

Demonstration

Mill-Thread Inserts and Toolholders for machining deep threads

- Improved productivity due to multi-insert toolholders.
- Partial Profile, standard or U-Type inserts for a wide range of threads.
- Inserts with three cutting edges, reduces tooling costs.
- Low cutting resistance due to the single point inserts.
- Holder allows for a long overhang and includes internal coolant.
- Same insert and toolholder for both external and internal thread.

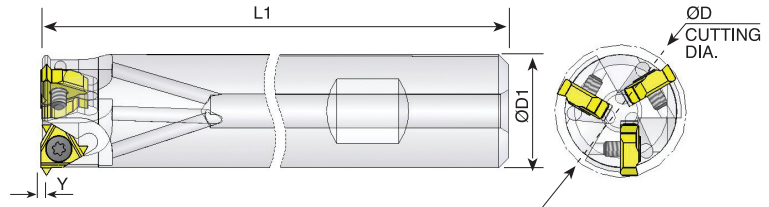
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Standard Toolholders and Inserts
U-Type Toolholders and Inserts

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D-Thread Mill-Thread Inserts & Toolholders for machining deep threads



Ordering Code	Insert Size		Y	D	D1	L1	No. of Inserts	Insert Screw	Torx Key
	L	I.C							
SR0023Q11	11	1/4	1	23.5	20	190	3	SE11	K11

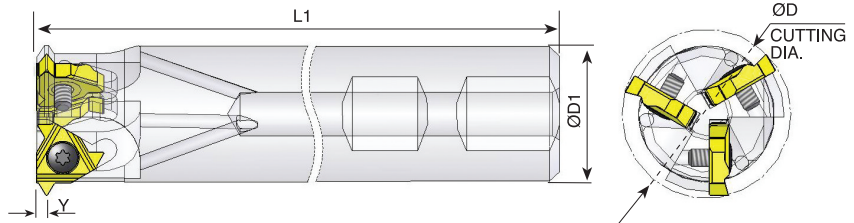
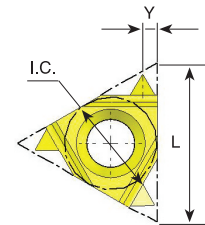
Partial 60° Size 11

Ordering Code		Pitch	
		mm	TPI
11 60D	INT.	1.0 - 2.0	24 - 12
	EX.	0.75 - 1.5	32 - 14

Coated Grade: BMA

Partial 55° Size 11

Ordering Code		Pitch TPI
11 55D	INT./EX.	24 - 14



Ordering Code	Insert Size		Y	D	D1	L1	No. of Inserts	Insert Screw	Torx Key
	L	I.C							
SR0031R16	16	3/8	1.8	31	25	225	3	SE16	K16

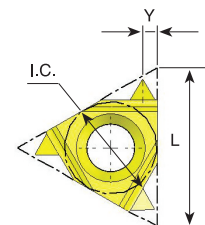
Partial 60° Size 16

Ordering Code		Pitch	
		mm	TPI
16 60D	INT.	2.5 - 3.5	10 - 7
	EX.	2.0 - 3.0	12 - 8

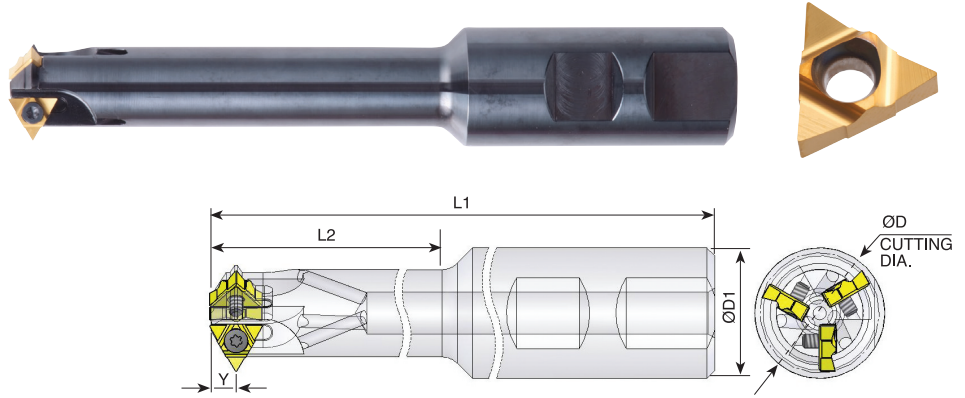
Coated Grade: BMA

Partial 55° Size 16

Ordering Code		Pitch TPI
16 55D	INT./EX.	12 - 8



D-Thread Mill-Thread Inserts & Toolholders for machining deep threads



Ordering Code	Insert Size		Y	D	D1	L1	L2	No. of Inserts	Insert Screw	Torx Key
	L	I.C								
*SR0015M11U	11U	1/4U	5	14.8	16	150	55	1	SE11	K11
**SR0021M11U	11U	1/4U	5	20.6	25	150	65	2	SE11	K11
SR0023M11U	11U	1/4U	5	23	25	150	88	3	SE11	K11

