

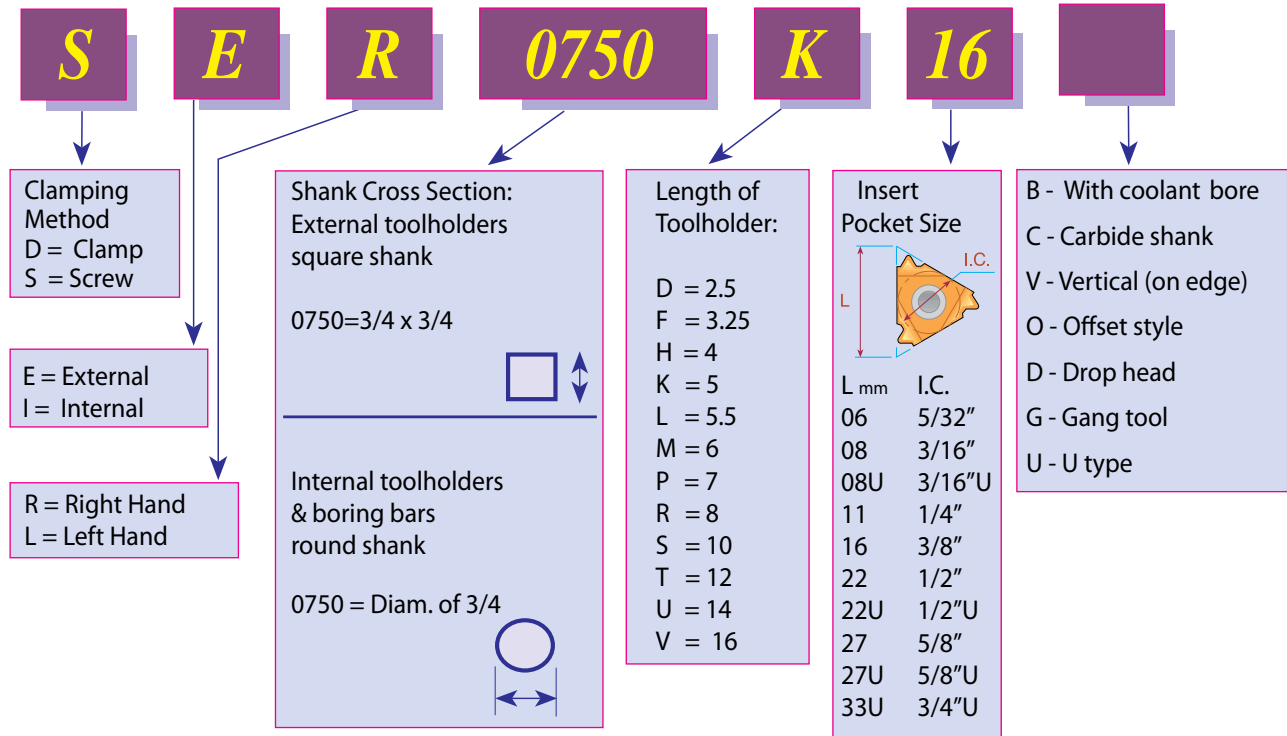
Thread Turning Toolholders and Kits



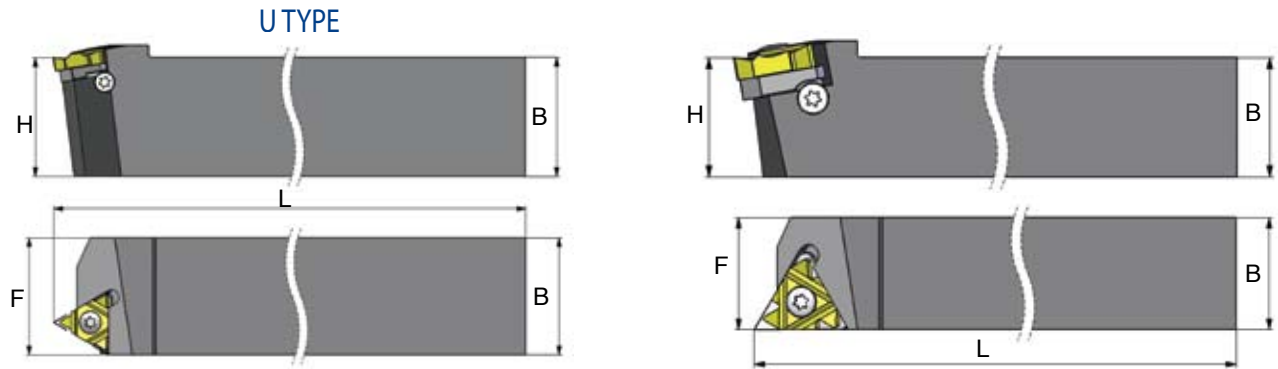
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Product Identification

Threading Toolholders Ordering Codes



External Toolholders



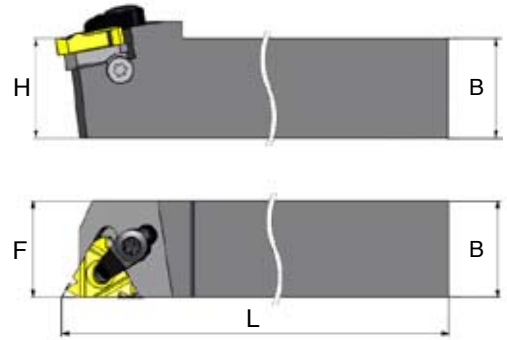
Ordering Code Right Hand	 L mm	B=H	L	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SER 0310 H11	11	.31	4.00	.43	S11	-	K11	-	-
*SER 0375 H11	11	.38	4.00	.43	S11	-	K11	-	-
SER 0375 D16	16	.38	2.50	.63	S16	A16	K16	AE16	AI16
SER 0500 F16	16	.50	3.25	.63	S16	A16	K16	AE16	AI16
SER 0625 H16	16	.63	4.00	.63	S16	A16	K16	AE16	AI16
SER 0750 K16	16	.75	5.00	.75	S16	A16	K16	AE16	AI16
SER 1000 M16	16	1.00	6.00	1.00	S16	A16	K16	AE16	AI16
SER 1250 P16	16	1.25	7.00	1.25	S16	A16	K16	AE16	AI16
SER 1000 M22	22	1.00	6.00	1.00	S22	A22	K22	AE22	AI22
