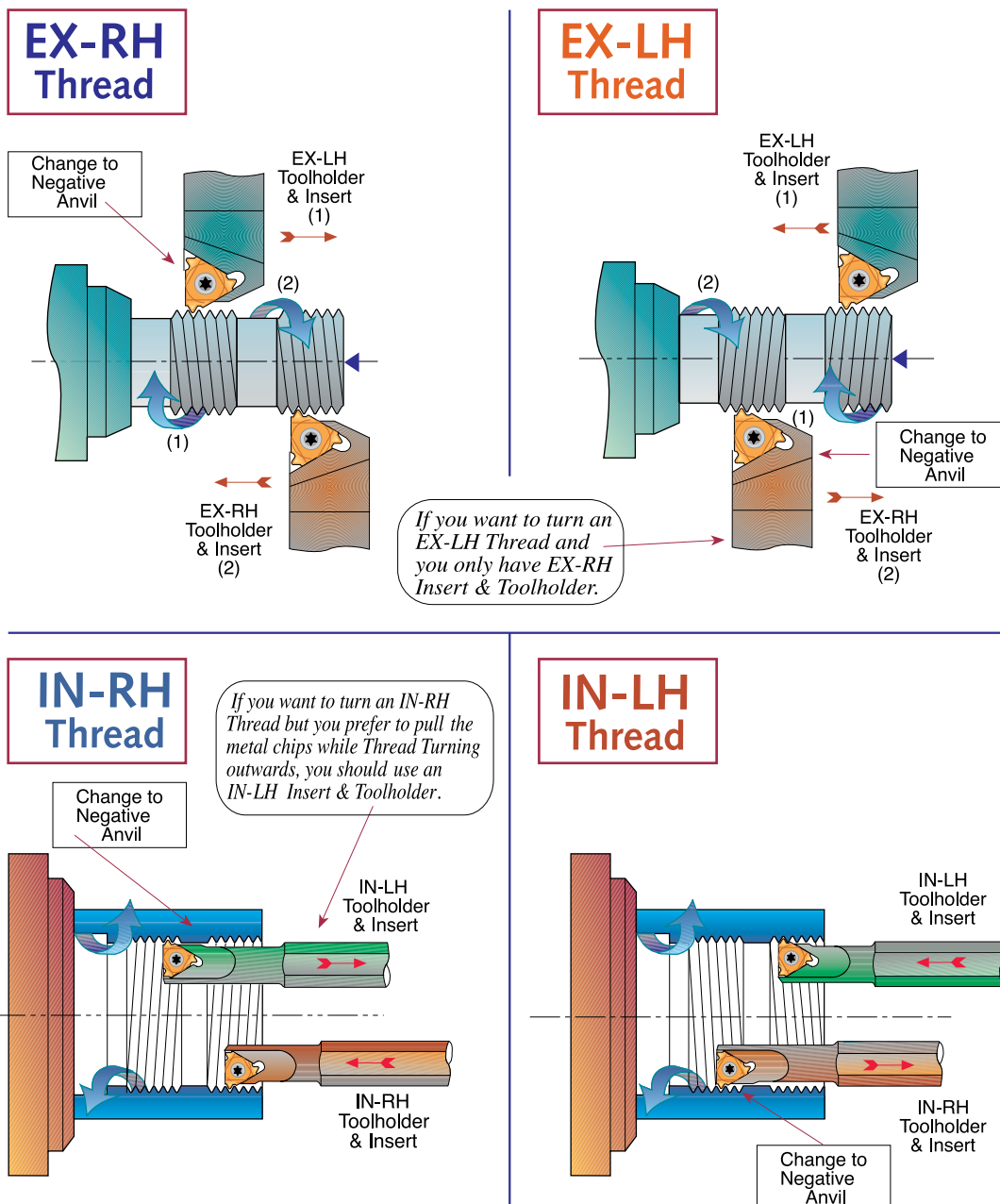
Number of threading passes selection for single point inserts

Pitch:	mm TPI	0.5 48	0.8 32	1.0 24	1.25 20	1.5 16	1.75 14	2.0 12	2.5 10	3.0 8	4.0 6	6.0 4
Number of Passes		3-6	4-7	4-9	6-10	5-11	9-12	6-13	7-15	8-17	10-20	11-22

NOTES:

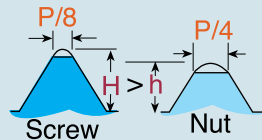
1. For most standard applications the middle of the range is a good starting point.
2. For most materials, the tougher the material, the higher the number of cutting passes you should select.
3. As a general rule of thumb, fewer passes are better than more speed.