* Pitch limitations: for partial 60° - INT. - 10-9 TPI, EX. -12 - 10 TPI; for partial 55° - 12 - 9 TPI

** Pitch limitations: for partial 60° - INT. - 10-8 TPI, EX. -12 - 9 TPI; for partial 55° - 12 - 9 TPI

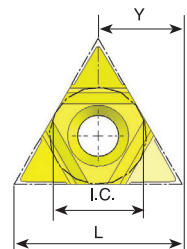
Partial 60° Size 11U

Ordering Code		Pitch	
		mm	TPI
11U 60D	INT.	2.5 - 4.0	10 - 6
	EX.	2.0 - 3.0	12 - 8
11U 60D-18-12	INT.	1.5 - 2.0	18 - 12
	EX.	1.25 - 1.75	20 - 14

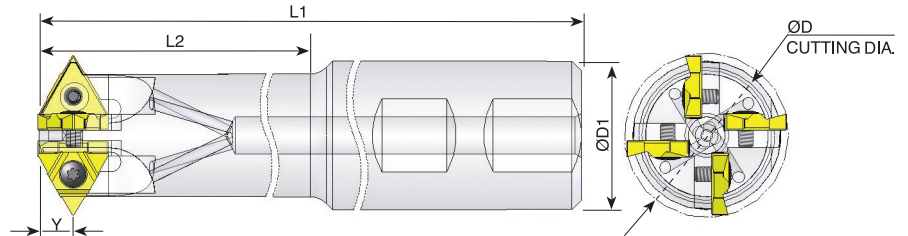
Coated Grade: BMA

Partial 55° Size 11U

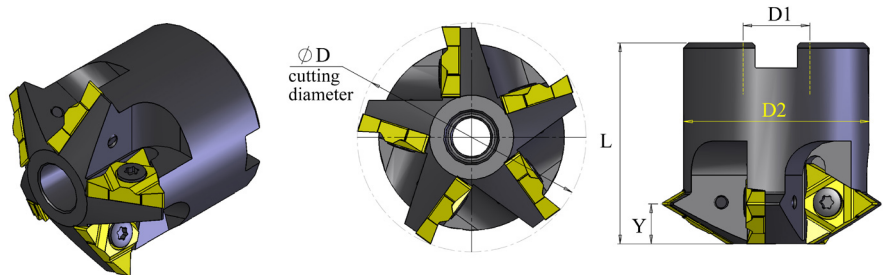
Ordering Code		Pitch TPI
11U 55D	INT./EX.	12 - 7



D-Thread Mill-Thread Inserts & Toolholders for machining deep threads



Ordering Code	Insert Size		Y	D	D1	L1	L2	No. of Inserts	Insert Screw	Torx Key
	L	I.C								
SR0035R16U	16U	3/8U	7.6	35.5	32	220	155	4	SE16	K16



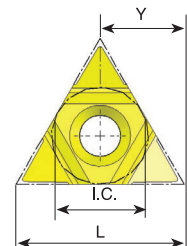
Ordering Code	Insert Size		Y	D	D1	D2	L	No. of Inserts	Insert Screw	Torx Key
	L	I.C								
SR0043B16U-5	16U	3/8U	7.6	43.4	16	35.3	38.1	5	SE16	K16

Partial 60° Size 16U

Ordering Code		Pitch	
		mm	TPI
16U 60D	INT.	4.0 - 6.0	6 - 4
	EX.	3.0 - 5.0	8 - 5
16U 60D-16-8	INT.	1.5 - 3.0	16 - 8
	EX.	1.5 - 2.5	18 - 10