SER 1250 P22	22	1.25	7.00	1.25	S22	A22	K22	AE22	AI22
SER 1500 R22	22	1.50	8.00	1.50	S22	A22	K22	AE22	AI22
SER 1000 M22U	22U	1.00	6.00	1.10	S22	A22	K22	AE22U	AI22U
SER 1250 P22U	22U	1.25	7.00	1.25	S22	A22	K22	AE22U	AI22U
SER 1500 R22U	22U	1.50	8.00	1.50	S22	A22	K22	AE22U	AI22U
SER 1000 M27	27	1.00	6.00	1.25	S27	A27	K27	AE27	AI27
SER 1250 P27	27	1.25	7.00	1.25	S27	A27	K27	AE27	AI27
SER 1500 R27	27	1.50	8.00	1.50	S27	A27	K27	AE27	AI27
SER 1000 M27U	27U	1.00	6.00	1.25	S27	A27	K27	AE27U	AI27U
SER 1250 P27U	27U	1.25	7.00	1.25	S27	A27	K27	AE27U	AI27U
SER 1500 R27U	27U	1.50	8.00	1.50	S27	A27	K27	AE27U	AI27U
SER 1000 M33U	33U	1.00	6.00	1.45	S33	-	K33	-	-
SER 1250 P33U	33U	1.25	7.00	1.45	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 consult helix angle chart (page 60) in the technical section of this catalogue.

