

# Thread Turning Toolholders and Kits

# A02

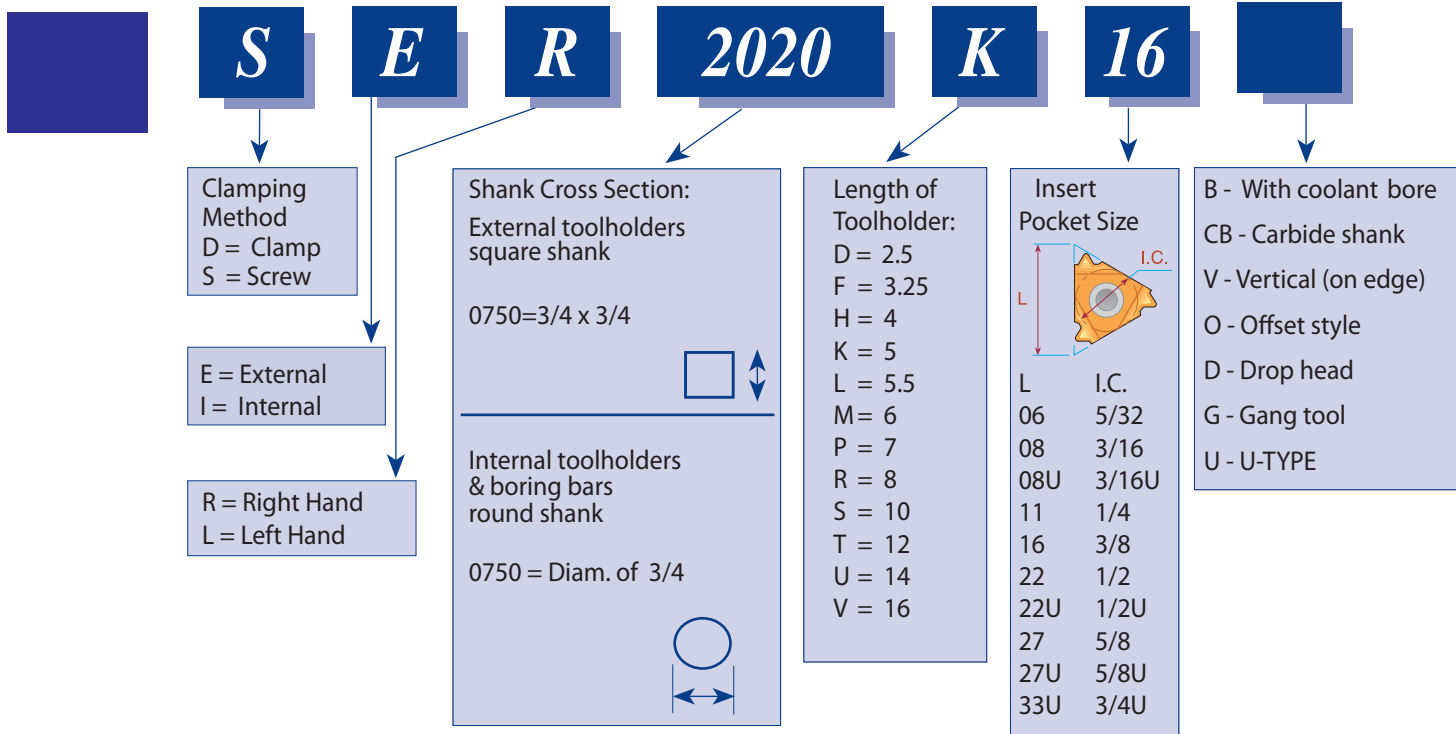


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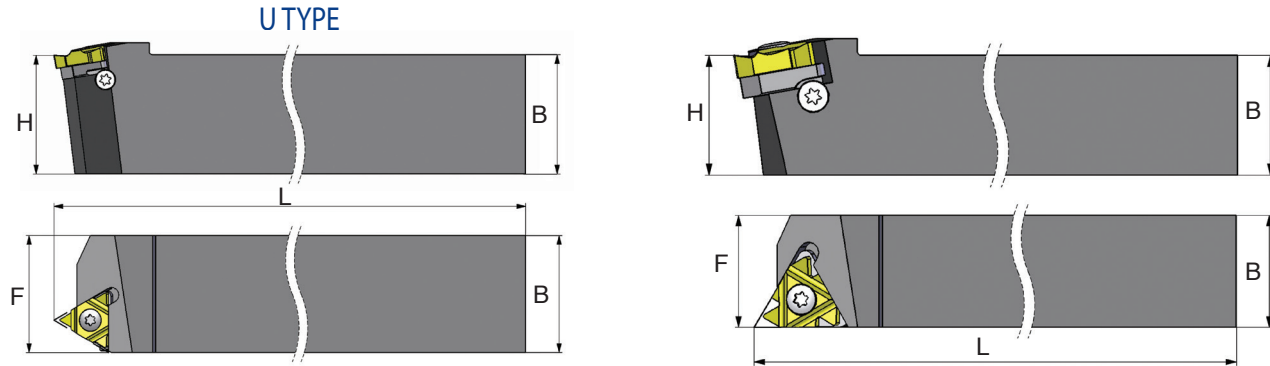
## Product Identification