Partial 55° Size 16U

Ordering Code		Pitch TPI
16U 55D	INT./EX.	6 - 4.5



Coated Grade: BMA



Demonstration

A Modular Line of Mill-Thread Toolholders

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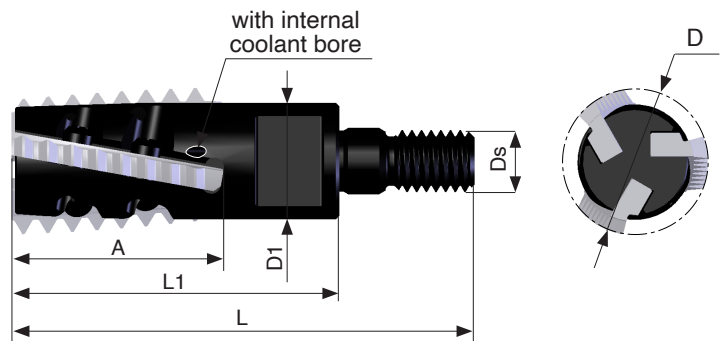
Toolholders
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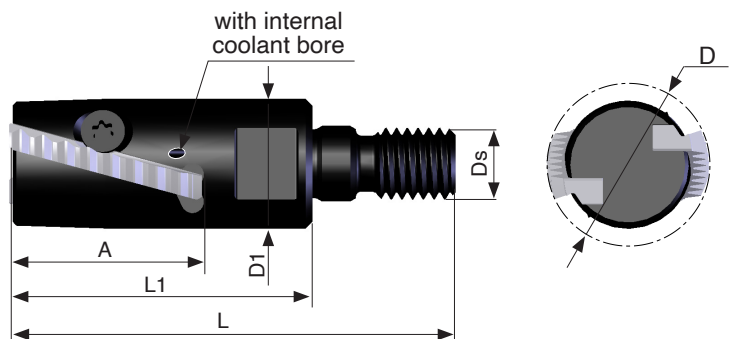
CPT presents a modular line of Mill-Thread toolholders

- CPT modular holders are ideal for deep reach applications.
- Unique clamping method enables optimal strength and indexability.
- Cost saving - Same shank can hold different heads.
- Toolholders with internal coolant bore.
- Screw connection allows long overhang.
- CPT standard thread milling inserts fit these toolholders.
- Different steel extensions are available.
- Toolholders are compatible with common toolholding systems.

Toolholders

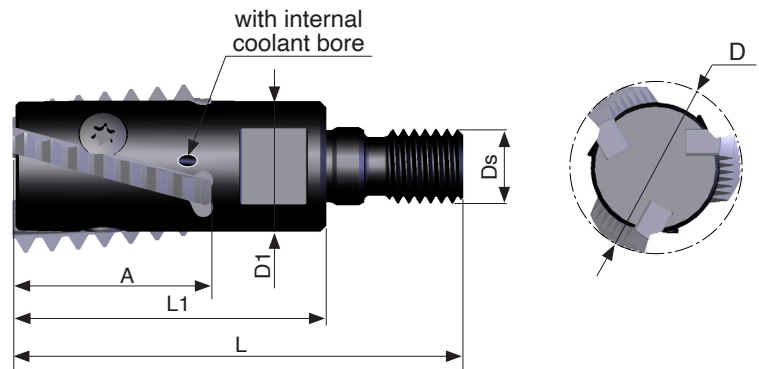


Ordering Code	Insert Type	Insert size A	D	D1	Ds	L1	L	No. of Inserts	Screw	Key
SRH19-3 S	H19	27	19	15	M8	42.5	60	3	S19	K11

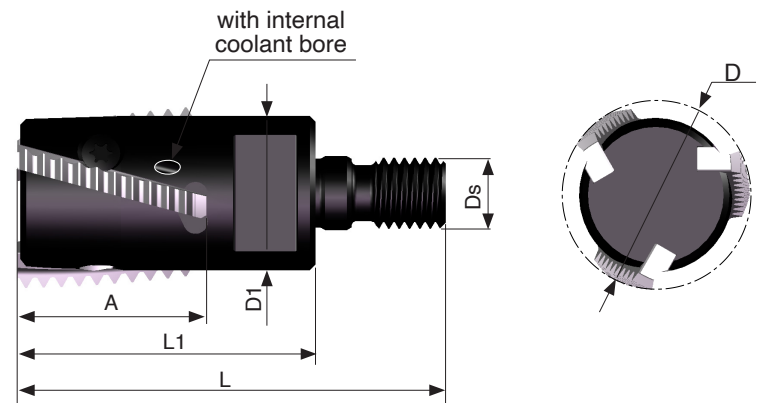


Ordering Code	Insert Type	Insert size A	D	D1	Ds	L1	L	No. of Inserts	Screw	Key
SRH23-2 S	H23	27	23	18	M10	42.5	62.5	2	S23	K16

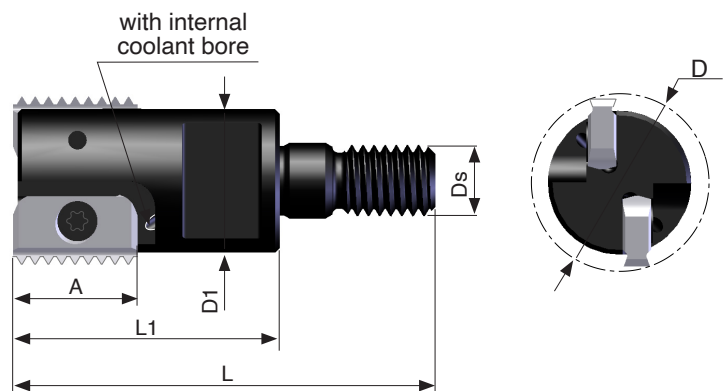
Deep Reach Mill-Thread



Ordering Code	Insert Type	Insert size A	D	D1	Ds	L1	L	No. of Inserts	Screw	Key
SRH28-3 S	H28	32	28	21	M12	50	72	3	S28	K16