External toolholders with top clamp



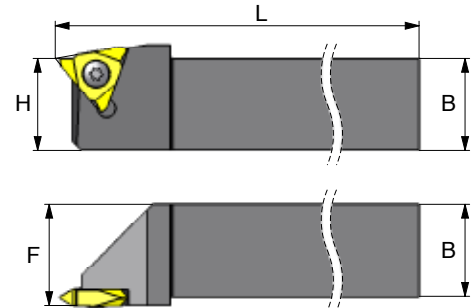
Ordering Code Right Hand	 L mm	B=H	L	F	Insert Screw	Clamp	Anvil Screw	Torx Key	RH Anvil	LH Anvil
DER 0750 K16	16	.75	5.0	.75	S16	C16	A16S	K16	AE16	AI16
DER 1000 M16	16	1.00	6.0	1.00	S16	C16	A16S	K16	AE16	AI16
*DER 1000 M22	22	1.00	6.0	1.00	S22	C22	A22	K22	AE22	AI22


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

Toolholders are made with a **1.5° Helix Angle**. For other Helix Angles please consult helix angle chart in the technical section of this catalogue. Two clamping methods can be used: screw or top clamp.

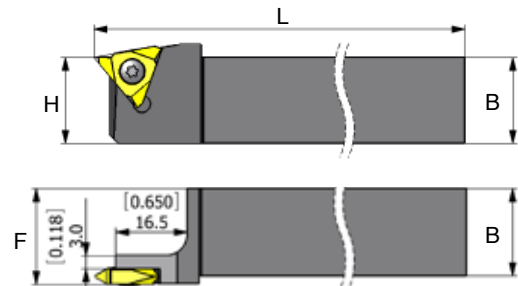
*Use K21 torx key for C22 clamp


Vertical toolholders



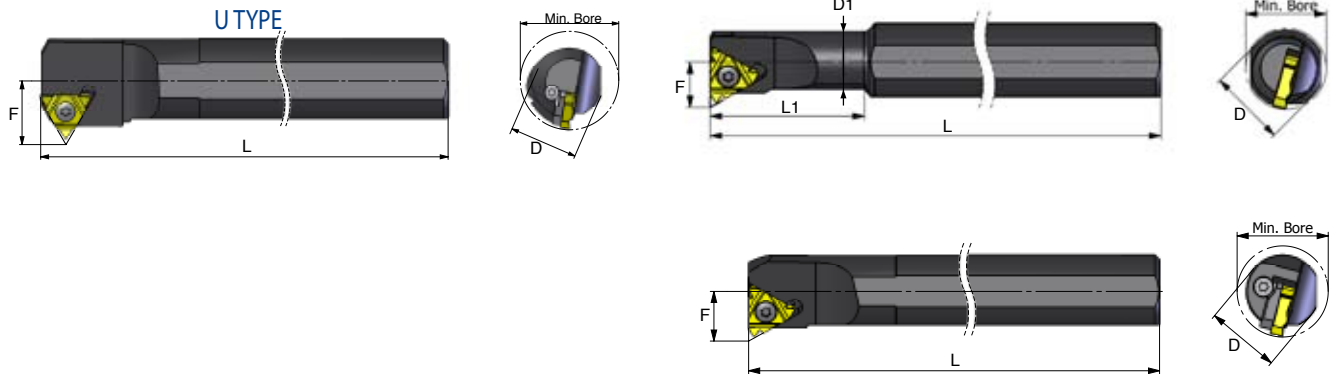
Ordering Code Right Hand	 mm	B=H	L	F	Insert Screw	Torx Key
SER 0750 K16V	16	.75	5.0	.87	S16S	K16
SER 1000 M16V	16	1.00	6.0	1.06	S16S	K16
SER 1000 M22V	22	1.00	6.0	1.08	S22S	K22
SER 1000 M27V-T10	27	1.00	6.0	1.42	S27	K27
SER 1000 M27V-ABUT 4/3-T10	27	1.00	6.0	1.42	S27	K27
SER 1250 P27V-T10	27	1.25	7.0	1.42	S27	K27
SER 1250 P27V-ABUT 4/3-T10	27	1.25	7.0	1.42	S27	K27