### Threading Toolholders Ordering Codes



# Thread Turning Toolholders

## External Toolholders



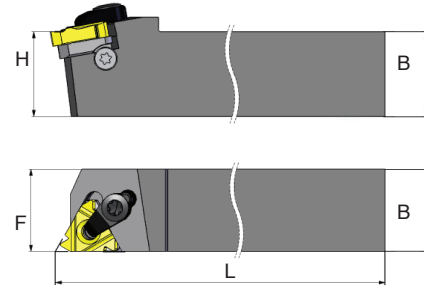
Ordering Code Right Hand	 L mm	B=H	L	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SER 0310 H11	11	.31	4.00	.43	S11	-	K11	-	-
*SER 0375 H11	11	.38	4.00	.43	S11	-	K11	-	-
*SER 0375 M11	11	.38	6.00	.43	S11	-	K11	-	-
*SER 0500 K11	11	.50	5.00	.50	S11	-	K11	-	-
*SER 0500 M11	11	.50	6.00	.50	S11	-	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 see helix angle chart (page A04-7) in the technical section of this catalog

## External toolholders with top clamp



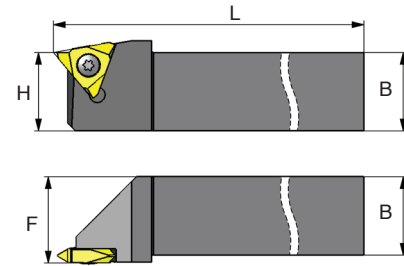
Ordering Code Right Hand	 L mm	B=H	L	F	Insert Screw	Clamp	Anvil Screw	Torx Key	RH Anvil	LH Anvil
<b>DER 0500 H16</b>	16	.50	4.0	.63	S16	C16	A16S	K16	AE16	AI16
<b>DER 0625 H16</b>	16	.63	4.0	.63	S16	C16	A16S	K16	AE16	AI16
<b>DER 0750 K16</b>	16	.75	5.0	.75	S16	C16	A16S	K16	AE16	AI16
<b>DER 1000 M16</b>	16	1.00	6.0	1.00	S16	C16	A16S	K16	AE16	AI16
<b>*DER 1000 M22</b>	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 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



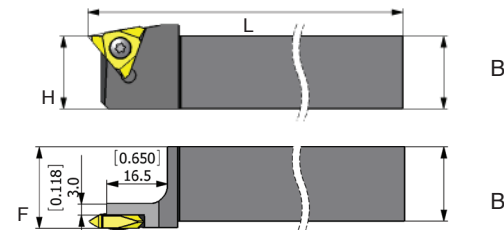
## Vertical toolholders




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

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

## Slim Throat toolholders

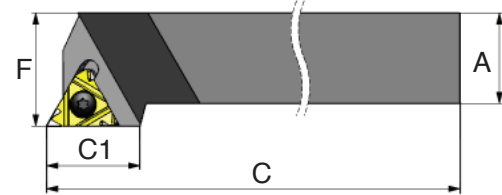
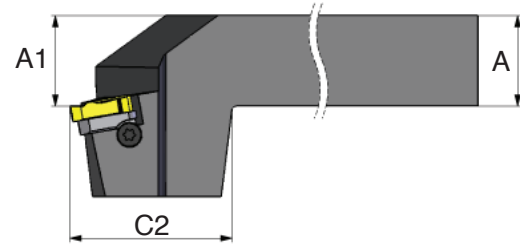
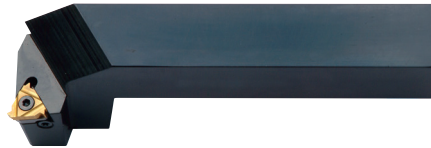


Ordering Code Right Hand	 mm	B=H	L	F	Insert Screw	Torx Key
<b>SER 0625 H16VS</b>	16	.63	4.0	.71	S16S	K16
<b>SER 0750 K16VS</b>	16	.75	5.0	.87	S16S	K16
<b>SER 1000 M16VS</b>	16	1.00	6.0	1.06	S16S	K16
<b>SER 1000 M22VS</b>	22	1.00	6.0	1.06	S22S	K22

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

# Thread Turning Toolholders

## Drophead Toolholders

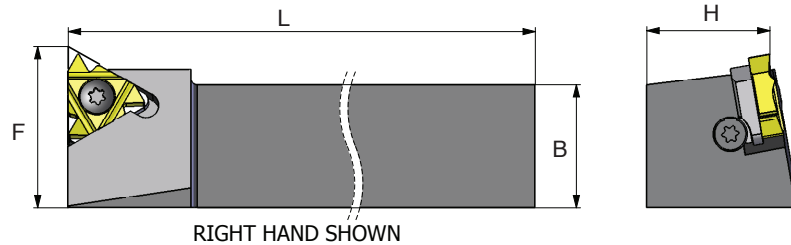
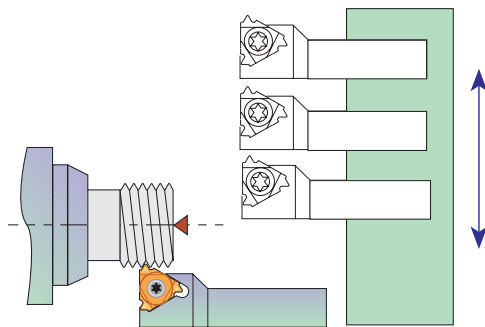


Ordering Code Right Hand	L mm	A	A1	C	C1	F	C2	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
<b>SER 0750 K16D</b>	16	.75	.75	5.0	.84	1.00	1.5	S16	A16	K16	AE16	AI16
<b>SER 1000 M16D</b>	16	1.00	1.00	6.0	.84	1.25	1.5	S16	A16	K16	AE16	AI16
<b>SER 1000 M22D</b>	22	1.00	1.00	6.0	1.00	1.25	1.5	S22	A22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

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

## Gang Toolholders

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



RIGHT HAND SHOWN



Ordering Code Right Hand	L mm	B=H mm	L	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
<b>*SER 8 8 H11G</b>	11	8	3.9	.47	S11	-	K11	-	-
<b>*SER 10 10 H11G</b>	11	10	3.9	.55	S11	-	K11	-	-
<b>SER 16 16 K16G</b>	16	16	4.9	.85	S16	A16	K16	AE16	AI16
<b>SER 20 20 K16G</b>	16	20	4.9	1.03	S16	A16	K16	AE16	AI16

