

# Mill - Thread Inserts and Kits



**Mill-Thread tools for threading on CNC milling machines  
by using helical interpolation programs**

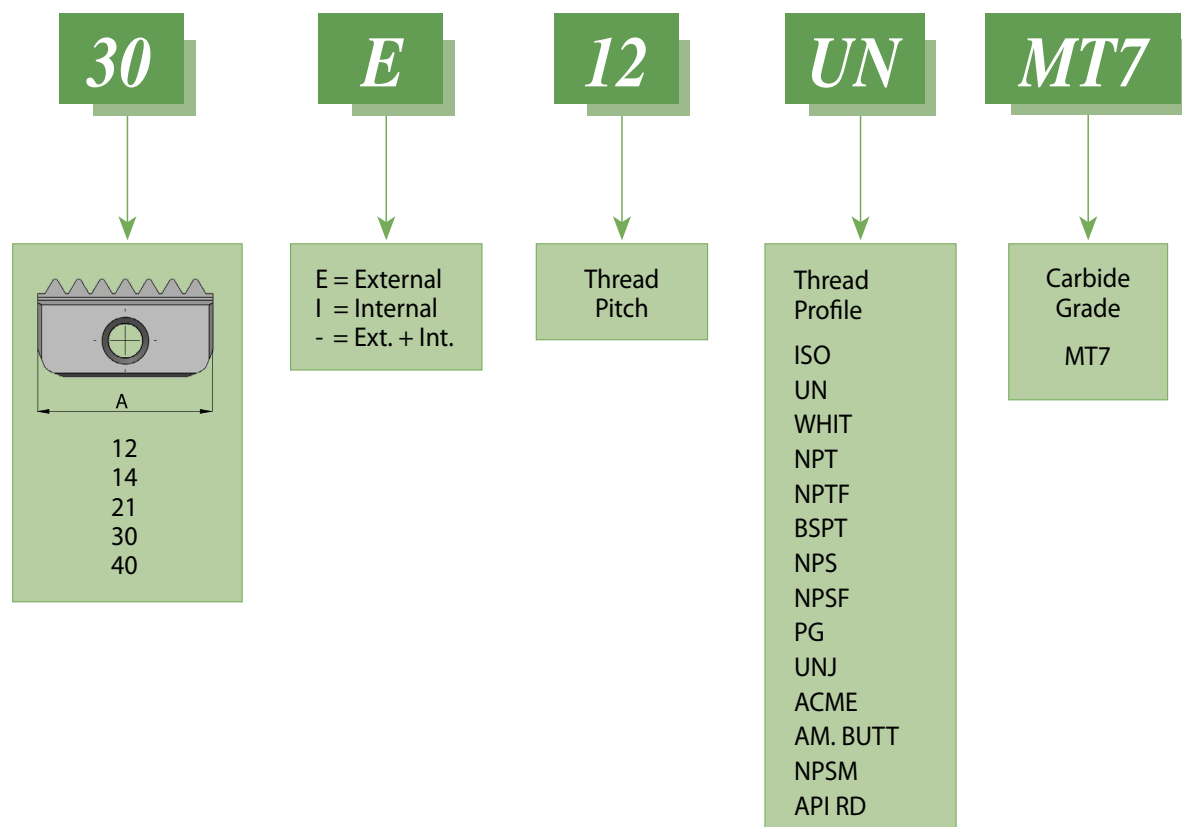
## Advantages of Mill-Thread Tools

- Same toolholder and insert can produce both right-hand and left-hand threads.
- A single insert & toolholder can produce a given thread on many diameters (External & Internal).
- Prismatic shape of insert's tail ensures exact and reliable clamping in the toolholder.
- Most inserts are double sided, having two cutting edges.
- Thread is produced in one tool pass.
- MT tools can produce tapered threads.
- Improved productivity thanks to increased cutting speeds and multitooth type carbide inserts.
- Threading to one pitch of a shoulder in a blind hole.
- Longer tool life thanks to a special multilayer coating process.
- Lower tooling costs, considerably less expensive than using taps and dies.
- Since lower machine power is required, a smaller machine can produce larger threads in a single operation with less idle time and tool changes.

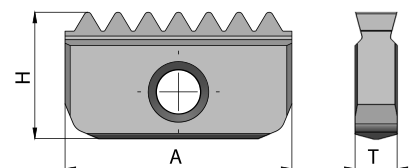
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## Product Identification

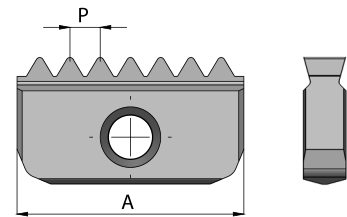
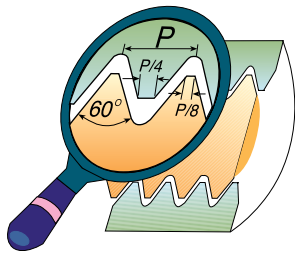
### Mill-Thread Inserts Ordering Codes



|   | Insert Size = A |       |       |       |       |
|---|-----------------|-------|-------|-------|-------|
|   | 12 mm           | 14 mm | 21 mm | 30 mm | 40 mm |
| H | .248            | .295  | .472  | .630  | .787  |
| T | .114            | .122  | .185  | .217  | .248  |



## ISO

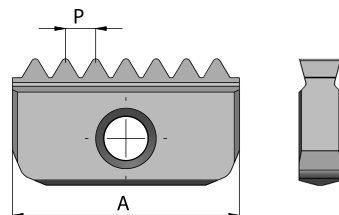
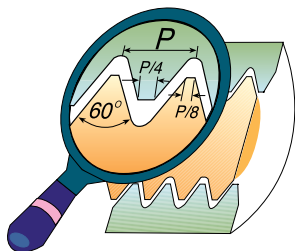


