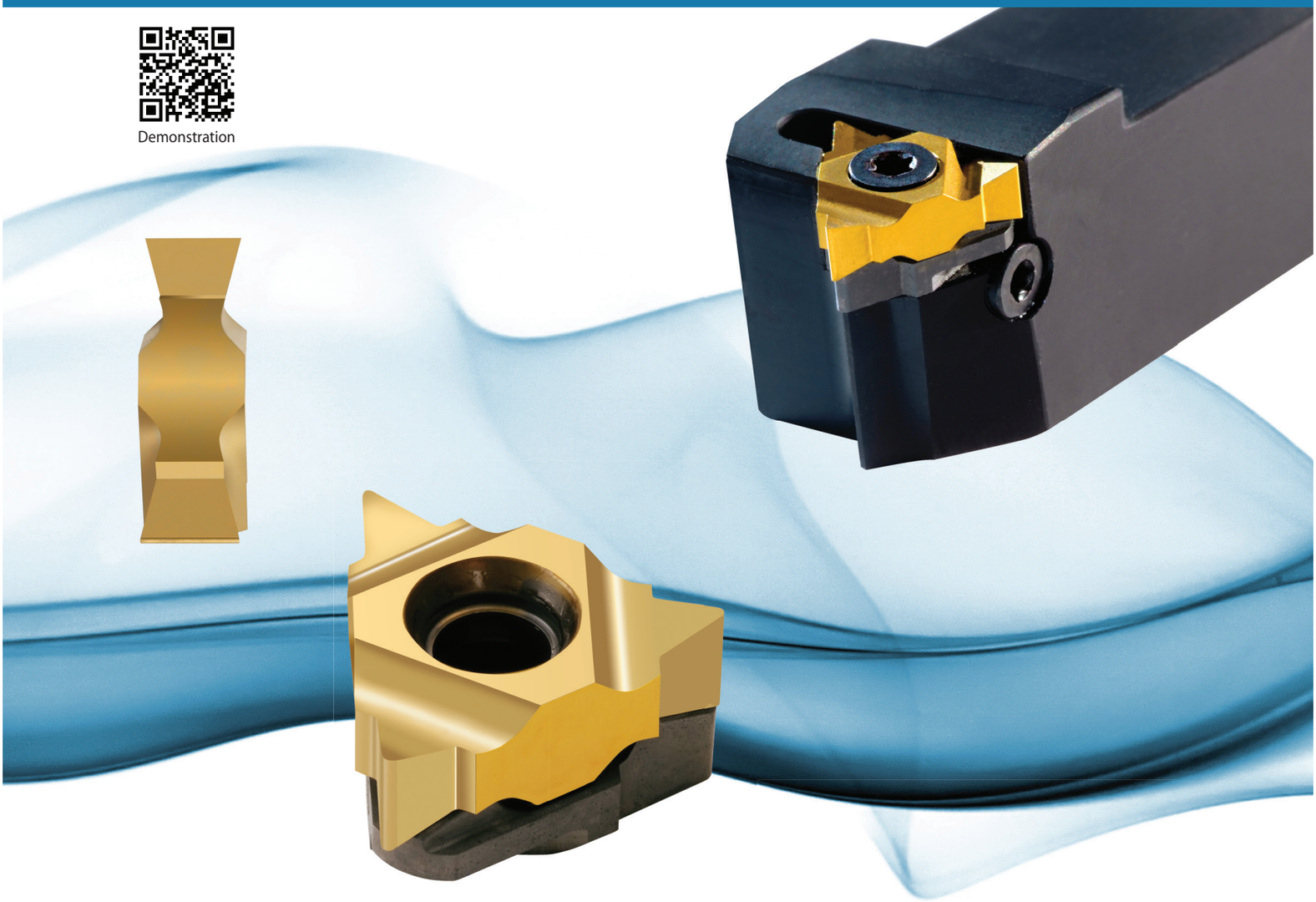
Double Sided Thread Turning Inserts & Toolholders | A03