\*Toolholders with no anvil

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



## *x-tream Jet*

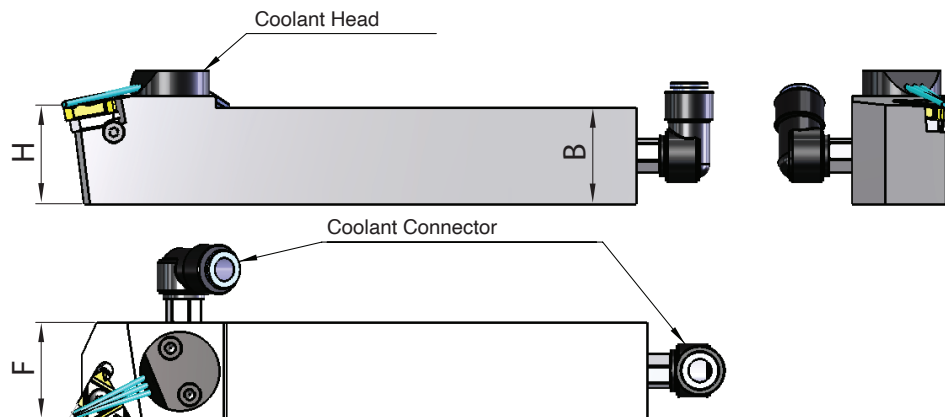
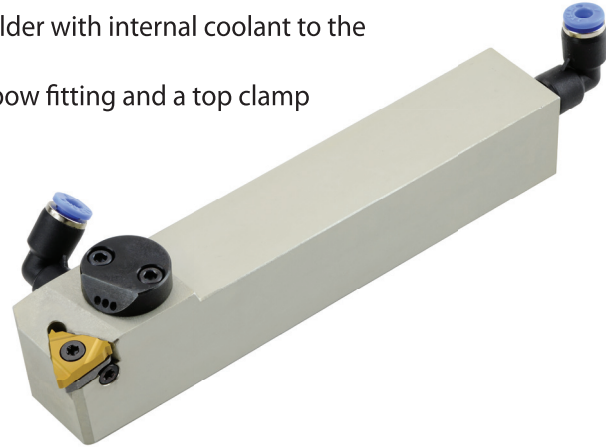
### External Toolholder with Internal Coolant


Carmex has developed a unique external thread turning holder with internal coolant to the cutting edge.

The holder includes two connecting options through an elbow fitting and a top clamp directing the coolant flow to the cutting edge.

#### The coolant flow provides:

- Better chip control, and chip flow
- Longer tool life and high performance
- Reduces the cutting edge temperature
- Available RH and LH tool holders
- Coated holders provide abrasive resistance



Ordering Code	 L mm	B=H	L	F	Torx + Insert Screw	Torx + Anvil Screw	Torx + Key	RH Anvil	LH Anvil	Coolant* Connector mm
<b>SER 0625 H16B</b>	16	.63	4.0	.63	S16P	A16P	K16P	AE16	AI16	Ø4 / Ø6
<b>SER 0750 K16B</b>	16	.75	5.0	.75	S16P	A16P	K16P	AE16	AI16	Ø4 / Ø6
<b>SER 1000 M16B</b>	16	1.00	6.0	1.00	S16P	A16P	K16P	AE16	AI16	Ø4 / Ø6
<b>SER 1000 M22B</b>	22	1.00	6.0	1.00	S22P	A22P	K22P	AE22	AI16	Ø4 / Ø6
<b>SER 1000 M27B</b>	27	1.00	6.0	1.25	S27P	A27P	K27P	AE27	AI27	Ø4 / Ø6
<b>SER 1250 P16B</b>	16	1.25	7.0	1.25	S16P	A16P	K16P	AE16	AI16	Ø4 / Ø6
<b>SER 1250 P22B</b>	22	1.25	7.0	1.25	S22P	A22P	K22P	AE22	AI22	Ø4 / Ø6
<b>SER 1250 P27B</b>	27	1.25	7.0	1.25	S27P	A27P	K27P	AE27	AI27	Ø4 / Ø6

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

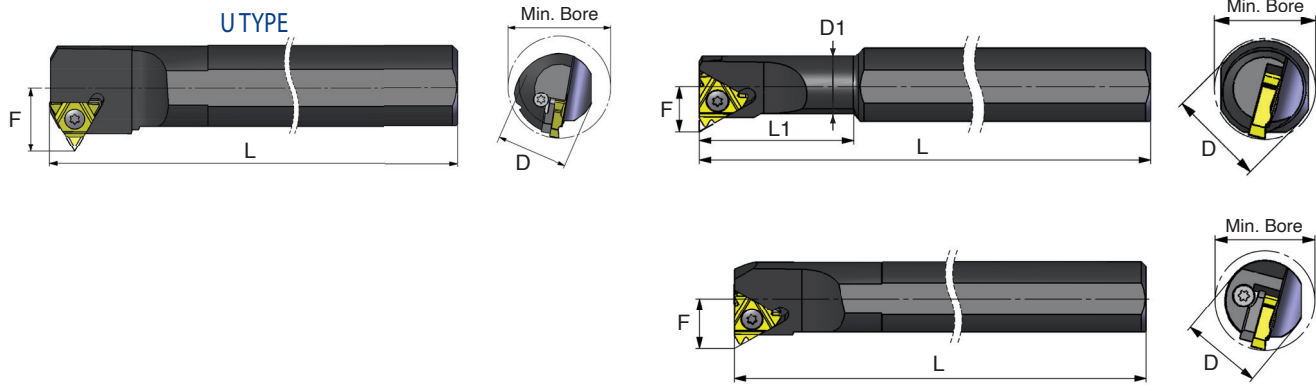
Toolholders made with 1.5° helix angle


Please consult the helix angle chart page A04-7 in the technical section of this catalog

