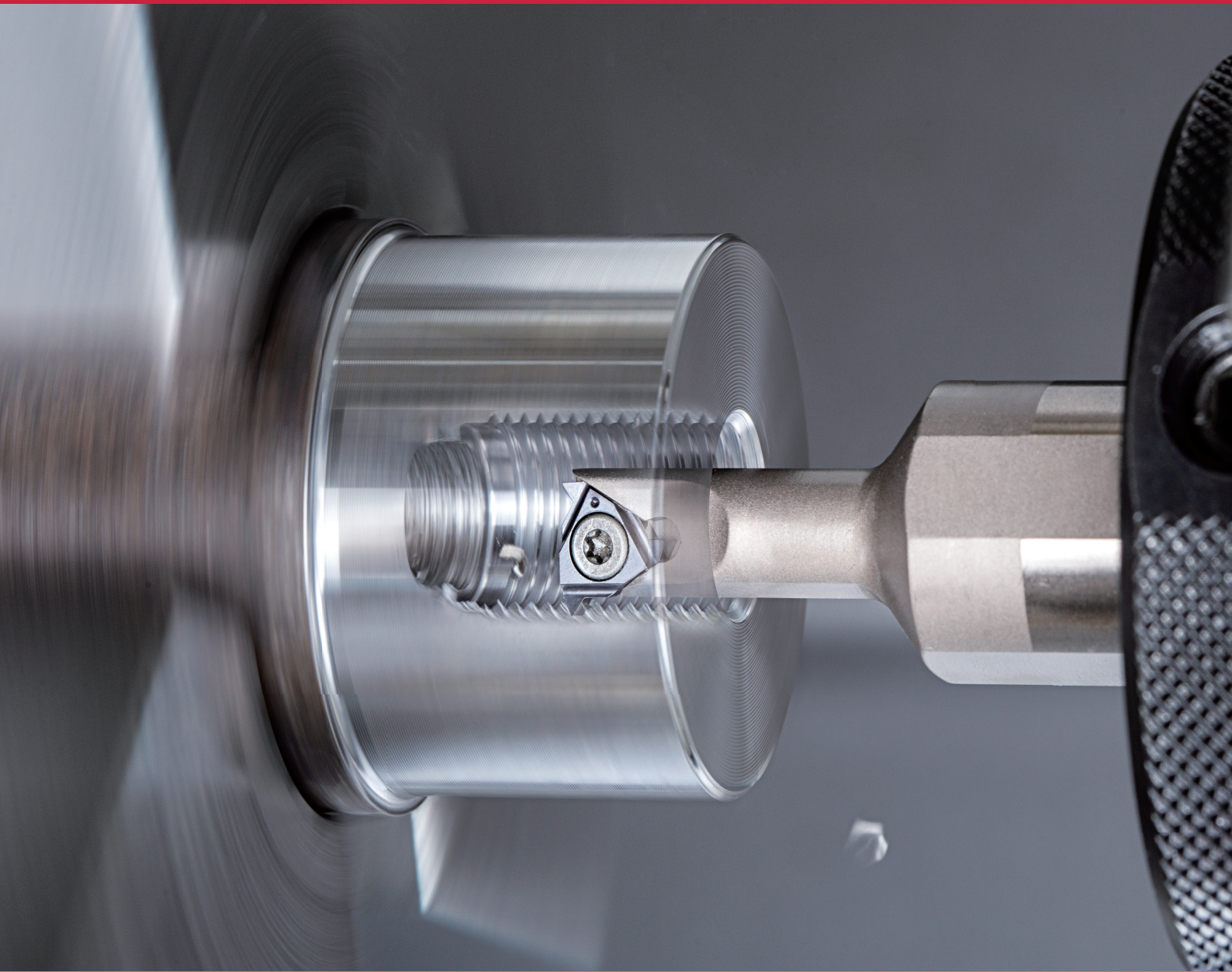


Expansion of insert & tool holder for small diameter internal threading





For more information

Efficient internal thread turning of small diameter holes!