| Pitch<br>mm |      | Insert Size = A |               |               |                |                |
|-------------|------|-----------------|---------------|---------------|----------------|----------------|
|             |      | 12 mm<br>.472   | 14 mm<br>.551 | 21 mm<br>.827 | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 0.5         | Ext. |                 |               |               |                |                |
| 0.5         | Int. | * 12 I 0.5 ISO  | 14 I 0.5 ISO  |               |                |                |
| 0.75        | Ext. |                 | 14 E 0.75 ISO |               |                |                |
| 0.75        | Int. | * 12 I 0.75 ISO | 14 I 0.75 ISO |               |                |                |
| 1.0         | Ext. |                 | 14 E 1.0 ISO  | 21 E 1.0 ISO  |                |                |
| 1.0         | Int. | * 12 I 1.0 ISO  | 14 I 1.0 ISO  | 21 I 1.0 ISO  |                |                |
| 1.25        | Ext. |                 | 14 E 1.25 ISO |               |                |                |
| 1.25        | Int. | * 12 I 1.25 ISO | 14 I 1.25 ISO | 21 I 1.25 ISO |                |                |
| 1.5         | Ext. |                 | 14 E 1.5 ISO  | 21 E 1.5 ISO  | 30 E 1.5 ISO   | 40 E 1.5 ISO   |
| 1.5         | Int. | * 12 I 1.5 ISO  | 14 I 1.5 ISO  | 21 I 1.5 ISO  | 30 I 1.5 ISO   | 40 I 1.5 ISO   |
| 1.75        | Ext. |                 | 14 E 1.75 ISO |               |                |                |
| 1.75        | Int. |                 | 14 I 1.75 ISO | 21 I 1.75 ISO |                |                |
| 2.0         | Ext. |                 | 14 E 2.0 ISO  | 21 E 2.0 ISO  | 30 E 2.0 ISO   | 40 E 2.0 ISO   |
| 2.0         | Int. |                 | 14 I 2.0 ISO  | 21 I 2.0 ISO  | 30 I 2.0 ISO   | 40 I 2.0 ISO   |
| 2.5         | Ext. |                 | 14 E 2.5 ISO  | 21 E 2.5 ISO  |                |                |
| 2.5         | Int. |                 | 14 I 2.5 ISO  | 21 I 2.5 ISO  |                |                |
| 3.0         | Ext. |                 |               | 21 E 3.0 ISO  | 30 E 3.0 ISO   | 40 E 3.0 ISO   |
| 3.0         | Int. |                 |               | 21 I 3.0 ISO  | 30 I 3.0 ISO   | 40 I 3.0 ISO   |
| 3.5         | Ext. |                 |               |               | 30 E 3.5 ISO   |                |
| 3.5         | Int. |                 |               | 21 I 3.5 ISO  | 30 I 3.5 ISO   | 40 I 3.5 ISO   |
| 4.0         | Ext. |                 |               |               | 30 E 4.0 ISO   | 40 E 4.0 ISO   |
| 4.0         | Int. |                 |               |               | 30 I 4.0 ISO   | 40 I 4.0 ISO   |
| 4.5         | Ext. |                 |               |               |                |                |
| 4.5         | Int. |                 |               |               | 30 I 4.5 ISO   | 40 I 4.5 ISO   |
| 5.0         | Ext. |                 |               |               |                | 40 E 5.0 ISO   |
| 5.0         | Int. |                 |               |               | 30 I 5.0 ISO   | 40 I 5.0 ISO   |
| 5.5         | Ext. |                 |               |               |                |                |
| 5.5         | Int. |                 |               |               | 30 I 5.5 ISO   | 40 I 5.5 ISO   |
| 6.0         | Ext. |                 |               |               |                | 40 E 6.0 ISO   |
| 6.0         | Int. |                 |               |               |                | 40 I 6.0 ISO   |

\* One cutting edge

Order example: 14 I 1.5 ISO MT7

## UN UNC, UNF, UNEF, UNS



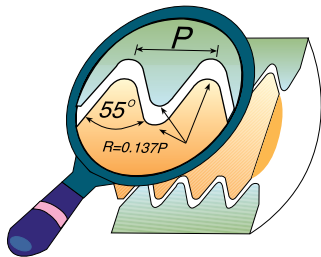
| Pitch<br>TPI |      | Insert Size = A |               |               |                |                |
|--------------|------|-----------------|---------------|---------------|----------------|----------------|
|              |      | 12 mm<br>.472   | 14 mm<br>.551 | 21 mm<br>.827 | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 32           | Ext. |                 | 14 E 32 UN    |               |                |                |
| 32           | Int. | * 12 I 32 UN    | 14 I 32 UN    |               |                |                |
| 28           | Ext. |                 | 14 E 28 UN    |               |                |                |
| 28           | Int. | * 12 I 28 UN    | 14 I 28 UN    |               |                |                |
| 27           | Ext. |                 |               |               |                |                |
| 27           | Int. |                 | 14 I 27 UN    |               |                |                |
| 24           | Ext. |                 | 14 E 24 UN    | 21 E 24 UN    |                |                |
| 24           | Int. | * 12 I 24 UN    | 14 I 24 UN    | 21 I 24 UN    |                |                |
| 20           | Ext. |                 | 14 E 20 UN    | 21 E 20 UN    | 30 E 20 UN     |                |
| 20           | Int. | * 12 I 20 UN    | 14 I 20 UN    | 21 I 20 UN    | 30 I 20 UN     |                |
| 18           | Ext. |                 | 14 E 18 UN    | 21 E 18 UN    | 30 E 18 UN     |                |
| 18           | Int. | * 12 I 18 UN    | 14 I 18 UN    | 21 I 18 UN    | 30 I 18 UN     |                |
| 16           | Ext. |                 | 14 E 16 UN    | 21 E 16 UN    | 30 E 16 UN     | 40 E 16 UN     |
| 16           | Int. | * 12 I 16 UN    | 14 I 16 UN    | 21 I 16 UN    | 30 I 16 UN     | 40 I 16 UN     |
| 14           | Ext. |                 | 14 E 14 UN    | 21 E 14 UN    | 30 E 14 UN     | 40 E 14 UN     |
| 14           | Int. |                 | 14 I 14 UN    | 21 I 14 UN    | 30 I 14 UN     | 40 I 14 UN     |
| 13           | Ext. |                 | 14 E 13 UN    |               |                |                |
| 12           | Ext. |                 | 14 E 12 UN    | 21 E 12 UN    | 30 E 12 UN     | 40 E 12 UN     |
| 12           | Int. |                 | 14 I 12 UN    | 21 I 12 UN    | 30 I 12 UN     | 40 I 12 UN     |
| 11           | Ext. |                 | 14 E 11 UN    | 21 E 11 UN    |                |                |
| 11           | Int. |                 | 14 I 11 UN    |               |                |                |
| 10           | Ext. |                 | * 14 E 10 UN  | 21 E 10 UN    | 30 E 10 UN     | 40 E 10 UN     |
| 10           | Int. |                 | 14 I 10 UN    | 21 I 10 UN    | 30 I 10 UN     | 40 I 10 UN     |
| 9            | Ext. |                 |               |               |                |                |
| 9            | Int. |                 | ** 14 I 9 UN  |               |                |                |
| 8            | Ext. |                 |               |               | 30 E 8 UN      | 40 E 8 UN      |
| 8            | Int. |                 |               | 21 I 8 UN     | 30 I 8 UN      | 40 I 8 UN      |
| 7            | Ext. |                 |               |               |                |                |
| 7            | Int. |                 |               | 21 I 7 UN     |                |                |
| 6            | Ext. |                 |               |               | 30 E 6 UN      | 40 E 6 UN      |
| 6            | Int. |                 |               |               | 30 I 6 UN      | 40 I 6 UN      |
| 5            | Ext. |                 |               |               |                |                |
| 5            | Int. |                 |               |               | 30 I 5 UN      |                |
| 4.5          | Ext. |                 |               |               |                |                |
| 4.5          | Int. |                 |               |               |                | 40 I 4.5UN     |
| 4            | Ext. |                 |               |               |                |                |
| 4            | Int. |                 |               |               |                | 40 I 4 UN      |