\* Standard packing with Ø6 mm

# Thread Turning Toolholders

## 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 2000 U16	16	2.00	2.00	2.30	14.0	-	1.20	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 2000 U22	22	2.00	2.00	2.25	14.0	-	1.25	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	-	-

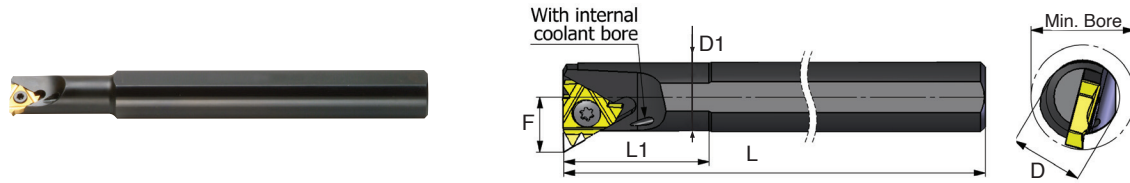
\*Toolholders with no anvil


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 A04-7) in the technical section of this catalog.

For "U" type inserts Tr,Acme,Stub Acme, see our software or contact main office for holder use.

## Internal toolholders with Coolant Bore



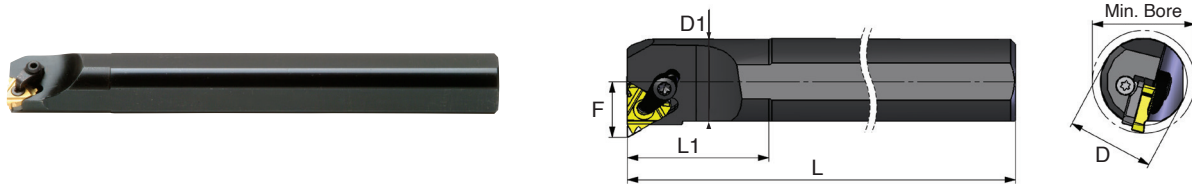
Ordering Code Right Hand	 L mm	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SIR 0375 K11B	11	.62	.38	.47	5.0	.98	.28	S11	-	K11	-	-
*SIR 0500 M16B	16	.62	.50	.64	6.0	1.26	.39	S16S	-	K16	-	-
*SIR 0625 P16B	16	.75	.63	.75	7.0	1.57	.45	S16S	-	K16	-	-
SIR 0750 P16B	16	.75	.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
SIR 1225 S16B	16	1.25	1.25	1.4	10.0	-	.77	S16	A16	K16	AI16	AE16


\*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 A04-7) in the technical section of this catalog.

## 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	Min Bore Diam.	L	L1	F	Insert Screw	Torx Key
SIR 0016 P16B-3.5	16	20	.630	.748	6.7	1.58	.540	S16S	K16
SIR 0020 P22B-3.5	22	20	.787	.945	6.7	-	.614	S22S	K22

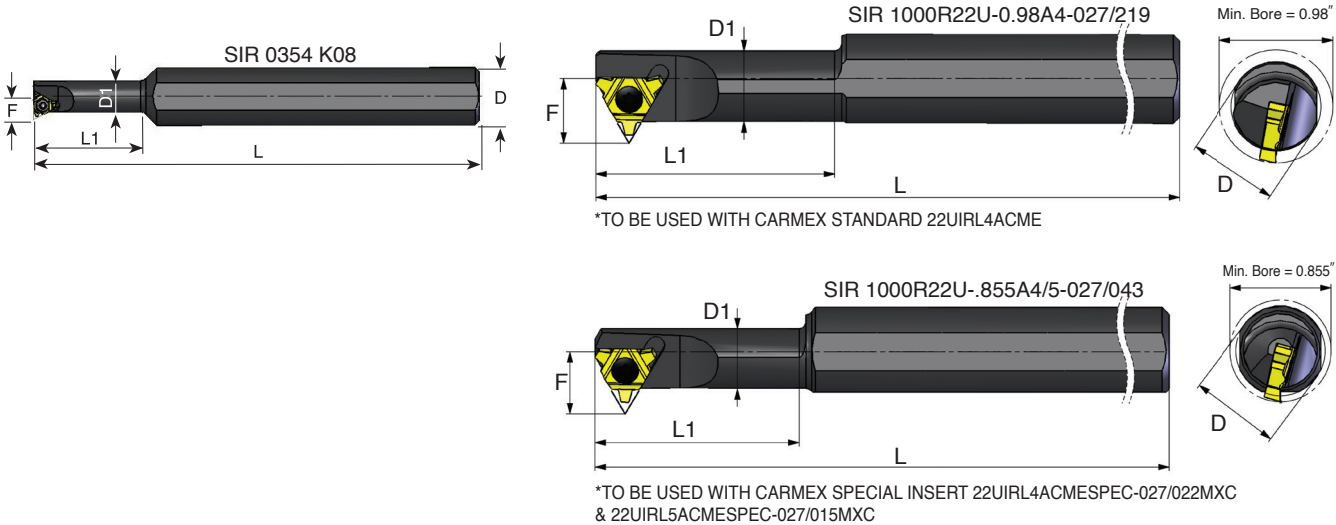
For **LEFT HAND** toolholders specify **SIL** instead of **SIR**