Slim Throat toolholders



Ordering Code Right Hand	 mm	B=H	L	F	Insert Screw	Torx Key
SER 0625 H16VS	16	0.63	4.0	0.71	S16S	K16
SER 0750 H16VS	16	0.75	5.0	0.87	S16S	K16
SER 1000 M16VS	16	1.00	6.0	1.06	S16S	K16

Internal Toolholders



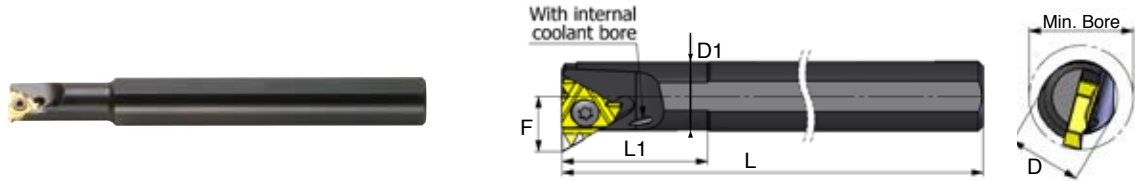
Ordering Code Right Hand	 L mm	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SIR 0205 H06	6	.50	.20	.24	4.0	.47	.17	S06	-	K06	-	-
*SIR 0265 K08	8	.62	.26	.31	5.0	.70	.21	S08	-	K08	-	-
*SIR 0310 K08U	8U	.62	.29	.35	5.0	.83	.26	S08	-	K08	-	-
*SIR 0375 H11	11	.38	.38	.47	4.0	-	.28	S11	-	K11	-	-
*SIR 0375 K11	11	.62	.38	.47	5.0	1.00	.28	S11	-	K11	-	-
*SIR 0500 L11	11	.62	.50	.58	5.5	1.25	.34	S11	-	K11	-	-
*SIR 0500 M16	16	.62	.50	.64	6.0	1.25	.39	S16S	-	K16	-	-
*SIR 0625 P16	16	.75	.62	.75	7.0	1.57	.45	S16S	-	K16	-	-
SIR 0750 P16	16	.75	.75	.90	7.0	-	.51	S16	A16	K16	AI16	AE16
SIR 1000 R16	16	1.00	1.00	1.16	8.0	-	.65	S16	A16	K16	AI16	AE16
SIR 1250 S16	16	1.25	1.25	1.40	10.0	-	.77	S16	A16	K16	AI16	AE16
SIR 1500 T16	16	1.50	1.50	1.65	12.0	-	.90	S16	A16	K16	AI16	AE16
*SIR 0750 P22	22	.75	.75	.90	7.0	-	.59	S22S	-	K22	-	-
SIR 1000 R22	22	1.00	1.00	1.16	8.0	-	.71	S22	A22	K22	AI22	AE22
SIR 1250 S22	22	1.25	1.25	1.50	10.0	-	.85	S22	A22	K22	AI22	AE22
SIR 1500 T22	22	1.50	1.50	1.75	12.0	-	.98	S22	A22	K22	AI22	AE22
SIR 1250 S22U	22U	1.25	1.25	1.50	10.0	-	.95	S22	A22	K22	AI22U	AE22U
SIR 1500 T22U	22U	1.50	1.50	1.75	12.0	-	1.08	S22	A22	K22	AI22U	AE22U
SIR 1250 S27	27	1.25	1.25	1.56	10.0	-	.88	S27	A27	K27	AI27	AE27
SIR 1500 T27	27	1.50	1.50	1.80	12.0	-	1.00	S27	A27	K27	AI27	AE27
SIR 2000 U27	27	2.00	2.00	2.30	14.0	-	1.25	S27	A27	K27	AI27	AE27
SIR 2500 V27	27	2.50	2.50	2.80	16.0	-	1.50	S27	A27	K27	AI27	AE27
SIR 1250 S27U	27U	1.25	1.25	1.56	10.0	-	1.00	S27	A27	K27	AI27U	AE27U
SIR 1500 T27U	27U	1.50	1.50	1.80	12.0	-	1.13	S27	A27	K27	AI27U	AE27U
SIR 2000 U27U	27U	2.00	2.00	2.30	14.0	-	1.37	S27	A27	K27	AI27U	AE27U
SIR 2500 V27U	27U	2.50	2.50	2.80	16.0	-	1.61	S27	A27	K27	AI27U	AE27U
*SIR 2000 U33U	33U	2.00	2.00	2.50	14.0	-	1.50	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 consult helix angle chart (page 60) in the technical section of this catalogue.