Thread Turning Methods

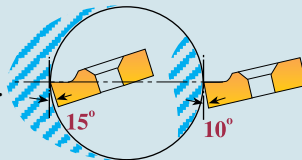


Important Points about Carmex Threading Inserts

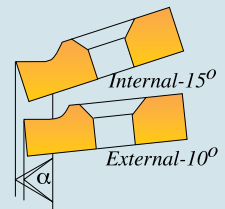
1. In most thread forms internal and external threads have different depth and radii, thus tools are not interchangeable



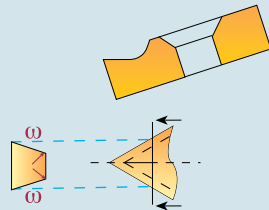
2. The Insert relief angle of a standard Carmex external toolholder is 10°; for an internal toolholder it is 15°. This 5° difference is to provide additional necessary radial clearance.



4. Profiles of Carmex internal & external threading inserts are precision ground to ensure accurate thread geometry when used in their corresponding toolholders. Using internal inserts with an external holder will result in distortion of angle and insert geometry.



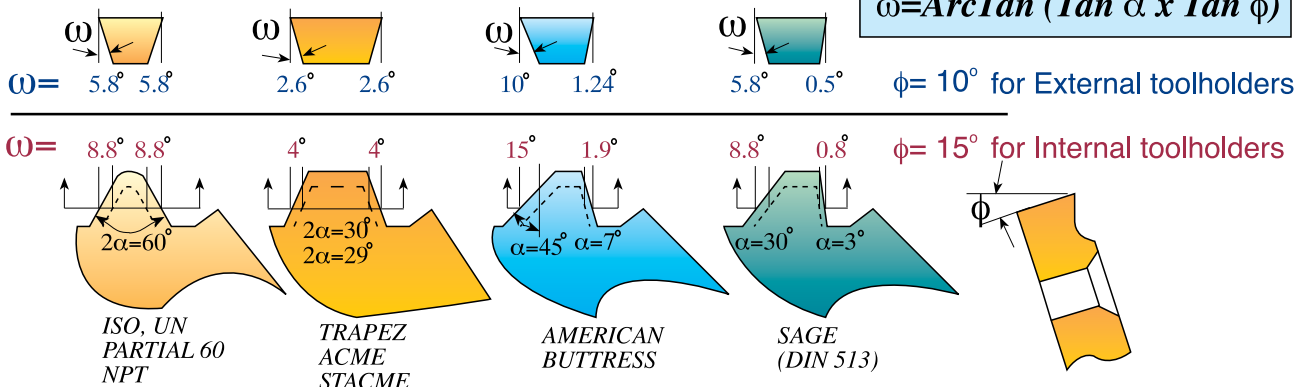
3. Our built-in relief angles ensure automatic insert flank angle clearance.



