

NEW
2005 EDITION



Spiral Mill-Thread



Spiral toolholders and inserts
for smooth cutting



Carmex
Precision Tools Ltd.

Metric

NEW

Specially designed Mill-Thread inserts and toolholders

The new spiral designed tools enable smooth cutting operations at high feed rates and reduced machining time. The tools are suitable for a wide range of applications, from small components in small machining centers to heavy-duty applications in high power milling machines.

H23 Toolholder

Ordering Code	Insert Size A	D	D1	L	L1	No. of Inserts	Screw	Key
SRH23-2	27	23	25	110	50	2	S23	K21

H23 Threading Inserts

ISO

Pitch mm	Ordering Code	Thread Size
1.0	H23 I 1.0 ISO	≥ M26
1.5	H23 I 1.5 ISO	≥ M27
2.0	H23 I 2.0 ISO	≥ M28
3.0	H23 I 3.0 ISO	≥ M30

For internal thread

UN

Pitch TPI	Ordering Code	Thread Size
24	H23 I 24 UN	≥ 1"
16	H23 I 16 UN	≥ 1 1/16"
12	H23 I 12 UN	≥ 1 1/8"
8	H23 I 8 UN	≥ 1 3/16"

For internal thread

WHITWORTH

Pitch TPI	Ordering Code	Thread Size
11	H23-11 W	≥ G 1"

Same insert for internal and external thread

BSPT

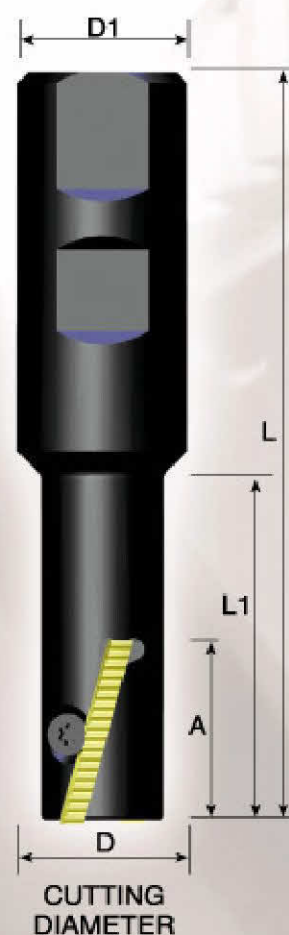
Pitch TPI	Ordering Code	Thread Size
11	H23-11 BSPT	≥ 1" BSPT

Same insert for internal and external thread

NPT

Pitch TPI	Ordering Code	Thread Size
11.5	H23-11.5 NPT	1"-2" NPT

Same insert for internal and external thread



- Spiral fluted toolholders hold 2 to 9 inserts in a comparatively small cutting diameter.
- The unique clamping method enables optimal indexability.
- These tools reduce vibration and chatter.
- High grade finish is achieved in all applications: threading, roughing and finishing.
- MT7 Sub-Micron Grade with Titanium Aluminium Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials.

NEW

H32 Toolholder

Ordering Code	Insert Size A	D	D1	L	L1	No. of Inserts	Screw	Key
SRH32-5	32	32	32	130	60	5	S32	K22

H32 Threading Inserts

ISO

Pitch mm	Ordering Code	Thread Size
1.5	H32 I 1.5 ISO	$\geq M35$
2.0	H32 I 2.0 ISO	$\geq M36$
3.0	H32 I 3.0 ISO	$\geq M38$
4.0	H32 I 4.0 ISO	$\geq M40$

For internal thread

UN

Pitch TPI	Ordering Code	Thread Size
16	H32 I 16 UN	$\geq 1 \frac{3}{8}"$
12	H32 I 12 UN	$\geq 1 \frac{7}{16}"$
8	H32 I 8 UN	$\geq 1 \frac{1}{2}"$
6	H32 I 6 UN	$\geq 1 \frac{9}{16}"$

For internal thread

WHITWORTH

Pitch TPI	Ordering Code	Thread Size
11	H32-11 W	Internal $\geq G \ 1 \frac{1}{8}"$ External $\geq G \ 1"$

Same insert for internal and external thread

BSPT

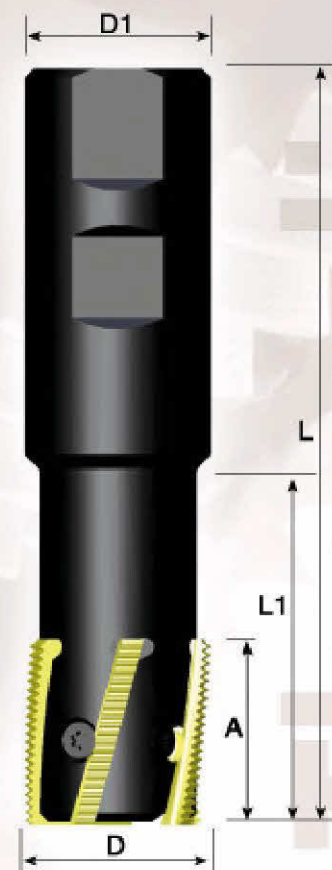
Pitch TPI	Ordering Code	Thread Size
11	H32-11 BSPT	Internal $\geq 1 \frac{1}{8}"$ BSPT External $\geq 1"$ BSPT