Internal toolholders with coolant bore



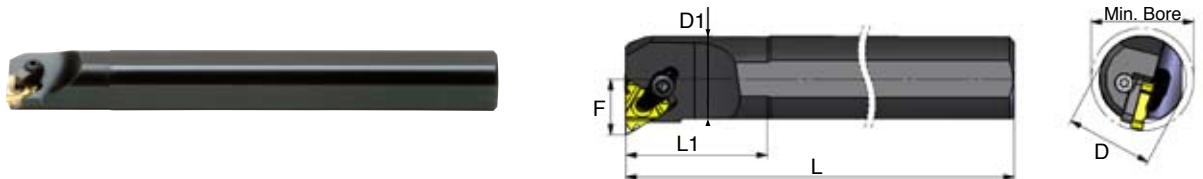
Ordering Code Right Hand	 L mm	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SIR 0375 K11B	11	.62	.38	.47	5.0	.98	.28	S11	-	K11	-	-
*SIR 0500 M16B	16	.62	.50	.64	6.0	1.26	.39	S16S	-	K16	-	-
*SIR 0625 P16B	16	.75	.63	.75	7.0	1.57	.45	S16S	-	K16	-	-
SIR 0750 P16B	16	.75	.75	.90	7.0	-	.90	S16	A16	K16	AI16	AE16
SIR 1000 R16B	16	1.00	1.00	1.16	8.0	-	.65	S16	A16	K16	AI16	AE16
SIR 1000 R22B	22	1.00	1.00	1.16	8.0	-	.71	S22	A22	K22	AI22	AE22


*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 consult helix angle chart (page 60) in the technical section of this catalogue.

Internal toolholders with top clamp




Ordering Code Right Hand	 L mm	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Clamp	Anvil Screw	Torx Key	RH Anvil	LH Anvil
DIR 0750 P16	16	.75	.75	.90	7.0	-	.51	S16	C16	A16S	K16	AI16	AE16
DIR 1000 R16	16	1.00	1.00	1.16	8.0	-	.65	S16	C16	A16S	K16	AI16	AE16
DIR 1250 S16	16	1.25	1.25	1.40	10.0	-	.77	S16	C16	A16S	K16	AI16	AE16
*DIR 1000 R22	22	1.00	1.00	1.16	8.0	-	.71	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

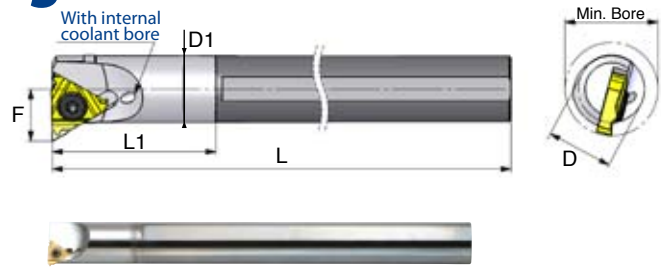
Toolholders with 3.5° Helix Angle

Ordering Code Right Hand	 L mm	D mm	D1 mm	Min Bore Diam. mm	L mm	L1 mm	F mm	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