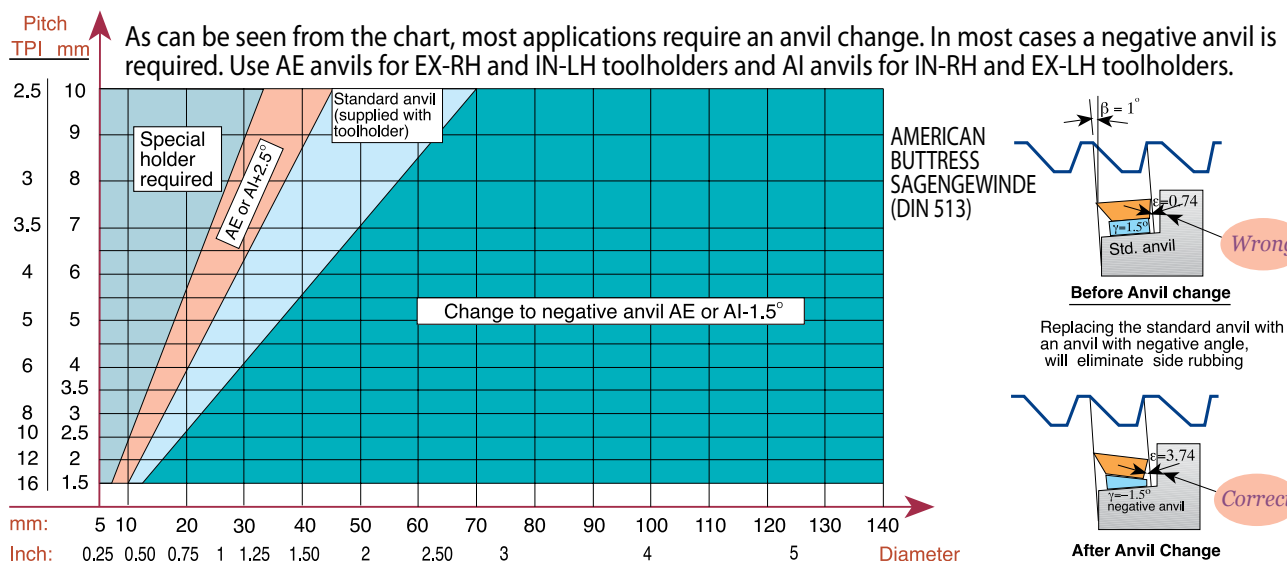
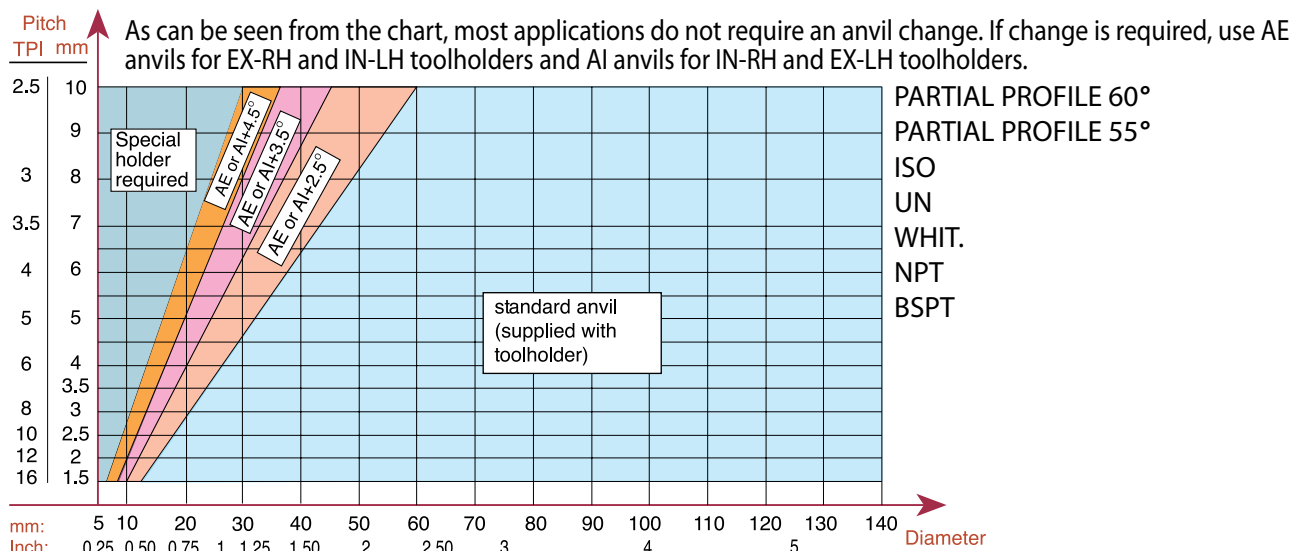
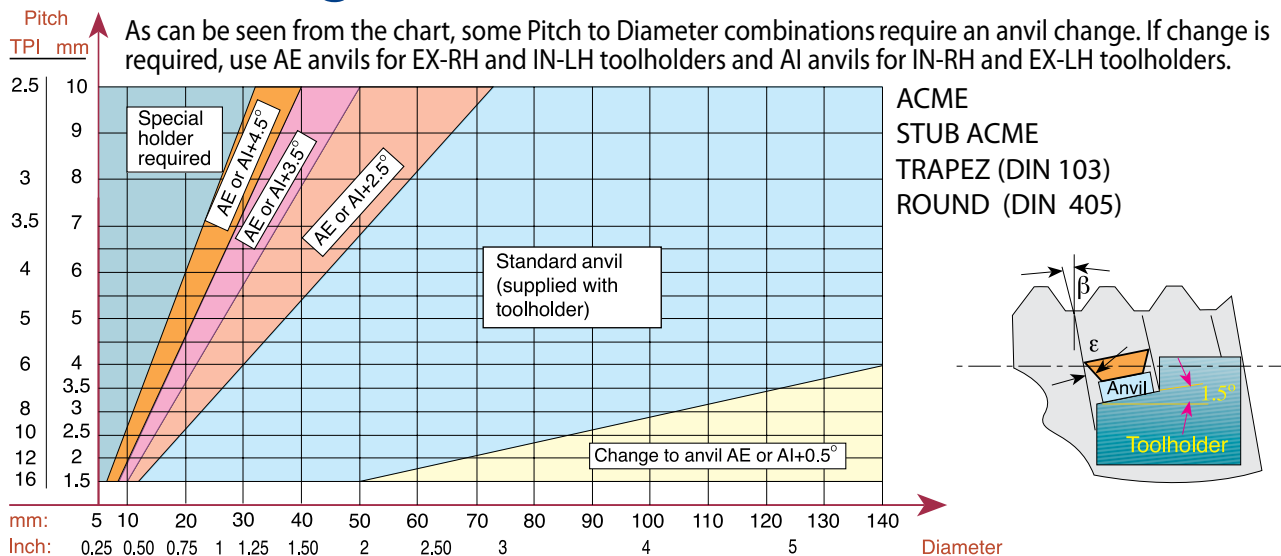
5. Insert and toolholder should always match. An IN-RH insert must be used with an IN-RH toolholder. No mismatch is allowed.