\* One cutting edge

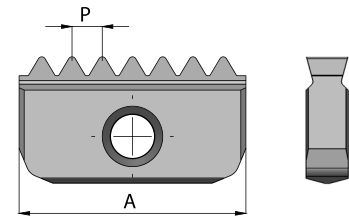
\*\* Cannot be used with carbide shank Toolholders.

Order example: 21 I 18 UN MT7

## WHIT BSW, BSF, BSP



Same Insert for External and Internal thread.

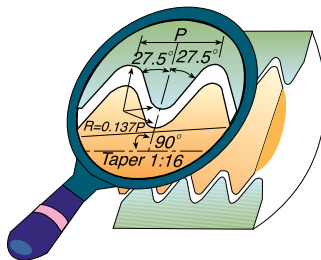


| Pitch<br>TPI | Insert Size = A |               |               |                |                |
|--------------|-----------------|---------------|---------------|----------------|----------------|
|              | 12 mm<br>.472   | 14 mm<br>.551 | 21 mm<br>.827 | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 24           |                 | 14-24 W       |               |                |                |
| 20           |                 | 14-20 W       | 21-20 W       |                |                |
| 19           | * 12 - 19 W     | 14-19 W       | 21-19 W       |                |                |
| 18           |                 | 14-18 W       |               |                |                |
| 16           |                 | 14-16 W       | 21-16 W       | 30-16 W        |                |
| 14           |                 | 14-14 W       | 21-14 W       | 30-14 W        |                |
| 12           |                 | 14-12 W       |               |                |                |
| 11           |                 | * 14-11 W     | 21-11 W       | 30-11 W        | 40-11 W        |
| 10           |                 |               | 21-10 W       |                |                |
| 8            |                 |               |               |                | 40- 8 W        |

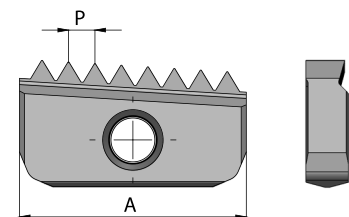
\* One cutting edge

Order example: 21-11 W MT7

## BSPT



Conical pipe thread inserts are one-sided and may be used for both External and Internal threading.

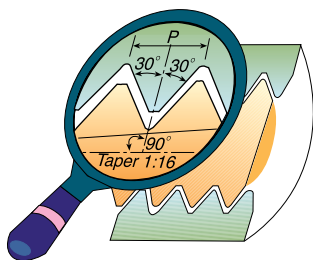


| Pitch<br>TPI | Insert Size = A |               |               |                |                |
|--------------|-----------------|---------------|---------------|----------------|----------------|
|              | 12 mm<br>.472   | 14 mm<br>.551 | 21 mm<br>.827 | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 19           | 12-19 BSPT      | 14-19 BSPT    |               |                |                |
| 14           |                 | 14-14 BSPT    | 21-14 BSPT    |                |                |
| 11           |                 |               | 21-11 BSPT    | 30-11 BSPT     | 40-11 BSPT     |

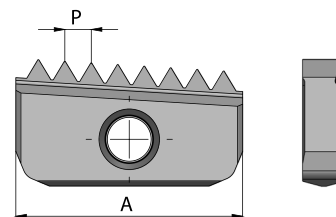
Order example: 14-19 BSPT MT7

For conical preparation end mills see page 253

## NPT



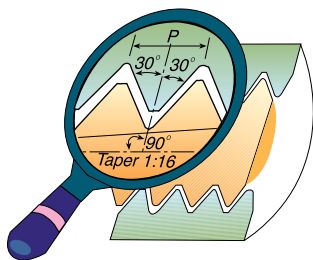
Conical pipe thread inserts are one-sided and may be used for both External and Internal threading.



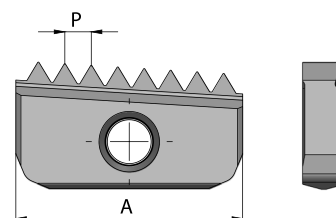
| Pitch<br>TPI | Insert Size = A |               |               |                |                |
|--------------|-----------------|---------------|---------------|----------------|----------------|
|              | 12 mm<br>.472   | 14 mm<br>.551 | 21 mm<br>.827 | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 18           | 12-18 NPT       | 14-18 NPT     |               |                |                |
| 14           |                 | 14-14 NPT     | 21-14 NPT     |                |                |
| 11.5         |                 |               | 21-11.5 NPT   | 30-11.5 NPT    | 40-11.5 NPT    |
| 8            |                 |               |               | 30- 8 NPT      | 40- 8 NPT      |

Order example: 30-11.5 NPT MT7

## NPTF



Conical pipe thread inserts are one-sided and may be used for both External and Internal threading.