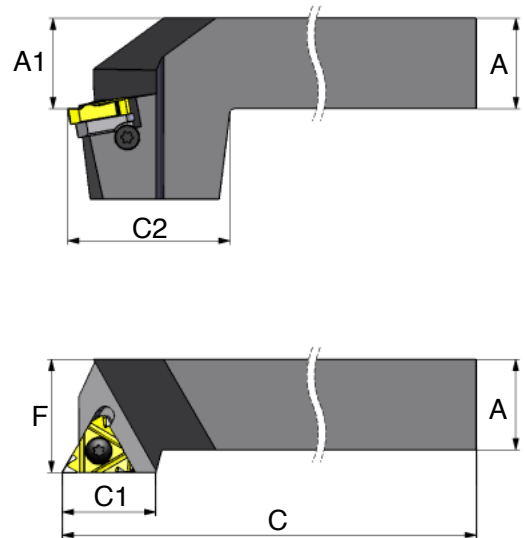
Carbide Shank Threading Bars are used when Chatter and deflection are expected due to long overhang in deep small bores.



Ordering Code Right Hand	L mm	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SIR 0205 H06CB	6	.25	.20	.24	4.0	1.02	.17	S06	-	K06	-	-
SIR 0265 K08CB	8	.31	.26	.31	5.0	1.22	.21	S08	-	K08	-	-
SIR 0310K08UCB	8U	.31	.29	.35	5.0	1.38	.26	S08	-	K08	-	-
SIR 0375 M11CB	11	.38	.38	.47	6.0	-	.28	S11	-	K11	-	-
SIR 0500 P11CB	11	.50	.50	.58	7.0	-	.34	S11	-	K11	-	-
SIR 0500 P16CB	16	.50	.50	.64	7.0	-	.40	S16S	-	K16	-	-
SIR 0625 R16CB	16	.62	.62	.75	8.0	-	.46	S16S	-	K16	-	-
*SIR 0750 S16CB	16	.75	.75	.90	10.0	-	.54	S16	A16	K16	AI16	AE16
*SIR 1000 S16CB	16	1.00	1.00	1.10	10.0	-	.64	S16	A16	K16	AI16	AE16

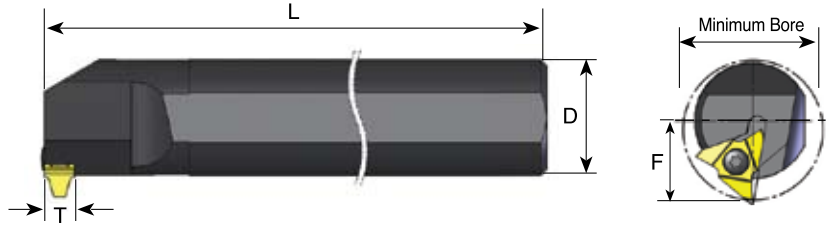
*Carbide shank Threading bars with anvil
For **LEFT HAND** toolholders specify **SIL** instead of **SIR**


Drophead Toolholders



Ordering Code Right Hand	L mm	A	A1	C	C1	F	C2	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SER 0750 K16D	16	.75	.75	5.0	.84	1.00	1.5	S16	A16	K16	AE16	AI16
SER 1000 M16D	16	1.00	1.00	6.0	.84	1.25	1.5	S16	A16	K16	AE16	AI16
SER 1000 M22D	22	1.00	1.00	6.0	1.00	1.25	1.5	S22	A22	K22	AE22	AI22

Vertical Toolholders

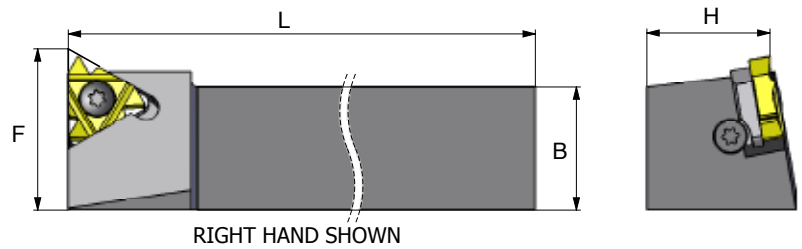
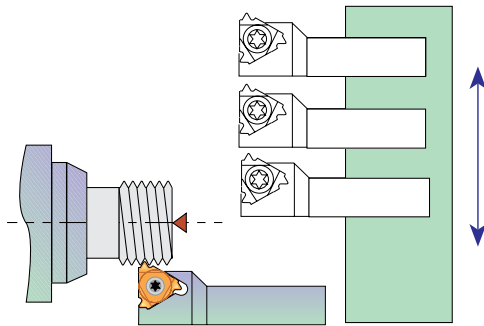



