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# Mini Spiral Mill-Thread New Products



CARMEX MINI SPIRAL MT NEWS 05/2015

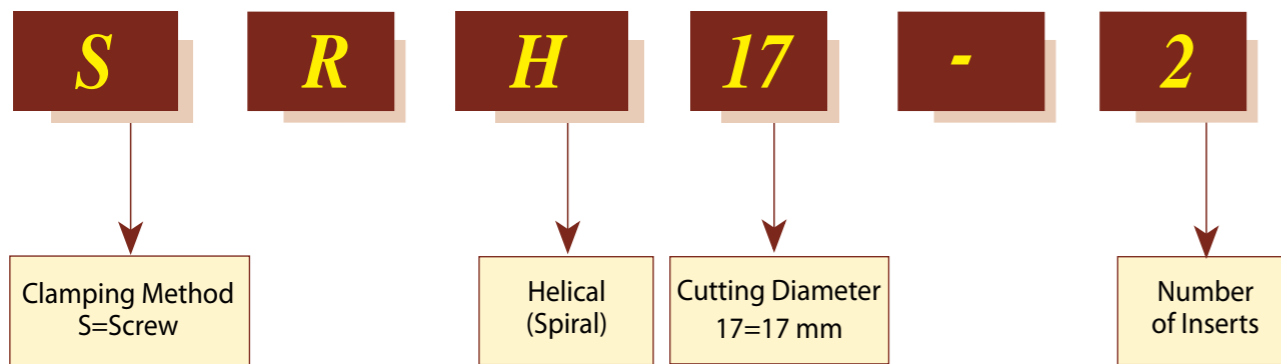


## Carmex presents the new members of the Spiral Mill-Thread product line.

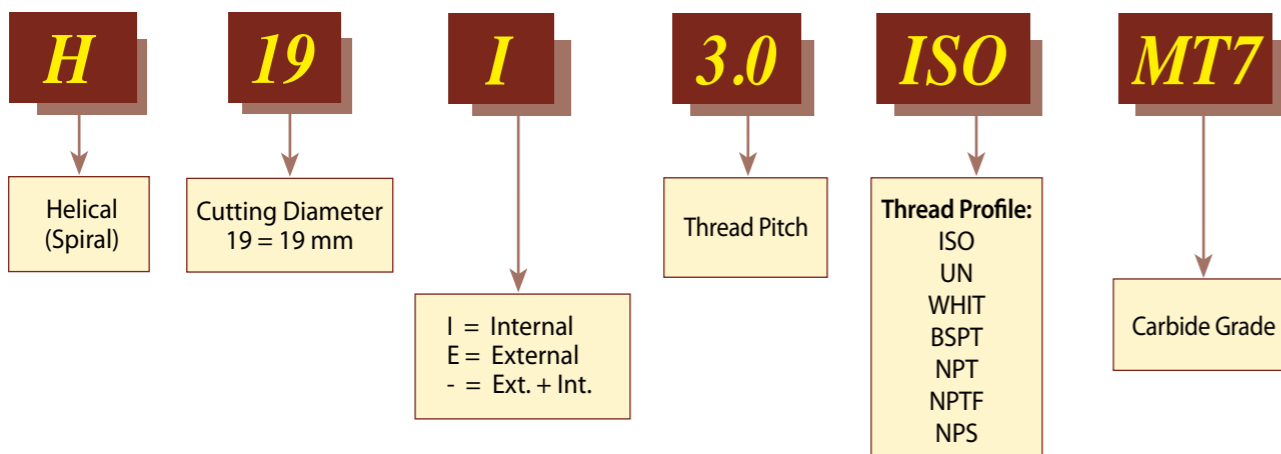
- Spiral fluted toolholders hold 1 to 3 inserts.
- Comparatively small cutting diameters.
- Toolholders with internal coolant bore.
- Smooth cutting operation at a high feed rate.
- Reduced machining time.
- Spiral design reduces vibrations and chatter.
- High grade surface finish.
- Inserts are available in MT7 Sub-Micron grade with TiAlN multi-layer coating.