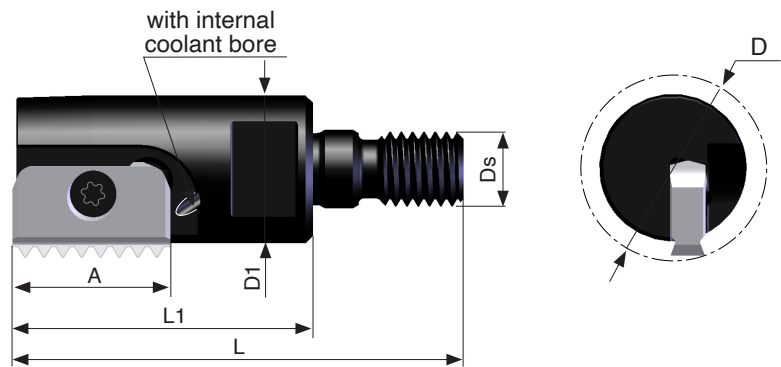


Ordering Code	Insert Type	Insert size A	D	D1	Ds	L1	L	No. of Inserts	Screw	Key
SRH32-3 S	H32	32	32	26	M12	50	72	3	S32S	K16

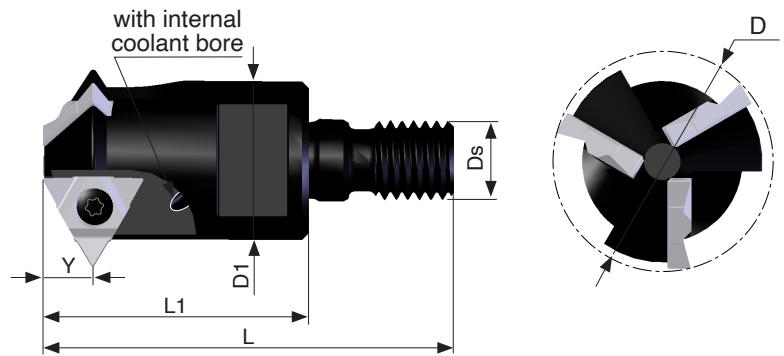


Ordering Code	Insert Type	Insert size A	D	D1	Ds	L1	L	No. of Inserts	Screw	Key
SR0020C14-2 S	MT14	14	20	16	M8	30.5	48	2	S14	K14

Toolholders

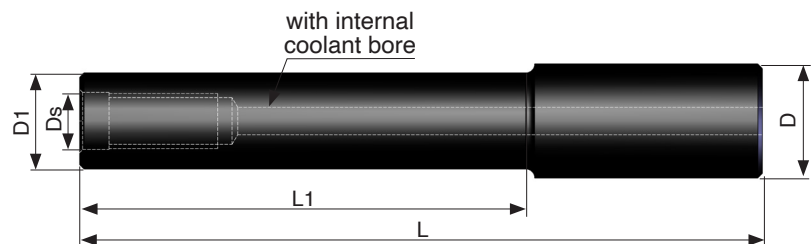


Ordering Code	Insert Type	Insert size A	D	D1	Ds	L1	L	No. of Inserts	Screw	Key
SR0025D21-1 S	MT21	21	25	19.7	M10	40	60	1	S21	K21



Ordering Code	Insert Type	Insert size		Y	D	D1	Ds	L1	L	No. of Inserts	Screw	Key
		L	I.C.									
SR0033D16U-3 S	16U	16U	3/8U	7.6	33	24	M12	40	60	3	S16	K16

Extensions



Ordering Code	D	D1	Ds	L	L1
E16 M08 L80	16	15	M08	80	30
E20 M10 L80	20	18	M10	80	30
E20 M10 L130	20	18	M10	130	80
E25 M12 L100	25	21	M12	100	50
E25 M12 L150	25	21	M12	150	100

Cutting Data

D-Thread type

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)
P	Low and Medium Carbon Steels <0.55%C	100 - 205
	High Carbon Steels ≥0.55%C	100 - 180
	Alloy Steels, Treated Steels	100 - 140
M	Stainless Steels - Free Cutting	85 - 125
	Stainless Steels - Austenitic	80 - 115
	Cast Steels	115 - 155
K	Cast Iron	75 - 145
N	Aluminum ≤12%Si, Copper	150 - 300
	Aluminum >12% Si	150 - 300
	Synthetics, Duroplastics, Thermoplastics	100 - 350
S	Nickel Alloys, Titanium Alloys	45 - 95

Recommended FEED RATE: 0.07 - 0.15 mm