Ordering Code Right Hand	 L	D	Min Bore Diam.	L	F	T	Insert Screw	Torx Key
SIR 1250 S27V-T10	27	1.25	1.65	10	0.94	0.41	S27	K27
SIR 1500 T27V-T10	27	1.5	1.80	12	1.05	0.41	S27	K27
SIR 2000 U27V-T10	27	2.0	2.32	14	1.31	0.41	S27	K27
SIR 2500 V27V-T10	27	2.5	2.85	16	1.51	0.41	S27	K27

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

Gang Toolholders

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



Ordering Code Right Hand	 L mm	B=H mm	L mm	F mm	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**

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 UN Kit Ordering Code:KEU

INSERTS

16 ER A60 P25C
 16 ER G60 P25C
 16 ER AG60 P25C
 16 ER 8 UN P25C
 16 ER 12 UN P25C
 16 ER 14 UN P25C
 16 ER 16 UN P25C
 16 ER 18 UN P25C
 16 ER 20 UN P25C
 16 ER 24 UN P25C

TOOLHOLDERS

SER 0750 K16
 KEY
 K16
 SCREW
 S16

Internal UN Kit Ordering Code:KIU

INSERTS

16 IR A60 P25C
 16 IR G60 P25C
 16 IR AG60 P25C
 16 IR 8 UN P25C
 16 IR 12 UN P25C
 16 IR 14 UN P25C
 16 IR 16 UN P25C
 16 IR 18 UN P25C
 16 IR 20 UN P25C
 16 IR 24 UN P25C

TOOLHOLDERS

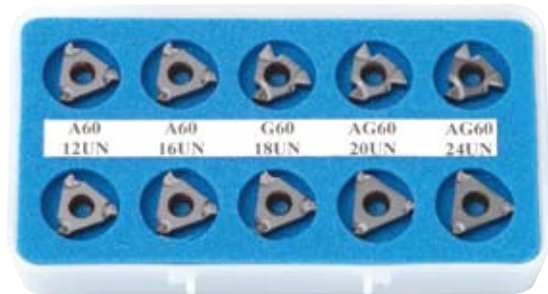
SIR 0750 K16
 KEY
 K16
 SCREW
 S16



If a larger toolholders with a 1.0 inch shank is required, add to the kit 1.0. For example: KIU - 1.0

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 UN KIT KEUB - BMA

16 ER B A60 BMA-2 Pcs
 16 ER B G60 BMA-1 Pcs
 16 ER B AG60 BMA-2 Pcs
 16 ER B 12 UN BMA-1 Pcs
 16 ER B 16 UN BMA-1 Pcs
 16 ER B 18 UN BMA-1 Pcs
 16 ER B 20 UN BMA-1 Pcs
 16 ER B 24 UN BMA-1 Pcs



EX-RH

INTERNAL UN KIT KIUB - BMA

16 IR B A60 BMA-2 Pcs
 16 IR B G60 BMA-1 Pcs
 16 IR B AG60 BMA-2 Pcs
 16 IR B 12 UN BMA-1 Pcs
 16 IR B 16 UN BMA-1 Pcs
 16 IR B 18 UN BMA-1 Pcs
 16 IR B 20 UN BMA-1 Pcs
 16 IR B 24 UN BMA-1 Pcs



IN-RH

Miniature & Ultra-miniature Kits



Ordering Code	Type	No. of Inserts	Inserts	Contents Boring Bar	Key
KU60I - BXC	ULTRA	10	06 IR A60 BXC	SIR 0205 H06	K6
KM60I - BXC	MINI	10	08 IR A60 BXC	SIR 0265 K08	K8

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

1/4" diameter

with just one deep reaching

CARBIDE shank ultra mini Boring Bar.