# Thread Turning Toolholders



## Special Thread Turning Applications



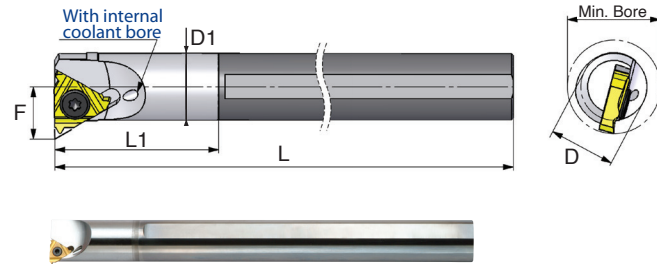
Ordering Code Right Hand	 mm	D	D1	L	L1	F	Thread	Insert Screw	Torx Key
<b>*SIR 0354 K08</b>	8	.63	.34	5.0	1.18	.25	<b>1/2 - 13UNC</b>	S08	K08
<b>SIR 1000 R22U-0.98A4-027/219</b>	22U	1.00	.79	8.0	2.75	.72	—	S22	K22
<b>SIR 1000 R22U-855A4/5-027/043</b>	22U	1.00	.67	8.0	2.00	.70	—	S22	K22


For LH holders call Carmex  
 \* Only right hand available



## 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.



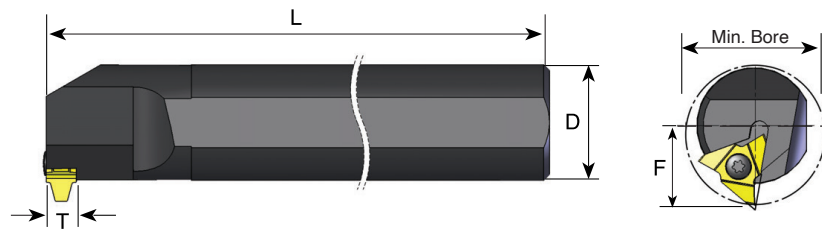
Ordering Code Right Hand	 L mm	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SIR 0205 H06CB	6	.25	.20	.24	4.0	1.02	.17	S06	-	K06	-	-
SIR 0265 K08CB	8	.31	.26	.31	5.0	1.22	.21	S08	-	K08	-	-
SIR 0310K08UCB	8U	.31	.29	.35	5.0	1.38	.26	S08	-	K08	-	-
SIR 0375 M11CB	11	.38	.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
SIR 0750 S22CB	22	.75	.76	.95	10.0	4.00	.61	S22	-	K22	-	-


\* Carbide shank Threading bars with anvil

\*\* Helix angle: 3.5°

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

## Vertical Toolholders



Ordering Code Right Hand	 L mm	D	* Min Bore Diam.	L	F	T	Insert Screw	Torx Key
SIR 1250 S27V-T10	27	1.25	1.65	10	.94	.41	S27	K27
SIR 1500 T27V-T10	27	1.5	1.80	12	1.05	.41	S27	K27
SIR 2000 U27V-T10	27	2.0	2.32	14	1.31	.41	S27	K27
SIR 2500 V27V-T10	27	2.5	2.85	16	1.51	.41	S27	K27

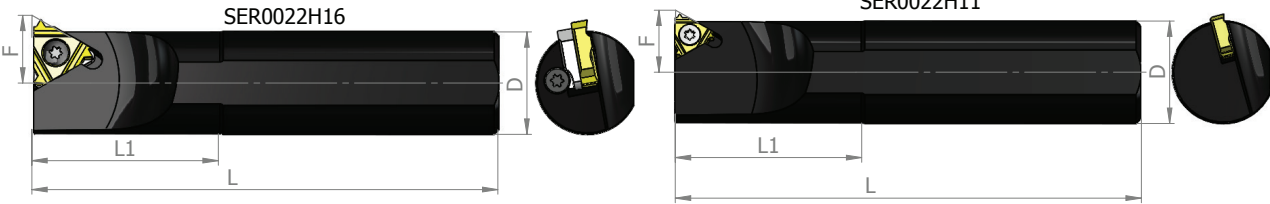
\* To be compared with given minimum bore profile.


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

# Thread Turning Toolholders



## Star Toolholders



Ordering Code Right Hand	 L	D mm	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
<b>SER 0022 H11</b>	11	22	3.94	1.57	.52	S11	-	K11	-	-
<b>SER 0022 H16</b>	16	22	3.94	1.57	.52	S16	A16	K16	AE16	AI16

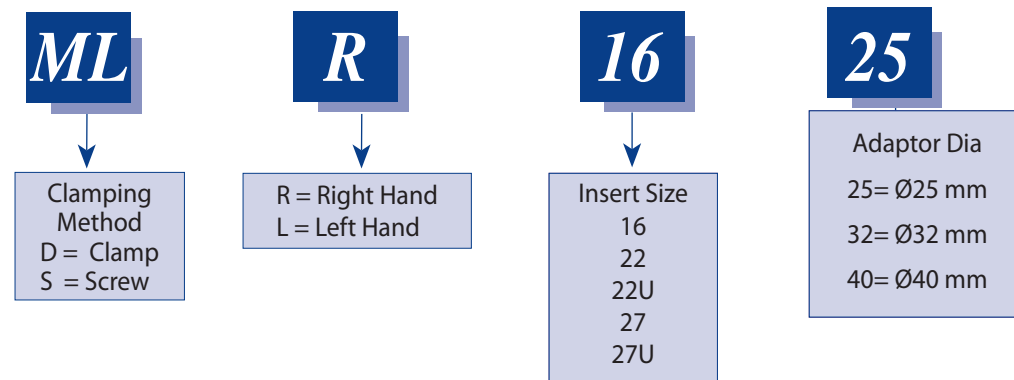
## High pressure coolant

The boring bars and the ML adaptors are design with internal coolant allowing a high pressure up to 120 Bar. A high pressure coolant helps to reduce the cutting edge temperature, provides a better chip evacuation and improves the insert tool life.