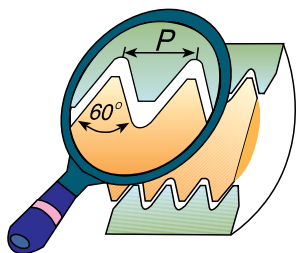


| Pitch<br>TPI | Insert Size = A |               |               |                |                |
|--------------|-----------------|---------------|---------------|----------------|----------------|
|              | 12 mm<br>.472   | 14 mm<br>.551 | 21 mm<br>.827 | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 18           | 12-18 NPTF      | 14-18 NPTF    |               |                |                |
| 14           |                 | 14-14 NPTF    | 21-14 NPTF    |                |                |
| 11.5         |                 |               | 21-11.5 NPTF  | 30-11.5 NPTF   | 40-11.5 NPTF   |
| 8            |                 |               |               | 30- 8 NPTF     | 40- 8 NPTF     |

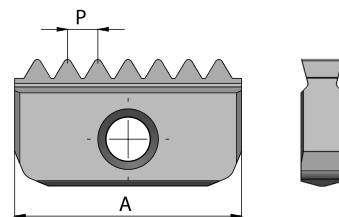
Order example: 21-14 NPTF MT7

For conical preparation end mills see page 253

## NPS



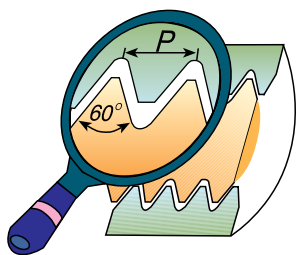
Same Insert for External and Internal thread



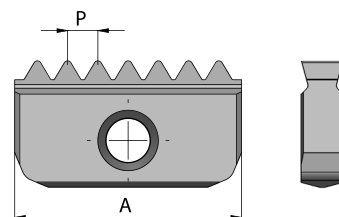
| Pitch<br>TPI | 12 mm<br>.472 | 14 mm<br>.551 | Insert Size = A |                |                |
|--------------|---------------|---------------|-----------------|----------------|----------------|
|              |               |               | 21 mm<br>.827   | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 18           | * 12-18 NPS   | 14-18 NPS     |                 |                |                |
| 14           |               | 14-14 NPS     | 21-14 NPS       |                |                |
| 11.5         |               |               | 21-11.5 NPS     | 30-11.5 NPS    | 40-11.5 NPS    |
| 8            |               |               |                 | 30- 8 NPS      | 40- 8 NPS      |

Order example: 16 ER 14 NPS MXC

## NPSF



Same Insert for External and Internal thread

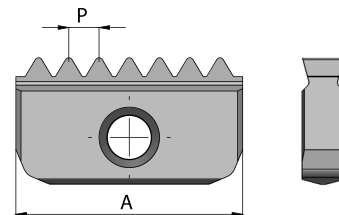
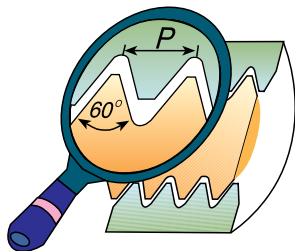


| Pitch<br>TPI | 12 mm<br>.472 | 14 mm<br>.551 | Insert Size = A |                |                |
|--------------|---------------|---------------|-----------------|----------------|----------------|
|              |               |               | 21 mm<br>.827   | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 18           | * 12-18 NPSF  | 14-18 NPSF    |                 |                |                |
| 14           |               | 14-14 NPSF    | 21-14 NPSF      |                |                |
| 11.5         |               |               | 21-11.5 NPSF    | 30-11.5 NPSF   | 40-11.5 NPSF   |
| 8            |               |               |                 | 30- 8 NPSF     | 40- 8 NPSF     |

Order example: 21-14 NPSF MT7

\* One cutting edge

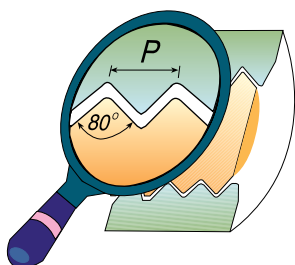
## NPSM



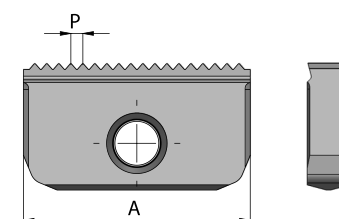
| Pitch<br>TPI |      | Insert Size = A |               |                |                |                |
|--------------|------|-----------------|---------------|----------------|----------------|----------------|
|              |      | 12 mm<br>.472   | 14 mm<br>.551 | 21 mm<br>.827  | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 18           | Ext. |                 | 14 E 18 NPSM  |                |                |                |
| 18           | Int. | 12 I 18 NPSM    | 14 I 18 NPSM  |                |                |                |
| 14           | Ext. |                 |               | 21 E 14 NPSM   |                |                |
| 14           | Int. |                 | 14 I 14 NPSM  | 21 I 14 NPSM   |                |                |
| 11.5         | Ext. |                 |               | 21 E 11.5 NPSM | 30 E 11.5 NPSM | 40 E 11.5 NPSM |
| 11.5         | Int. |                 |               | 21 I 11.5 NPSM | 30 I 11.5 NPSM | 40 I 11.5 NPSM |
| 8            | Ext. |                 |               |                | 30 E 8 NPSM    | 40 E 8 NPSM    |
| 8            | Int. |                 |               |                | 30 I 8 NPSM    | 40 I 8 NPSM    |

Order example: 21 I 11.5 NPSM MT7

## PG - DIN 40430



Same Insert for External and Internal thread

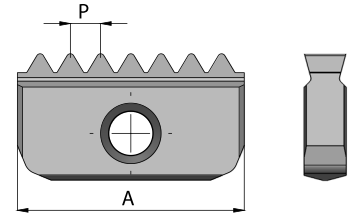
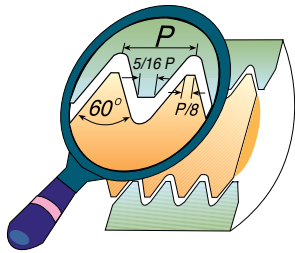


| Pitch<br>TPI | Insert Size = A                  |                                     |                             |
|--------------|----------------------------------|-------------------------------------|-----------------------------|
|              | 14 mm<br>.551                    | 21 mm<br>.827                       | 30 mm<br>1.181              |
| 18           | 14-18 PG<br>(PG 9, 11, 13.5, 16) | 21-18 PG<br>(PG 16)                 |                             |
| 16           |                                  | 21-16 PG<br>(PG 21, 29, 36, 42, 48) | 30-16 PG<br>(PG 36, 42, 48) |