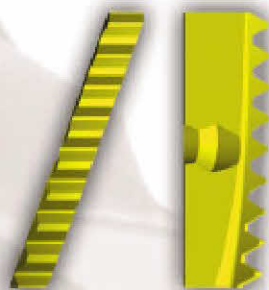
Same insert for internal and external thread

NPT

Pitch TPI	Ordering Code	Thread Size
11.5	H32-11.5 NPT	Internal $1 \frac{1}{4}"$ -2" NPT External $1"$ -2" NPT

Same insert for internal and external thread





SPIRAL INSERTS HAVE
ONE CUTTING EDGE



H45 Toolholder

Ordering Code	Insert Size A	D	D1	L	No. of Inserts	Screw	Key
SRH45-6	37	45	32	130	6	S45	K40

H45 Threading Inserts

ISO

Pitch mm	Ordering Code	Thread Size
1.5	H45 I 1.5 ISO	$\geq M50$
2.0	H45 I 2.0 ISO	$\geq M50$
3.0	H45 I 3.0 ISO	$\geq M56$
4.0	H45 I 4.0 ISO	$\geq M56$

For internal thread

UN

Pitch TPI	Ordering Code	Thread Size
16	H45 I 16 UN	$\geq 2"$
12	H45 I 12 UN	$\geq 2"$
8	H45 I 8 UN	$\geq 2 \frac{1}{4}"$
6	H45 I 6 UN	$\geq 2 \frac{1}{4}"$

For internal thread

WHITWORTH

Pitch TPI	Ordering Code	Thread Size
11	H45-11 W	Internal $\geq G 1 \frac{3}{4}"$ External $\geq G 1"$

Same insert for internal and external thread

BSPT

Pitch TPI	Ordering Code	Thread Size
11	H45-11 BSPT	Internal $\geq 1 \frac{3}{4}"$ BSPT External $\geq 1"$ BSPT

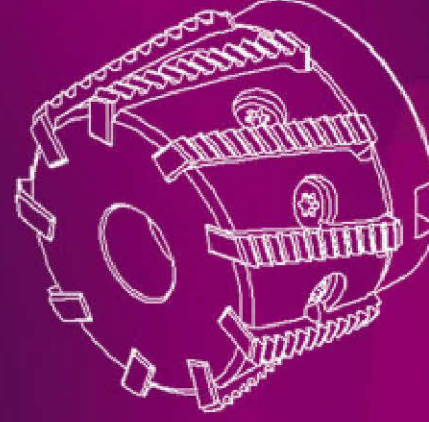
Same insert for internal and external thread

NPT

Pitch TPI	Ordering Code	Thread Size
11.5	H45-11.5 NPT	Internal 2" NPT External 1"-2" NPT

Same insert for internal and external thread





H63 Toolholder

Ordering Code	Insert Size A	D	D1	L	No. of Inserts	Screw	Key
SRH63-9	38	63	22	50	9	S63	K40

H63 Threading Inserts

ISO

Pitch mm	Ordering Code	Thread Size
1.5	H63 I 1.5 ISO	$\geq M70$
2.0	H63 I 2.0 ISO	$\geq M70$
3.0	H63 I 3.0 ISO	$\geq M75$
4.0	H63 I 4.0 ISO	$\geq M75$

For internal thread

UN

Pitch TPI	Ordering Code	Thread Size
16	H63 I 16 UN	$\geq 2 \frac{3}{4}"$
12	H63 I 12 UN	$\geq 2 \frac{3}{4}"$
8	H63 I 8 UN	$\geq 3"$
6	H63 I 6 UN	$\geq 3"$

For internal thread

WHITWORTH

Pitch TPI	Ordering Code	Thread Size
11	H63-11 W	Internal $\geq G 2 \frac{1}{2}"$ External $\geq G 1"$

Same insert for internal and external thread

BSPT

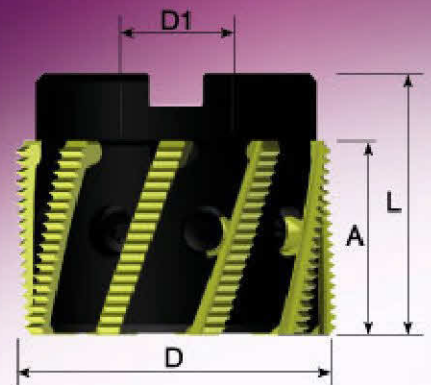
Pitch TPI	Ordering Code	Thread Size
11	H63-11 BSPT	Internal $\geq 2 \frac{1}{2}"$ BSPT External $\geq 1"$ BSPT

Same insert for internal and external thread

NPT

Pitch TPI	Ordering Code	Thread Size
11.5	H63-11.5 NPT	External $\geq 1"$ NPT

For external thread



SPIRAL INSERTS HAVE
ONE CUTTING EDGE

Special Tools

In addition to standard products, Carmex manufactures special tools and inserts according to customers' requests. The toolholders are multi-purpose, making them suitable for both roughing and finishing inserts. Special tools are supplied in short delivery times.



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