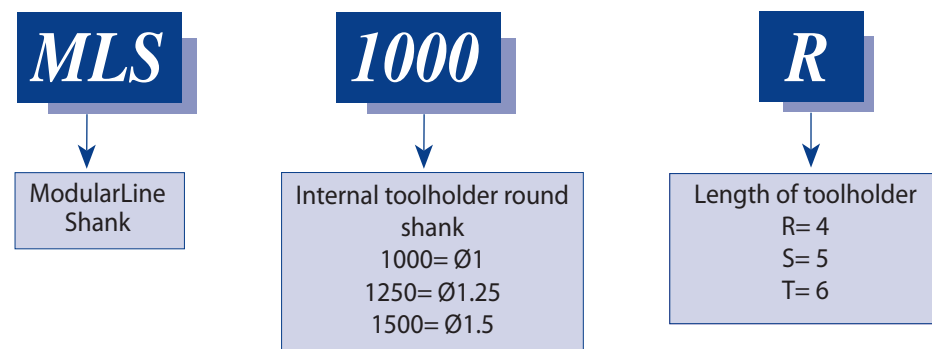
The tools can be used also with normal coolant pressure available on the customer machine.

## Product Identification

### Ordering Codes: ML Turning adaptors

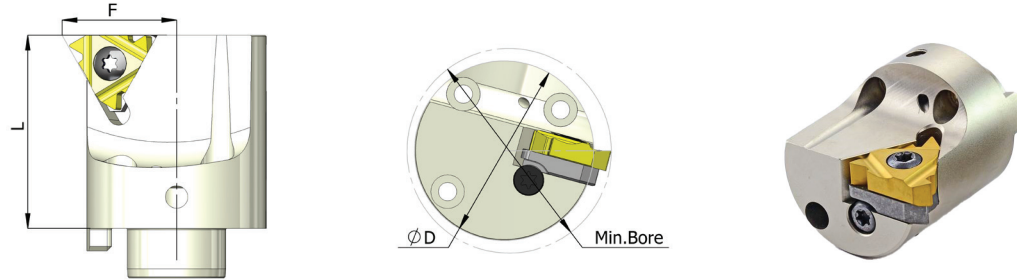


### Ordering Codes: Boring Bars



# Thread Turning Toolholders

## ML Turning adaptors

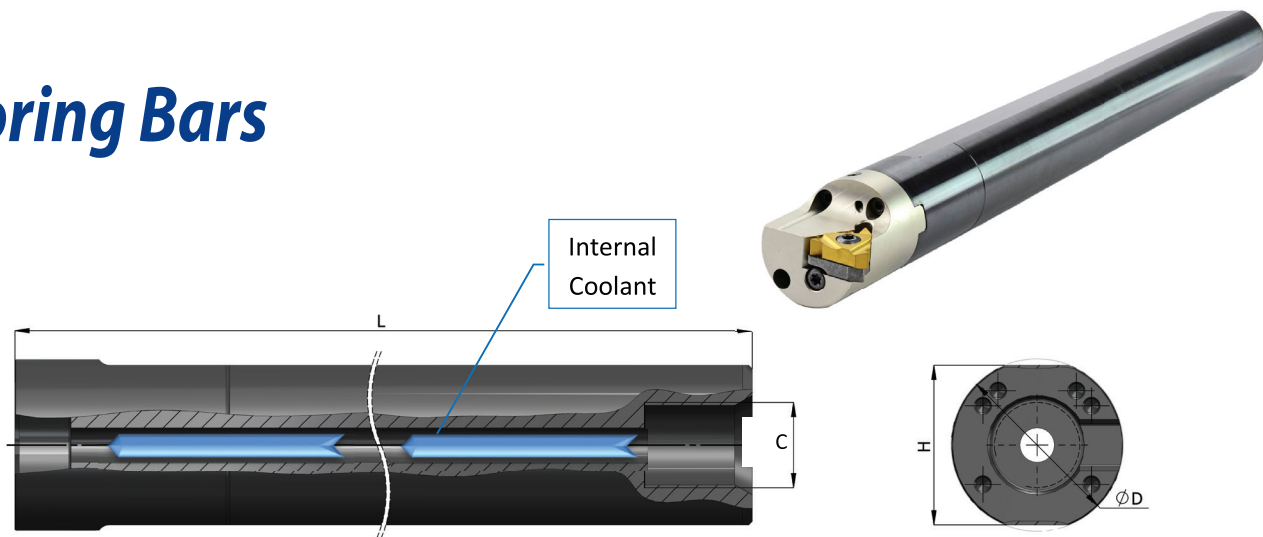


D	Ordering Code Right Hand	L	I.C.	Min Bore Diam.	L	F	Insert Screw Torx+	Anvil Screw Torx+	Torx+ key	RH Anvil	LH Anvil
25	<b>*MLR 16-25</b>	16	3/8	1.14	1.2	.65	S16P	---	K16P	---	---
25	<b>*MLR 22-25</b>	22	1/2	1.22	1.2	.71	S22P	---	K22P	---	---
32	<b>MLR 16-32</b>	16	3/8	1.42	1.7	.78	S16P	A16P	K16P	AI16	AE16
32	<b>MLR 22-32</b>	22	1/2	1.50	1.7	.85	S22P	A22P	K22P	AI22	AE22
32	<b>MLR 22U-32</b>	22U	1/2U	1.62	1.7	.96	S22P	A22P	K22P	AI22U	AE22U
40	<b>MLR 16-40</b>	16	3/8	1.73	1.7	.93	S16P	A16P	K16P	AI16	AE16
40	<b>MLR 22-40</b>	22	1/2	1.81	1.7	1.01	S22P	A22P	K22P	AI22	AE22
40	<b>MLR 22U-40</b>	22U	1/2U	1.81	1.7	1.12	S22P	A22P	K22P	AI22U	AE22U
40	<b>MLR 27-40</b>	27	5/8	1.90	1.7	1.05	S27P	A27P	K27P	AI27	AE27
40	<b>MLR 27U-40</b>	27U	5/8U	1.90	1.7	1.16	S27P	A27P	K27P	AI27U	AE27U

\*Toolholders with no anvil

For left hand specify MLL... instead of MLR...