Order example: 21-18 PG MT7



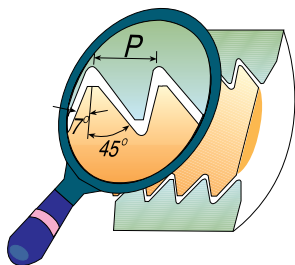
## UNJ



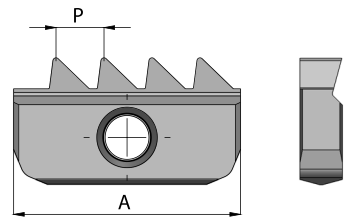
| Pitch<br>TPI |      | Insert Size = A |               |
|--------------|------|-----------------|---------------|
|              |      | 14 mm<br>.551   | 21 mm<br>.827 |
| 24           | Ext. | 14 E 24 UNJ     | 21 E 24 UNJ   |
| 24           | Int. | 14 I 24 UNJ     | 21 I 24 UNJ   |
| 20           | Ext. | 14 E 20 UNJ     | 21 E 20 UNJ   |
| 20           | Int. | 14 I 20 UNJ     | 21 I 20 UNJ   |
| 18           | Ext. | 14 E 18 UNJ     | 21 E 18 UNJ   |
| 18           | Int. | 14 I 18 UNJ     | 21 I 18 UNJ   |
| 16           | Ext. | 14 E 16 UNJ     | 21 E 16 UNJ   |
| 16           | Int. | 14 I 16 UNJ     | 21 I 16 UNJ   |
| 14           | Ext. | 14 E 14 UNJ     | 21 E 14 UNJ   |
| 14           | Int. | 14 I 14 UNJ     | 21 I 14 UNJ   |
| 12           | Ext. | 14 E 12 UNJ     | 21 E 12 UNJ   |
| 12           | Int. | 14 I 12 UNJ     | 21 I 12 UNJ   |

Order example: 21E 16 UNJ MT7

## American Buttress



ABUT thread inserts are one-sided and may be used for both External and Internal threading

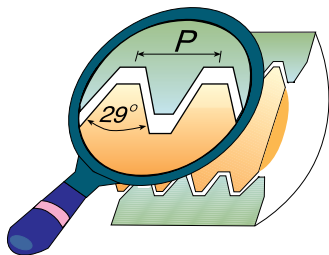


| Pitch<br>TPI | Insert Size = A |                |                |
|--------------|-----------------|----------------|----------------|
|              | 21 mm<br>.827   | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 16           | 21 - 16 ABUT    | 30 - 16 ABUT   |                |
| 12           | 21 - 12 ABUT    | 30 - 12 ABUT   |                |
| 10           | 21 - 10 ABUT    | 30 - 10 ABUT   |                |
| 8            | 21 - 8 ABUT     | 30 - 8 ABUT    |                |
| 6            |                 | 30 - 6 ABUT    |                |
| 4            |                 | * 30 - 4 ABUT  | 40 - 4 ABUT    |

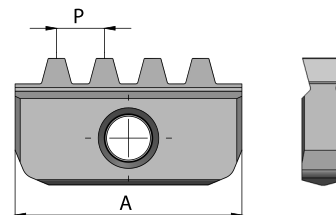
Order example: 30 - 6 ABUT MT7

\* Inserts to be used only on Multi-Insert toolholders see page 187

## ACME



Inserts for Internal threads



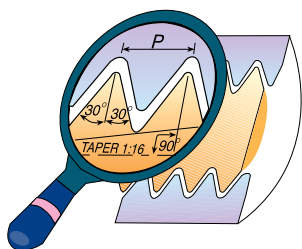
| Pitch<br>TPI |      | Insert Size = A |                |                |
|--------------|------|-----------------|----------------|----------------|
|              |      | 21 mm<br>.827   | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 12           | Int. | 21   12 ACME    | 30   12 ACME   |                |
| 10           | Int. | 21   10 ACME    | 30   10 ACME   |                |
| 8            | Int. | 21   8 ACME     | 30   8 ACME    |                |
| 6            | Int. |                 | 30   6 ACME    |                |
| 5            | Int. |                 | 30   5 ACME    |                |
| 4            | Int. |                 | * 30   4 ACME  | 40   4 ACME    |
| 3.5          | Int. |                 |                | 40   3.5 ACME  |
| 3            | Int. |                 |                | ** 40   3 ACME |

Order example: 21 | 8 ACME MT7

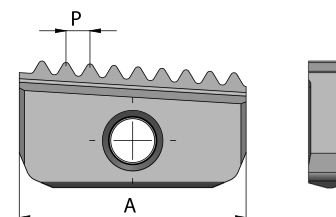
\* Inserts to be used only on Multi-Insert toolholders see page 187

\*\* One cutting edge

## API RD



API RD thread inserts are one - sided and may be used for both External and Internal threading



| Pitch<br>TPI | Insert Size = A |                |                |
|--------------|-----------------|----------------|----------------|
|              | 21 mm<br>.827   | 30 mm<br>1.181 | 40 mm<br>1.575 |
| 10           | 21 - 10 API RD  | 30 - 10 API RD |                |
| 8            |                 | 30 - 8 API RD  | 40 - 8 API RD  |