Flank Clearance Angle ω



Anvil Change Recommendation



Thread Turning - Step by Step

Step 1 : Choose Thread Turning Method from page 63

Step 2 : Choose Insert

Step 3 : Choose Toolholder

Step 4 : Choose Insert Grade

Step 5 : Choose Thread Turning Speed

Step 6 : Choose Number of Threading Passes

In most cases the above mentioned 6 steps would be the steps needed to ensure a good thread. When cutting more complicated threads such as TRAPEZ, ACME, BUTTRESS or SAGE, it is advisable to check the effect of the thread "HELIX ANGLE" β on the "RESULTANT FLANK CLEARANCE" ϵ . If ϵ is smaller than 2° , an anvil change is required.

Step 7 : Find Thread Helix Angle

Step 8 : Choose Correct Anvil

EXAMPLES:

Example No. 1:

Step 1: Choose Thread Turning Method from page 63, we chose **EX - RH Insert & Toolholder**

Step 2: Choose Insert from page 9: **16 ER 1.5 ISO**

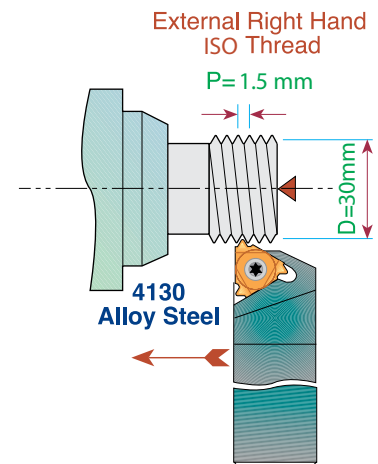
Step 3: Choose Toolholder from page 39: **SER 2020 K16**

Step 4: Choose Insert Grade from selection on page 60
Our choice for Alloy Steel is Grade **P25C**

Step 5: Choose Thread Turning Speed from chart on page 61,
we chose **100 m/min**

Rotational Speed calculation:
$$N = \frac{100 \times 1000}{\pi \times 30} = 1065 \text{ rpm}$$

Step 6: Choose Number of Threading passes from table on page 63, we chose **8 passes**



Example No. 2:

Step 1: Choose Thread Turning Method from page 63
Usually, an IN-RH Toolholder and Insert will be chosen, however, in this particular case we prefer to pull the metal chips while thread turning outward, thus we chose to work with **IN-LH Insert & Toolholder**

Step 2: Choose Insert from page 13: **16 IL 12 UN**

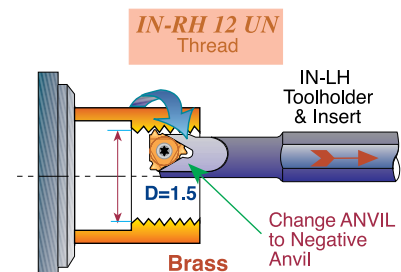
Step 3: Choose Toolholder from page 41: **SIL 0025 R16**
Note: since we thread cut IN-RH thread outward with an IN-LH tool, do not forget to replace the standard anvil (supplied with the holder) with a negative anvil **AE16-1.5**