Demonstration



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

Advantages of DSI-Thread Turning Inserts

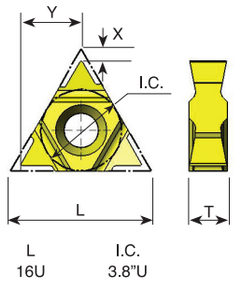
- Increased productivity thanks to the six cutting edges.
- U-Style inserts for a wide range of full or partial profile standard threads.
- Same insert for right hand or left hand thread.
- Saving on tooling costs.
- Unique anti-vibration anvil designed for clamping the insert and supporting the cutting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

Contents:

Product Identification

DSI Ordering Code

16U **E** **R/L** **1.5** **ISO** **6** **BMA**



E=External
I = Internal

R = Right Hand
L = Left Hand

Pitch
mm:
1.5-5.0
inch - TPI:
16-5

Full Profiles:
ISO
UN
WHIT
NPT

Partial Profiles:
G60 G55
AG60 AG55
N60 N55

Inserts with 6 cutting edges

Grade:
MXC
BMA

S **E** **R** **0750** **K** **16U** **B** **6**

Clamping Method
S = Screw

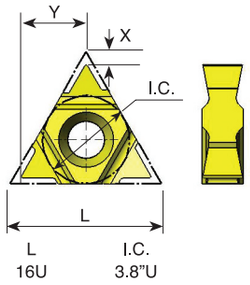
E = External
I = Internal

R = Right Hand
L = Left Hand

Shank Cross Section:
External toolholders square shank
0750=3/4 x 3/4

Internal toolholders & boring bars round shank
0750 = Diam. of 3/4

Length of Toolholders:
K = 5
M = 6
P = 7
R = 8

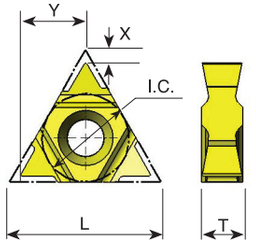


B: with internal coolant bore

6 - for DSI Thread Turning Insert

Carmex Precision Tools Ltd.

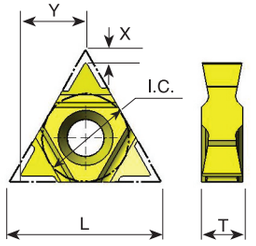
Partial Profile 60°



Pitch Range mm	Pitch Range TPI	L mm	I.C.	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**	.06	.28	.18
0.5 - 3.0	48-8	16U	3/8U	**16U ER/L AG60-6**	**16U IR/L AG60-6**	.06	.28	.18
3.5 - 5.0	7-5	16U	3/8U	**16U ER/L N60-6**	**16U IR/L N60-6**	.05	.29	.18

Available coating grades: BMA or MXC
Order example: 16U ER/L G60-6 BMA

Partial Profile 55°

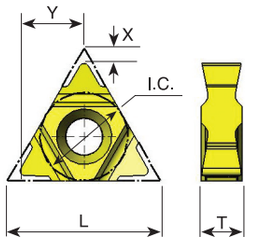


Pitch Range mm	Pitch Range TPI	L mm	I.C.	EXTERNAL Ordering Code	INTERNAL Ordering Code	X	Y	T
1.75 - 3.0	14-8	16U	3/8U	**16U ER/L G55-6**	**16U IR/L G55-6**	.06	.28	.18
0.5 - 3.0	48-8	16U	3/8U	**16U ER/L AG55-6**	**16U IR/L AG55-6**	.06	.28	.18
3.5 - 5.0	7-5	16U	3/8U	**16U ER/L N55-6**	**16U IR/L N55-6**	.05	.29	.18