Order example: 30 - 8 API RD MT7

## Internal UN Kits



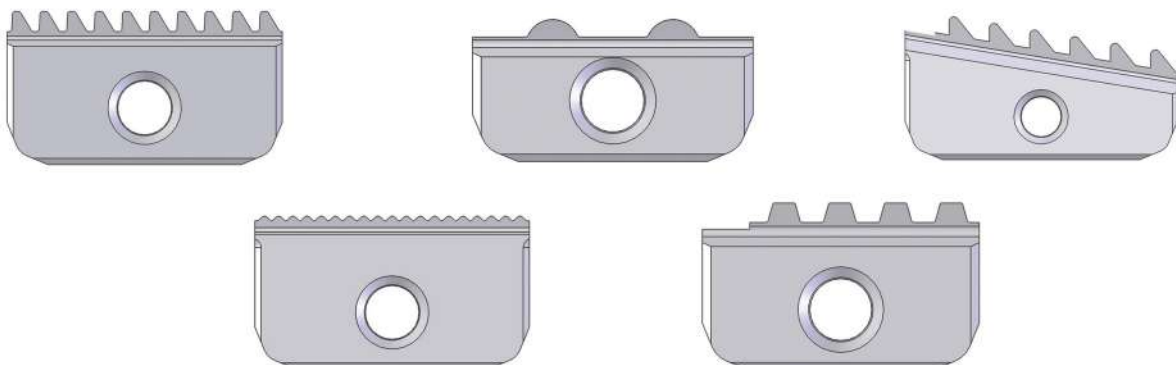
| MTK 12 I UN                                                                                                         | MTK 14 I UN                                                                                                         |
|---------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------|
| <div>INSERTS</div> <div>12 I 32 UN<br/>12 I 24 UN<br/>12 I 20 UN<br/>12 I 20 UN<br/>12 I 16 UN<br/>12 I 16 UN</div> | <div>INSERTS</div> <div>14 I 24 UN<br/>14 I 24 UN<br/>14 I 20 UN<br/>14 I 20 UN<br/>14 I 16 UN<br/>14 I 16 UN</div> |
| <div>TOOLHOLDER</div> <div>SR 0375 H12</div>                                                                        | <div>TOOLHOLDER</div> <div>SR 0670 H14</div>                                                                        |
| <div>KEY</div> <div>K12</div>                                                                                       | <div>KEY</div> <div>K14</div>                                                                                       |
| <div>SCREW</div> <div>S12</div>                                                                                     | <div>SCREW</div> <div>S14</div>                                                                                     |

Order example : MTK 14 I UN

## Special Tools



In addition to standard products,  
Carmex manufactures special tools and inserts  
according to customers' requests.  
Special tools are supplied in short delivery times.



# Mill-Thread Toolholders



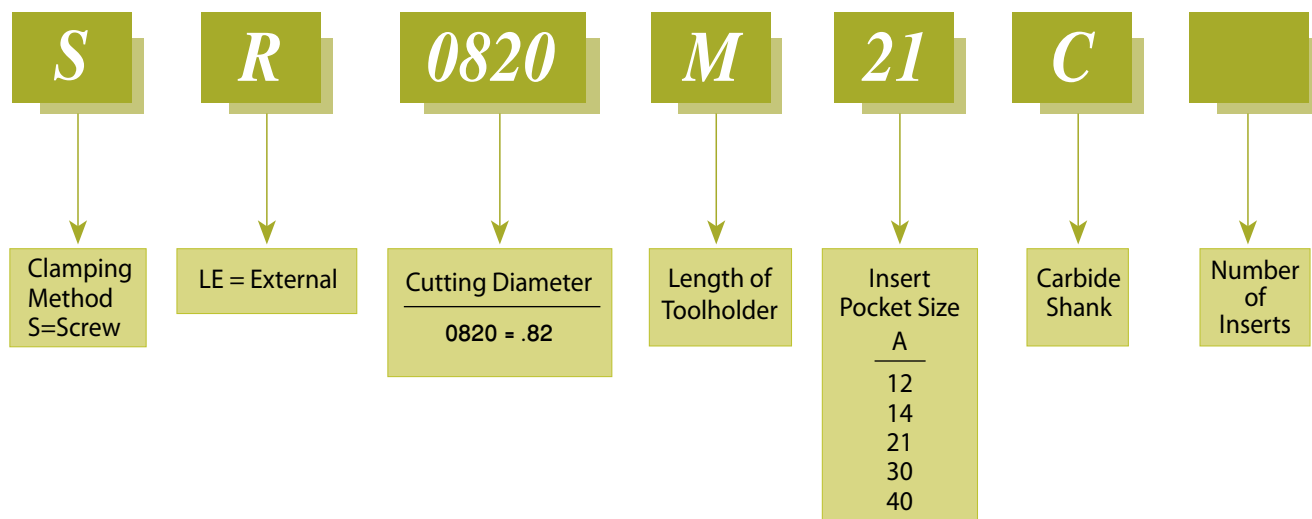
## Contents:

## Page:

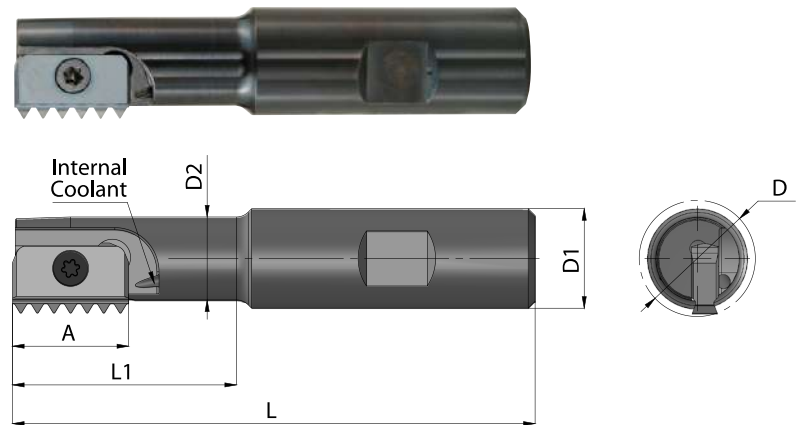
|                                                      |     |
|------------------------------------------------------|-----|
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| Long Carbide Shank Toolholders                       | 188 |
| Carbide Shank Toolholders for Single Point Threading | 188 |