Step 4: Choose Insert Grade from selection on page 60
Our choice for Brass is Grade **K20**

Step 5: Choose Thread Turning Speed from chart on page 61,
we chose **150 m/min**

Rotational Speed calculation:
$$N = \frac{150 \times 1000}{\pi \times 38.1} = 1254 \text{ RPM}$$

Step 6: Choose Number of Threading passes from table on page 63, we chose **9 passes**

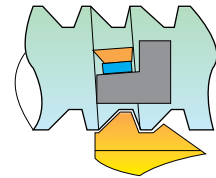


Example No. 3:

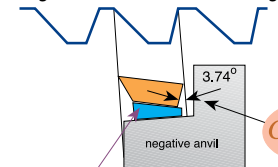
- Step 1: Choose Thread Turning Method from page 63
We chose EX-RH Insert & Toolholder.
- Step 2: Choose Insert from page 33: **16 ER 12 ABUT**
- Step 3: Choose Toolholder from page 39: **SER 2525 M16**
- Step 4: Choose Insert Grade from selection on page 60
Our choice for Stainless Steel is Grade **BMA**
- Step 5: Choose Thread Turning Speed from chart on page 61
We chose 120 m/min.
Rotational Speed calculation:
$$N = \frac{120 \times 1000}{\pi \times 40} = 954 \text{ RPM}$$
- Step 6: Choose Number of Threading passes from table on page 63. We chose **13 passes**
- Step 7: Find Thread Helix Angle: on page 48 for Pitch of 12 TPI and 40 Diameter
Helix Angle as shown in the chart is 1°
- Step 8: Choose correct Anvil: As can be seen from the chart on page 65, for AMERICAN BUTTRESS Thread, for 12 TPI and 40 Diameter a negative anvil **AE16-1.5** should replace the standard anvil supplied with the toolholder

EX-RH. AMERICAN BUTTRESS
12 TPI on 40 mm diameter.

Stainless Steel 304



Replacing the standard anvil with an anvil with negative angle will eliminate side rubbing



Anvil chosen:
AE16-1.5

Troubleshooting

Chipping



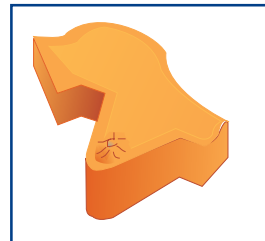
1. Use a tougher carbide grade
2. Eliminate tool overhang
3. Check if insert is correctly clamped
4. Eliminate vibration

Crater Wear



1. Reduce cutting speed
2. Apply coolant fluid
3. Use a harder carbide grade

Build-up Edge



1. Increase cutting speed
2. Use a tougher carbide grade

Thermal Cracking



1. Reduce cutting speed
2. Apply coolant fluid
3. Use a tougher carbide grade

Deformation



1. Use a harder carbide grade
2. Reduce cutting speed
3. Reduce depth of cut
4. Apply coolant fluid

Fracture



1. Use a tougher carbide grade
2. Reduce depth of cut
3. Index insert sooner
4. Check machine and tool stability

Threading Inserts Standards

Thread Profile	Standard	Thread Class
ISO	DIN 13	6g / 6H
UN	ANSI B1.1-1989	2A / 2B
WHITWORTH	B.S. 84: 1956	Medium Class
NPT	ANSI B1.20.1-1983	-
NPTF	ANSI B1.20.3-1976	-
BSPT	B.S. 21: 1957	-
DIN 477	DIN 477	-
ACME	ANSI B1.5-1988	3G
STUB ACME	ANSI B1.5-1988	2G
TRAPEZ	DIN 103	7e / 7H
ROUND	DIN 405	Class 7
UNJ	MIL-S-8879C	3A / 3B
MJ	ISO 5855	4h/6h 4H/5H
AMERICAN BUTTRESS	ANSI B1.9-1973	Class 2
SAGENGEWINDE	DIN 513	-
PG	DIN 40430	-
V-0.040	API Spec7	-
V-0.038R	API Spec7	-
V-0.050	API Spec7	-
V-0.055	API Spec7	-
API ROUND	API Spec Standard 5B	-
EXTREME – LINE CASING	API Spec Standard 5B	-
BUTTRESS CASING	API Spec Standard 5B	-
VAM	VAM	-

DIN: **Deutsches Institut für Normung**
 ANSI: **American National Standards Institute**
 API: **American Petroleum Institute**
 B.S.: **British Standards**
 ISO: **International Organisation for Standardisation**
 MIL-S: **Military Specification**