Available coating grades: BMA or MXC

For carbide grade and cutting speed see page A04-2 and 3

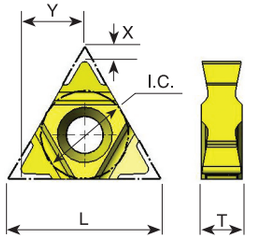
ISO



Pitch mm	L mm	I.C.	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	.06	.27	.18
1.75	16U	3/8U	16U ER/L 1.75 ISO-6	16U IR/L 1.75 ISO-6	.06	.27	.18
2.0	16U	3/8U	16U ER/L 2.0 ISO-6	16U IR/L 2.0 ISO-6	.06	.27	.18
2.5	16U	3/8U	16U ER/L 2.5 ISO-6	16U IR/L 2.5 ISO-6	.06	.27	.18
3.0	16U	3/8U	16U ER/L 3.0 ISO-6	16U IR/L 3.0 ISO-6	.06	.27	.18
3.5	16U	3/8U	16U ER/L 3.5 ISO-6	16U IR/L 3.5 ISO-6	.06	.27	.18
4.0	16U	3/8U	16U ER/L 4.0 ISO-6	16U IR/L 4.0 ISO-6	.06	.27	.18
4.5	16U	3/8U	16U ER/L 4.5 ISO-6	16U IR/L 4.5 ISO-6	.06	.27	.18
5.0	16U	3/8U	16U ER/L 5.0 ISO-6	16U IR/L 5.0 ISO-6	.06	.27	.18

Available coating grades: BMA or MXC
Order example: 16U ER/L 1.75 ISO-6 BMA

UN - Unified UNC, UNF, UNEF, UNS

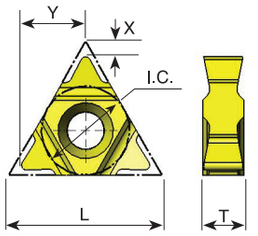


Pitch TPI	L mm	I.C.	EXTERNAL Ordering Code	INTERNAL Ordering Code	X	Y	T
16	16U	3/8U	16U ER/L 16 UN-6	16U IR/L 16 UN-6	.06	.27	.18
14	16U	3/8U	16U ER/L 14 UN-6	16U IR/L 14 UN-6	.06	.27	.18
13	16U	3/8U	16U ER/L 13 UN-6	16U IR/L 13 UN-6	.06	.27	.18
12	16U	3/8U	16U ER/L 12 UN-6	16U IR/L 12 UN-6	.06	.27	.18
11.5	16U	3/8U	16U ER/L 11.5 UN-6	16U IR/L 11.5 UN-6	.06	.27	.18
11	16U	3/8U	16U ER/L 11 UN-6	16U IR/L 11 UN-6	.06	.27	.18
10	16U	3/8U	16U ER/L 10 UN-6	16U IR/L 10 UN-6	.06	.27	.18
9	16U	3/8U	16U ER/L 9 UN-6	16U IR/L 9 UN-6	.06	.27	.18
8	16U	3/8U	16U ER/L 8 UN-6	16U IR/L 8 UN-6	.06	.27	.18
7	16U	3/8U	16U ER/L 7 UN-6	16U IR/L 7 UN-6	.06	.27	.18
6	16U	3/8U	16U ER/L 6 UN-6	16U IR/L 6 UN-6	.06	.27	.18
5	16U	3/8U	16U ER/L 5 UN-6	16U IR/L 5 UN-6	.06	.27	.18

Available coating grades: BMA or MXC

For carbide grade and cutting speed see page A04-2 and 3

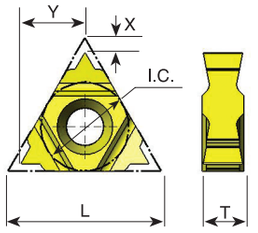
Whitworth 55° BSW, BSF, BSP, BSB



Pitch TPI	L mm	I.C.	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	.06	.27	.18
14	16U	3/8U	16U ER/L 14 W-6	16U IR/L 14 W-6	.06	.27	.18
12	16U	3/8U	16U ER/L 12 W-6	16U IR/L 12 W-6	.06	.27	.18
11	16U	3/8U	16U ER/L 11 W-6	16U IR/L 11 W-6	.06	.27	.18
10	16U	3/8U	16U ER/L 10 W-6	16U IR/L 10 W-6	.06	.27	.18
9	16U	3/8U	16U ER/L 9 W-6	16U IR/L 9 W-6	.06	.27	.18
8	16U	3/8U	16U ER/L 8 W-6	16U IR/L 8 W-6	.06	.27	.18
7	16U	3/8U	16U ER/L 7 W-6	16U IR/L 7 W-6	.06	.27	.18
6	16U	3/8U	16U ER/L 6 W-6	16U IR/L 6 W-6	.06	.27	.18
5	16U	3/8U	16U ER/L 5 W-6	16U IR/L 5 W-6	.06	.27	.18