## Product Identification

### Mill-Thread Toolholders Ordering Codes



## Single Insert Toolholders

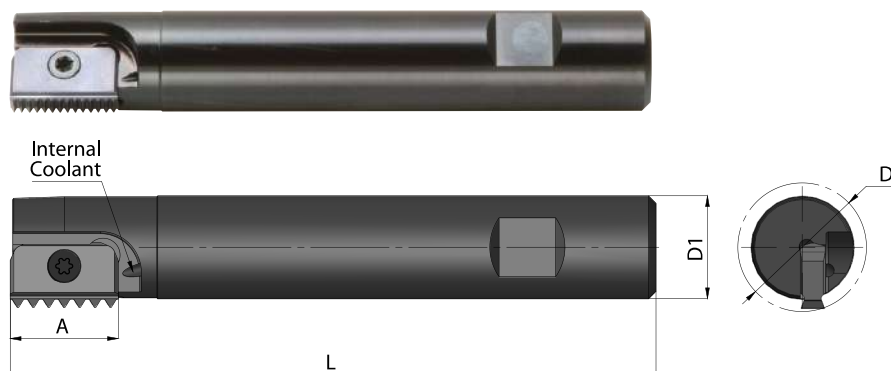


| Ordering Code | A<br>mm | D    | D1   | D2   | L    | L1   | Insert<br>Screw | Torx<br>Key |
|---------------|---------|------|------|------|------|------|-----------------|-------------|
| SR0375H12     | 12      | .37  | .75  | .30  | 3.35 | .51  | S12             | K12         |
| * SR0390H12   | 12      | .39  | .75  | .30  | 3.35 | .51  | S12             | K12         |
| SR0500F14     | 14      | .50  | .75  | .37  | 2.95 | .70  | S14             | K14         |
| SR0540F14     | 14      | .54  | .75  | .38  | 2.98 | .77  | S14             | K14         |
| SR0570H14     | 14      | .57  | .75  | .41  | 3.20 | 1.00 | S14             | K14         |
| SR0670H14     | 14      | .67  | .75  | .53  | 3.35 | 1.18 | S14             | K14         |
| SR0790H21     | 21      | .79  | .75  | .61  | 3.70 | 1.57 | S21             | K21         |
| SR0790K21     | 21      | .79  | .75  | .61  | 5.00 | 2.25 | S21             | K21         |
| SR1140J30     | 30      | 1.14 | 1.00 | .88  | 4.27 | 1.85 | S30             | K30         |
| SR1500P40     | 40      | 1.50 | 1.25 | 1.13 | 7.00 | 4.25 | S40             | K40         |
| SR1500R40     | 40      | 1.50 | 1.25 | 1.13 | 8.00 | 5.25 | S40             | K40         |
| SR1730M40     | 40      | 1.73 | 1.50 | 1.38 | 6.02 | 3.19 | S40             | K40         |

Order example: SR0790H21

\* For conical inserts: 12-18 NPT, 12-18 NPTF, 12-19 BSPT

## Long Shank Toolholders

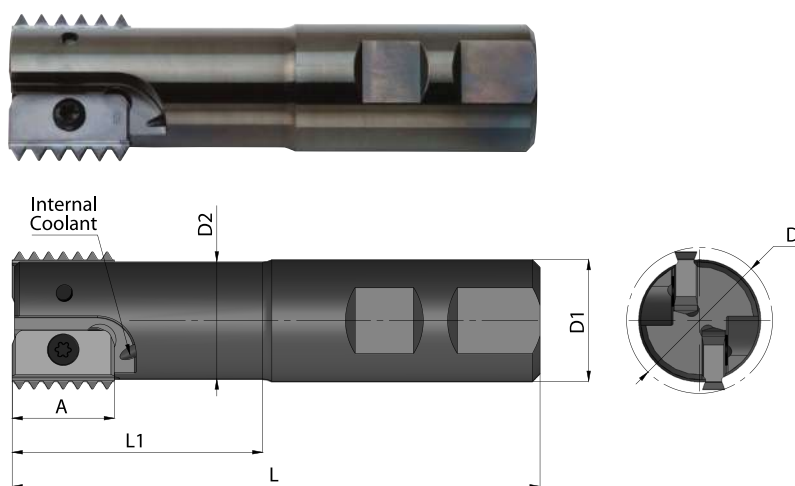


| Ordering Code    | A mm | D    | D1   | L    | Insert Screw | Torx Key |
|------------------|------|------|------|------|--------------|----------|
| <b>SR0940K21</b> | 21   | .94  | .75  | 5.00 | S21          | K21      |
| <b>SR1240M30</b> | 30   | 1.24 | 1.00 | 6.00 | S30          | K30      |
| <b>SR1500M30</b> | 30   | 1.50 | 1.25 | 6.00 | S30          | K30      |

Order example: SR1240M30

For holders with long overhang reduce the cutting speed and feed rate between 20% to 40% (depends on workpiece material, pitch and overhang)

## Twin Insert Toolholders

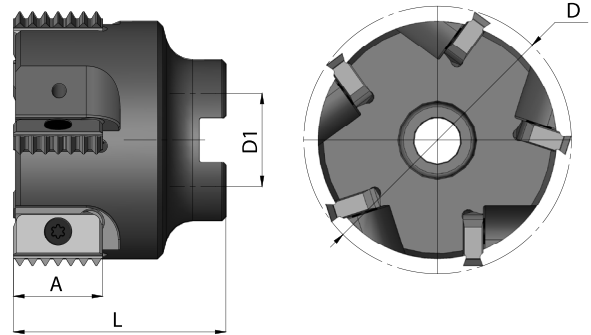


| Ordering Code      | A mm | D    | D1   | D2   | L    | L1   | No. of Inserts | Insert Screw | Torx Key |
|--------------------|------|------|------|------|------|------|----------------|--------------|----------|
| <b>SR0790H14-2</b> | 14   | .79  | .75  | .63  | 3.66 | 1.54 | 2              | S14          | K14      |
| <b>SR1180J21-2</b> | 21   | 1.18 | 1.00 | .95  | 4.25 | 1.97 | 2              | S21          | K21      |
| <b>SR1580L30-2</b> | 30   | 1.57 | 1.25 | 1.18 | 5.12 | 2.80 | 2              | S30          | K30      |
| <b>SR1970M40-2</b> | 40   | 1.97 | 1.50 | 1.49 | 6.02 | 3.35 | 2              | S40          | K40      |