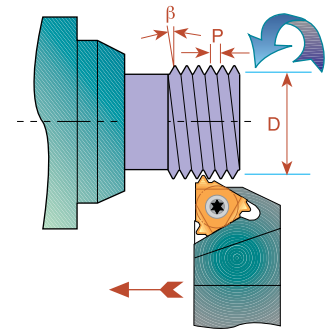
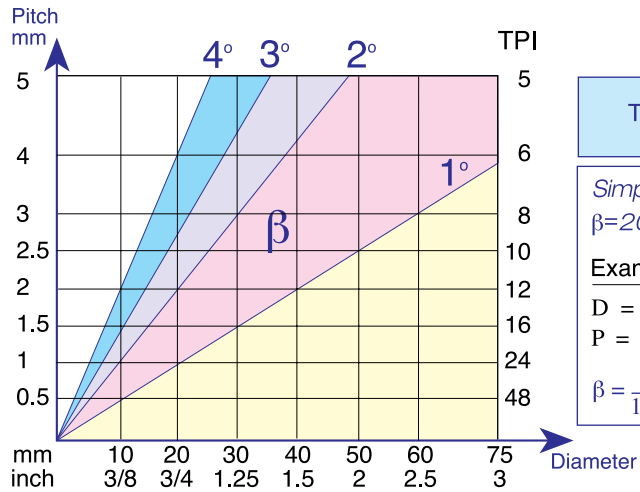
Ordering Code	Contents			Key
	Threading Insert	Turning Inserts	Boring Bar	
KC6TI	06 IR A60 BXC 10Pcs	06 IR TURN BMA 10Pcs	SIR 0205 H06CB	K6

BMA - Coated carbide grade for medium to high cutting speeds

BXC - Coated carbide grade for low cutting speed - 130 to 300 ft/min

CB - Carbide shank boring bar with coolant bore

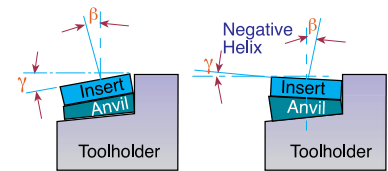
Thread Helix Angle



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 mm	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.)



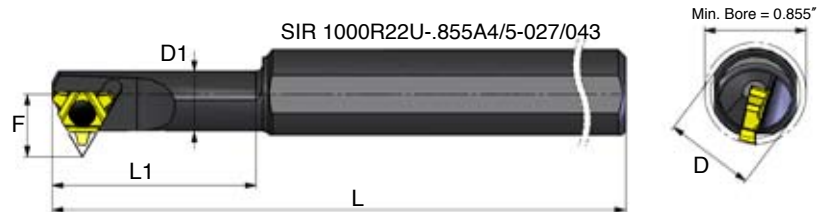
AI (FOR IN.RH. & EX.LH.)

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


Special Thread Turning Applications



*TO BE USED WITH CARMEX STANDARD 22UJRL4ACME



*TO BE USED WITH CARMEX SPECIAL INSERT 22UJRL4ACMESPEC-027/022MXC & 22UJRL5ACMESPEC-027/015MXC

Ordering Code Right Hand		D	D1	L	L1	F	Thread	Insert Screw	Torx Key
*SIR 0354 K08	8	0.63	0.34	5	1.18	0.25	1/2 - 13UNC	S08	K08
SIR 1000 R22U-0.98A4-027/219	22U	1.00	0.79	8	2.75	0.72	—	S22	K22
SIR 1000 R22U-855A4/5-027/043	22U	1.00	0.67	8	2.00	0.70	—	S22	K22

For LH holders call carmex

* Only right hand available