Available coating grades: BMA or MXC
Order example: 16U ER/L 9 W-6 BMA

NPT



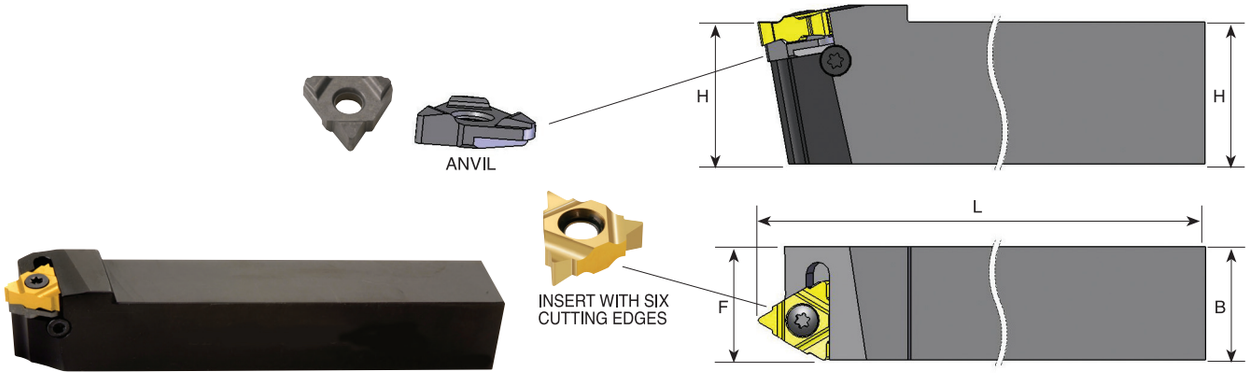
Pitch TPI	L mm	I.C.	EXTERNAL Ordering Code	INTERNAL Ordering Code	X	Y	T
14	16U	3/8U	16U ER/L 14 NPT-6	16U IR/L 14 NPT-6	.06	.27	.18
11.5	16U	3/8U	16U ER/L 11.5 NPT-6	16U IR/L 11.5 NPT-6	.06	.27	.18
8	16U	3/8U	16U ER/L 8 NPT-6	16U IR/L 8 NPT-6	.06	.27	.18

Available coating grades: BMA or MXC

For carbide grade and cutting speed see page A04-2 and 3

Heavy Duty Thread Turning Toolholders

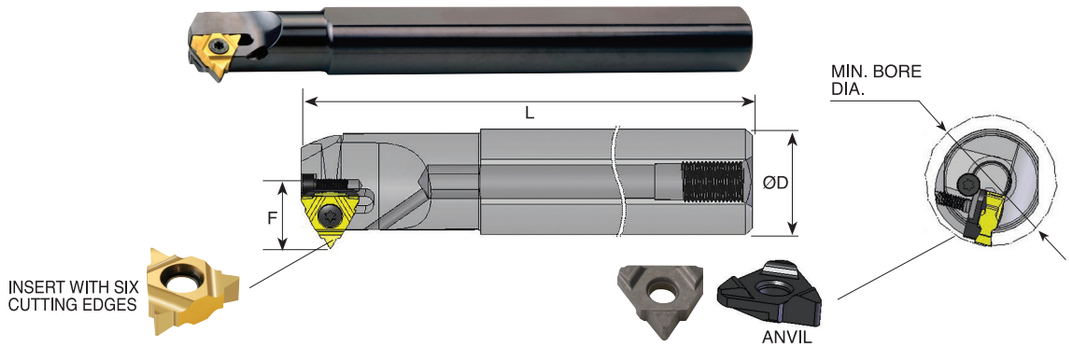
External



Ordering Code Right Hand	H	B	L	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SER 0750 K16U-6	.75	.75	5	.75	S16	A16	K16	AER 16U-6	AEL 16U-6
SER 1079 M16U-6	1.0	.79	6	.79	S16	A16	K16	AER 16U-6	AEL 16U-6

For **LEFT HAND** toolholders specify SE**L** instead of SE**R**

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 0750 P16UB-6	.75	.94	7	.57	S16	A16	K16	AIR 16U-6	AIL 16U-6
SIR 1000 R16UB-6	1.0	1.14	8	.69	S16	A16	K16	AIR 16U-6	AIL 16U-6

For **LEFT HAND** toolholders specify SI**L** instead of SI**R**