### Product Identification Ordering Codes

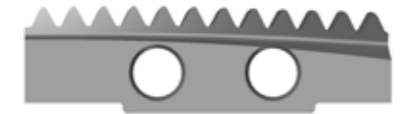
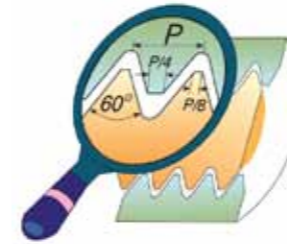
#### Toolholders



#### Inserts

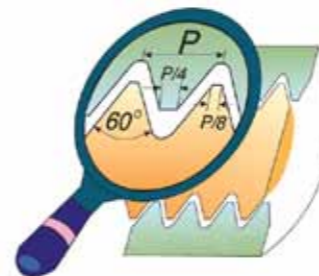


## Inserts ISO



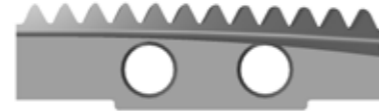
Insert Size	Pitch mm	M coarse	M fine	Ordering code	Toolholder
H13	1.0	M16	≥ 15	H13 I 1.0 ISO	SRH 13 - 1
	1.5		≥ 16	H13 I 1.5 ISO	
	2.0		≥ 16	H13 I 2.0 ISO	
H15	1.0	M18	≥ 17	H15 I 1.0 ISO	SRH 15 - 1
	1.5		≥ 17	H15 I 1.5 ISO	
	2.0		≥ 18	H15 I 2.0 ISO	
	2.5		≥ 18	H15 I 2.5 ISO	
H17	1.0	M20, M22	≥ 19	H17 I 1.0 ISO	SRH 17 - 2
	1.5		≥ 19	H17 I 1.5 ISO	
	2.0		≥ 20	H17 I 2.0 ISO	
	2.5		≥ 20	H17 I 2.5 ISO	
H19	2.0	M24, M27	≥ 22	H19 I 2.0 ISO	SRH 19 - 3
	3.0		≥ 22	H19 I 3.0 ISO	

## UN



Insert Size	Pitch TPI	UN	UNC	UNF	UNS	Ordering code	Toolholder
H13	16	5/8, 11/16				H13 I 16 UN	SRH 13 - 1
	14				5/8	H13 I 14 UN	
	12	11/16				H13 I 12 UN	
H15	16			3/4		H15 I 16 UN	SRH 15 - 1
	14				3/4	H15 I 14 UN	
	12	3/4, 13/16				H15 I 12 UN	
	10				7/8, 1	H15 I 10 UN	
H17	16	13/16				H17 I 16 UN	SRH 17 - 2
	14			7/8, 1		H17 I 14 UN	
	12	7/8				H17 I 12 UN	
H19	9		7/8			H17 I 9 UN	SRH 19 - 3
	12	15/16		1		H19 I 12 UN	
	8	11/16, 11/8	1			H19 I 8 UN	

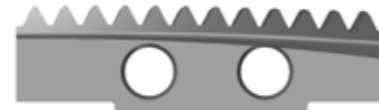
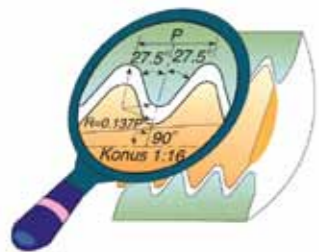
## BSP (G)



Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	19	G 3/8	<b>H13- 19 W</b>	SRH 13 - 1
H15	14	G 1/2	<b>H15- 14 W</b>	SRH 15 - 1
H17	14	G 1/2 - 5/8	<b>H17- 14 W</b>	SRH 17 - 2
	11	G ≥ 1"	<b>H17- 11 W</b>	
H19	14	G 3/4 - 7/8	<b>H19- 14 W</b>	SRH 19 - 3
	11	G ≥ 1"	<b>H19- 11 W</b>	

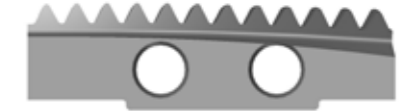
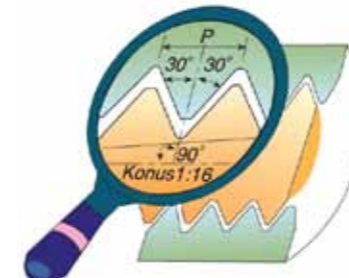
## BSPT



Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	19	3/8	<b>H13- 19 BSPT</b>	SRH 13 - 1
H15	14	1/2 - 3/4	<b>H15- 14 BSPT</b>	SRH 15 - 1
H17	14	1/2 - 3/4	<b>H17- 14 BSPT</b>	SRH 17 - 2

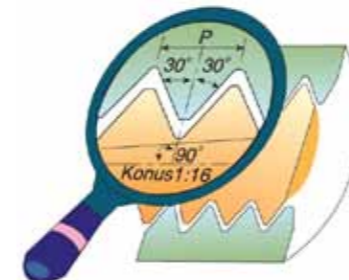
## NPT



Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	18	3/8	<b>H13- 18 NPT</b>	SRH 13 - 1
H15	14	1/2 - 3/4	<b>H15- 14 NPT</b>	SRH 15 - 1
H17	14	1/2 - 3/4	<b>H17- 14 NPT</b>	SRH 17 - 2

## NPTF



Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	18	3/8	<b>H13- 18 NPTF</b>	SRH 13 - 1
H15	14	1/2 - 3/4	<b>H15- 14 NPTF</b>	SRH 15 - 1
H17	14	1/2 - 3/4	<b>H17- 14 NPTF</b>	SRH 17 - 2

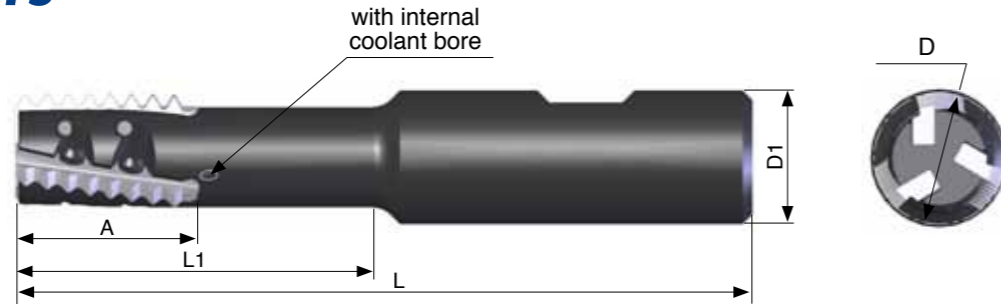
## NPS



Same insert for internal and external thread

Insert Size	Pitch TPI	Thread	Ordering code	Toolholder
H13	18	3/8	<b>H13- 18 NPS</b>	SRH 13 - 1
H15	14	1/2 - 3/4	<b>H15- 14 NPS</b>	SRH 15 - 1
H17	14	1/2 - 3/4	<b>H17- 14 NPS</b>	SRH 17 - 2

## Toolholders



Ordering Code	Insert Type	Insert size A	D	D1	L	L1	No. of Inserts	Screw	Key
SRH13-1	H13	27	13	20	90	35	1	S13	K11
SRH15-1	H15	27	15	20	95	40	1	S15	K11
* SRH17-2	H17	27	17	20	85	30	2	S17	K11
* SRH17J-2	H17	27	17	20	100	45	2	S17	K11
SRH19-3	H19	27	19	20	85	30	3	S19	K11
SRH19J-3	H19	27	19	20	110	55	3	S19	K11

\* When using NPT, NPTF, BSPT inserts the cutting diameter D = 18 mm

## Spiral Mill-Thread Inserts Speed and Feed Selection

**MT7** Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed m/min MT7
<b>P</b>	Low and Medium Carbon Steels	145-360
	High Carbon Steels	165-255
	Alloy Steels, Treated Steels	135-230
<b>M</b>	Stainless Steels	165-245
	Cast Steels	190-245
<b>K</b>	Cast Iron	100-220
<b>N</b>	Non-Ferrous and Aluminium	230-440
	Synthetics, Duroplastics, Thermoplastics	145-590
<b>S</b>	Nickel Alloys, Titanium Alloys	30-115

**Recommended FEED RATE: 0.05 - 0.15 mm**

As you may note, cutting speed is shown in range terms. In most standard cases, choosing a speed in the middle of the range would be a good choice for a start.

For hard metals reduce cutting speed.