Order example: SR1580L30-2



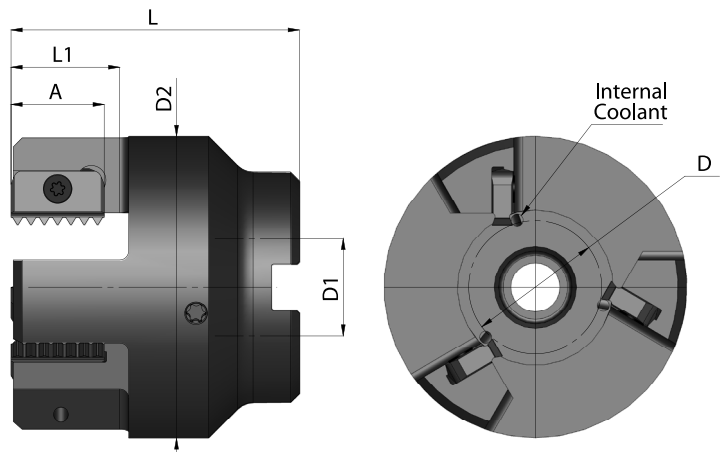
## Multi Insert Toolholders



| Ordering Code | A<br>mm | D    | D1   | L    | No. of<br>Inserts | Insert<br>Screw | Torx<br>Key |
|---------------|---------|------|------|------|-------------------|-----------------|-------------|
| SR2480C21-5   | 21      | 2.48 | .75  | 1.97 | 5                 | S21             | K21         |
| SR2480C30-4   | 30      | 2.48 | .75  | 1.97 | 4                 | S30             | K30         |
| SR3150D30-4   | 30      | 3.15 | 1.00 | 2.16 | 4                 | S30             | K30         |
| SR3940D30-4   | 30      | 3.94 | 1.25 | 2.36 | 4                 | S30             | K30         |
| SR3940D30-8   | 30      | 3.94 | 1.25 | 2.36 | 8                 | S30             | K30         |
| SR3150D40-4   | 40      | 3.15 | 1.00 | 2.56 | 4                 | S40             | K40         |
| SR3940E40-4   | 40      | 3.94 | 1.25 | 2.76 | 4                 | S40             | K40         |
| SR3940E40-6   | 40      | 3.94 | 1.25 | 2.76 | 6                 | S40             | K40         |

Order example: SR3940D30-4

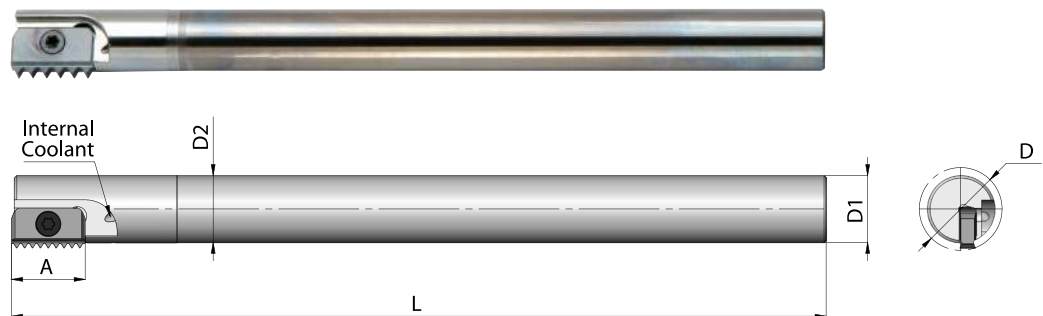
## External Multi Insert Toolholder



| Ordering Code | A<br>mm | D    | D1   | D2   | L    | L1  | No. of<br>Inserts | Insert<br>Screw | Torx<br>Key |
|---------------|---------|------|------|------|------|-----|-------------------|-----------------|-------------|
| SLE0790D21-3  | 21      | .79  | .75  | 2.28 | 2.56 | .95 | 3                 | S21             | K21         |
| SLE1180D21-3  | 21      | 1.18 | .75  | 2.68 | 2.56 | .95 | 3                 | S21             | K21         |
| SLE1770E21-4  | 21      | 1.77 | 1.00 | 3.27 | 2.76 | .95 | 4                 | S21             | K21         |

Order example: SLE1180D21-3

## Long Carbide Shank Toolholders

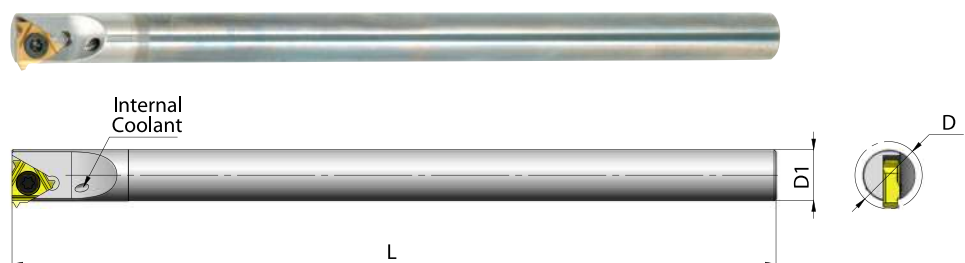


| Ordering Code     | A<br>mm | D    | D1   | D2   | L    | Insert<br>Screw | Torx<br>Key |
|-------------------|---------|------|------|------|------|-----------------|-------------|
| <b>SR0390K12C</b> | 12      | .39  | .312 | .312 | 5.0  | S12             | K12         |
| <b>SR0500J14C</b> | 14      | .50  | .375 | .375 | 6.0  | S14             | K14         |
| <b>SR0620K14C</b> | 14      | .62  | .500 | .500 | 7.0  | S14             | K14         |
| <b>SR0820M21C</b> | 21      | .82  | .625 | .625 | 8.0  | S21             | K21         |
| <b>SR1020S30C</b> | 30      | 1.02 | .750 | .750 | 10.5 | S30             | K30         |

Order example: SR0620 K14C

For holders with long overhang reduce the cutting speed and feed rate between 20% to 40% (depends on workpiece material, pitch and overhang)

## Carbide Shank Toolholders for Single Point Threading



| Ordering Code        | L<br>mm | Pitch Range |       | D   | D1  | L   | Insert<br>Screw | Torx<br>Key |
|----------------------|---------|-------------|-------|-----|-----|-----|-----------------|-------------|
|                      |         | mm          | TPI   |     |     |     |                 |             |
| <b>* SR0250H08C</b>  | 08      | 0.5-1.75    | 48-14 | .35 | .25 | 4.0 | S08             | K08         |
| <b>** SR0375M11C</b> | 11      | 0.5-2.00    | 48-11 | .50 | .38 | 6.0 | S11             | K11         |

For Inserts see the Thread Turning Tools section of this Catalog.

For an internal application use an internal R.H. insert.

\* Without coolant bore

\*\* For an external application use an external L.H. insert.