## Boring Bars



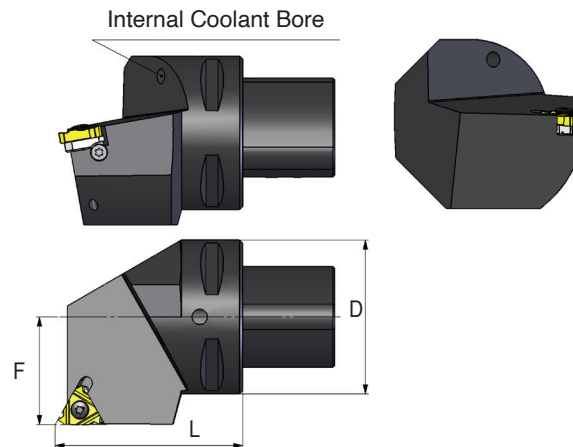
D	Ordering Code	L	H	C	Screw	Key
1.00	<b>MLS 1000 R</b>	8.0	.905	1/4 - 18NPT	S420, S435	K3
1.25	<b>MLS 1250 S</b>	10.0	1.12	3/8 - 18NPT	S520, S550	K4
1.50	<b>MLS 1500 T</b>	12.0	1.34	1/2 - 14NPT	S520, S550	K4


A02-13



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

## External Toolholders

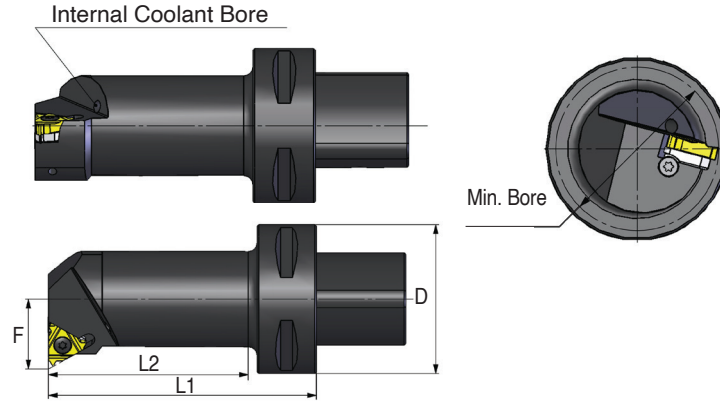



Equivalent to...	Ordering Code	 mm	D mm	F	L	Insert Screw	Anvil Screw	Torx key	RH Anvil	LH Anvil
C4	<b>P40-SER 27050-16</b>	16	40	1.06	2.0	S16	A16	K16	AE16	AI16
C5	<b>P50-SER 35060-16</b>	16	50	1.38	2.4	S16	A16	K16	AE16	AI16
C6	<b>P63-SER 45065-16</b>	16	63	1.77	2.6	S16	A16	K16	AE16	AI16
C4	<b>P40-SER 27050-22</b>	22	40	1.06	2.0	S22	A22	K22	AE22	AI22
C5	<b>P50-SER 35060-22</b>	22	50	1.38	2.4	S22	A22	K22	AE22	AI22
C6	<b>P63-SER 45065-22</b>	22	63	1.77	2.6	S22	A22	K22	AE22	AI22
C8	<b>P80-SER 55080-16</b>	16	80	2.17	3.1	S16	A16	K16	AE16	AI16
C8	<b>P80-SER 55080-22</b>	22	80	2.17	3.1	S22	A22	K22	AE22	AI22
C6	<b>P63-SER 45065-27</b>	27	63	1.772	2.6	S27	A27	K27	AE27	AI27

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

# Thread Turning Toolholders

## Internal Toolholders

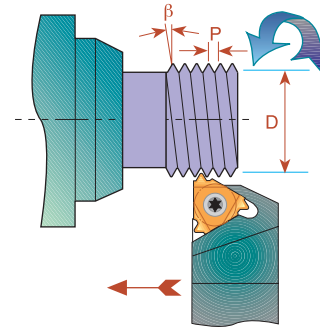
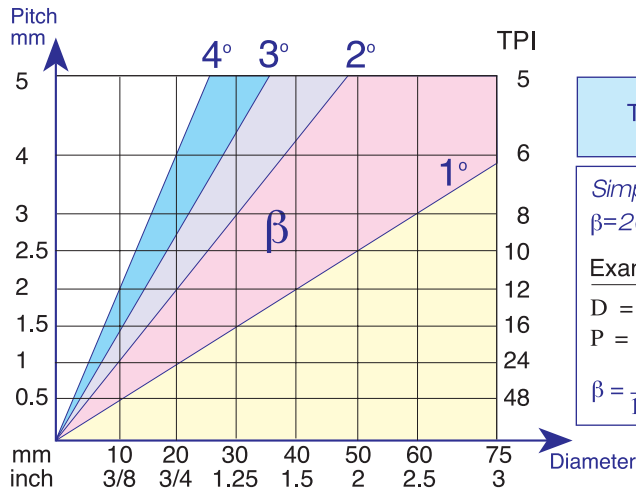


Equivalent to...	Ordering Code	 mm	D mm	F	Min. Bore Dia.	L1	L2	Insert Screw	Anvil Screw	Torx key	RH Anvil	LH Anvil
C4	* P40-SIR 12060-16	16	40	.46	.79	2.36	1.46	S16	-	K16	-	-
	P40-SIR 14060-16	16	40	.53	.98	2.36	1.50	S16	A16	K16	AI16	AE16
	P40-SIR 17070-16	16	40	.63	1.14	2.76	1.89	S16	A16	K16	AI16	AE16
	P40-SIR 22090-16	16	40	.77	1.42	3.54	2.72	S16	A16	K16	AI16	AE16
	P40-SIR 27080-16	16	40	.93	1.73	3.15	2.36	S16	A16	K16	AI16	AE16
C5	* P50-SIR 12060-16	16	50	.46	.79	2.36	1.38	S16	-	K16	-	-
	P50-SIR 14060-16	16	50	.53	.98	2.36	1.42	S16	A16	K16	AI16	AE16
	P50-SIR 17070-16	16	50	.63	1.14	2.76	1.85	S16	A16	K16	AI16	AE16
	P50-SIR 22090-16	16	50	.77	1.42	3.54	2.68	S16	A16	K16	AI16	AE16
	P50-SIR 27105-16	16	50	.93	1.73	4.13	3.31	S16	A16	K16	AI16	AE16
C6	P63-SIR 14070-16	16	63	.53	.984	2.76	1.65	S16	A16	K16	AI16	AE16
	P63-SIR 17075-16	16	63	.63	1.14	2.95	1.89	S16	A16	K16	AI16	AE16
	P63-SIR 22090-16	16	63	.77	1.50	3.54	2.52	S16	A16	K16	AI16	AE16
	P63-SIR 27105-16	16	63	.93	1.81	4.13	3.15	S16	A16	K16	AI16	AE16
C4	* P40-SIR 15065-22	22	40	.61	.98	2.56	1.65	S22	-	K22	-	-
	P40-SIR 19070-22	22	40	.70	1.14	2.76	1.89	S22	A22	K22	AI22	AE22
	P40-SIR 22090-22	22	40	.84	1.50	3.54	2.72	S22	A22	K22	AI22	AE22
	P40-SIR 27080-22	22	40	1.00	1.81	3.15	2.36	S22	A22	K22	AI22	AE22
C5	* P50-SIR 15065-22	22	50	.61	.98	2.56	1.61	S22	-	K22	-	-
	P50-SIR 19070-22	22	50	.70	1.14	2.76	1.85	S22	A22	K22	AI22	AE22
	P50-SIR 22090-22	22	50	.84	1.50	3.54	2.68	S22	A22	K22	AI22	AE22
	P50-SIR 27105-22	22	50	1.00	1.81	4.13	3.31	S22	A22	K22	AI22	AE22
C6	P63-SIR 19075-22	22	63	.70	1.14	2.95	1.89	S22	A22	K22	AI22	AE22
	P63-SIR 22090-22	22	63	.84	1.47	3.54	2.52	S22	A22	K22	AI22	AE22
	P63-SIR 27105-22	63	63	1.00	1.81	4.13	3.15	S22	A22	K22	AI22	AE22

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

\* Holders without anvil

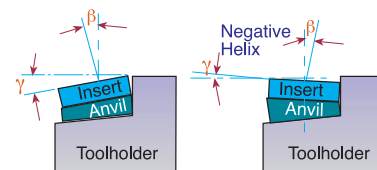
## Thread Helix Angle



## 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 $\gamma$	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	<b>AE16</b>	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	<b>AI 16</b>	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	<b>AE22</b>	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	<b>AI 22</b>	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	<b>AE22U</b>	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	<b>AI 22U</b>	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	<b>AE27</b>	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	<b>AI 27</b>	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	<b>AE27U</b>	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	<b>AI 27U</b>	AI 27U+0.5	AI 27U-0.5	AI 27U-1.5

# Thread Turning Toolholders

## 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				
<b>KA16</b>	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
<b>KA22</b>	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
<b>KA22U</b>	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
<b>KA27</b>	AE27+4.5 AI 27+4.5		AE27+2.5 AI 27+2.5		AE27-1.5 AI 27-1.5
<b>KA27U</b>	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 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 P16  
 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

## Miniature & Ultra-miniature Kits



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

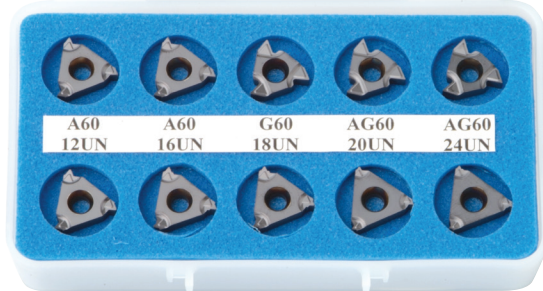


# Thread Turning Toolholders

## 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 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



**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



### Standard Inserts Kits

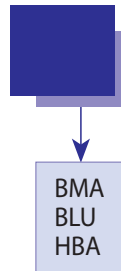
**EXTERNAL ISO KIT**

- 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

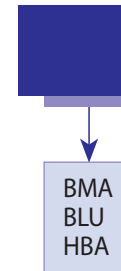
**INTERNAL ISO KIT**

- 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  $\varnothing 1/4$  with just one deep reaching CARBIDE shank ultra mini Boring Bar.



Ordering Code	Contents			
	Threading Insert	Turning Inserts	Boring Bar	Key
<b>KC6TI</b>	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