New



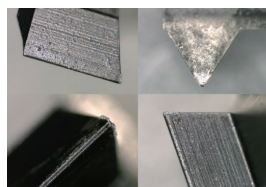
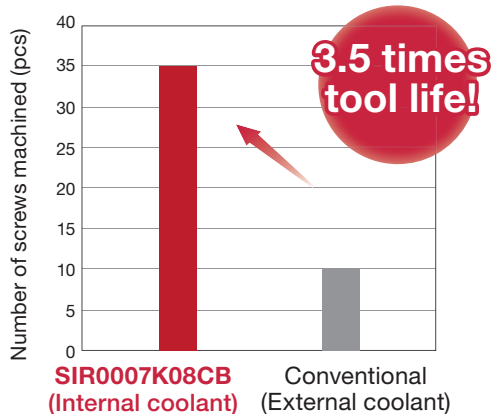
- Economical 3-edged insert
- For small holes in diameters 7.4 mm and larger
- Through-coolant holders are also available

Conventional

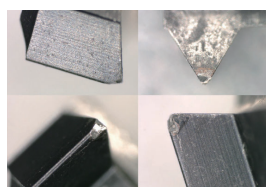


- Single-edged insert
- For hole diameters in 9.0 mm and larger
- No through-coolant

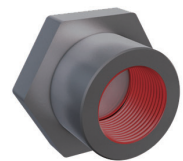
Cutting performance



SIR0007K08CB
(Internal coolant)
After 30 threaded



Conventional
After 10 threaded

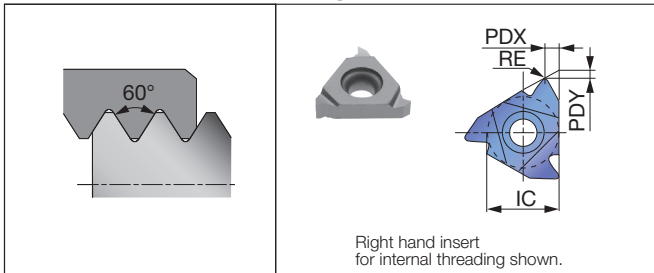


M	Holder	: SIR0007K08CB (Internal coolant)
	Insert	: 08IRA60 AH725
	Workpiece material	: SUS316L
	Cutting speed	: Vc = 60 m/min
	Pitch	: 0.75 mm
	Machining	: Internal threading
	Infeed method	: Radial infeed
	Coolant	: Wet

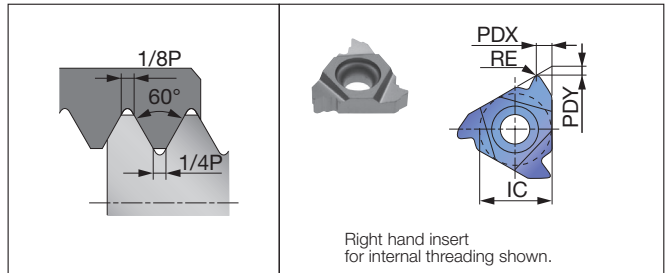
Standard cutting conditions

ISO	Workpiece materials	Hardness	Cutting speed Vc (m/min)	
			AH725	GH330
P	Carbon steel	< 200 HB	80 - 180	80 - 170
		> 200 HB	60 - 160	60 - 130
M	Stainless steel	-	50 - 130	70 - 120

60° thread angle



ISO metric



Partial-profile inserts

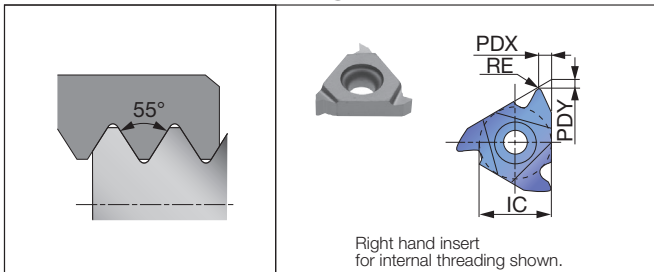
Insert size	Pitch	TPI	Hand of cut	Internal insert						
				Designation	Grades		IC	PDX	PDY	RE
					Coating					
					AH725	GH330				
06	0.5~1.25	48~20	R	06IRA60			4	0.6	0.6	0.04
08	0.5~1.5	48~16	R	08IRA60			5	0.7	0.6	0.04

Full-profile inserts

Insert size	Pitch	TPI	Hand of cut	Internal insert						
				Designation	Grades	IC	PDX	PDY	RE	
					Coating					
					AH725					
06	0.5	R	06IR05ISO	●	4	0.4	0.9	0.04		
06	0.75	R	06IR075ISO	●	4	0.5	0.6	0.05		
06	1	R	06IR10ISO	●	4	0.6	0.6	0.05		
06	1.25	R	06IR125ISO	●	4	0.6	0.6	0.07		
08	1	R	08IR10ISO	●	5	0.6	0.6	0.05		
08	1.25	R	08IR125ISO	●	5	0.7	0.7	0.07		
08	1.5	R	08IR15ISO	●	5	0.7	0.7	0.09		
08	1.75	R	08IR175ISO	●	5	0.8	0.6	0.1		

●: New / Package quantity = 5 pcs.

55° thread angle



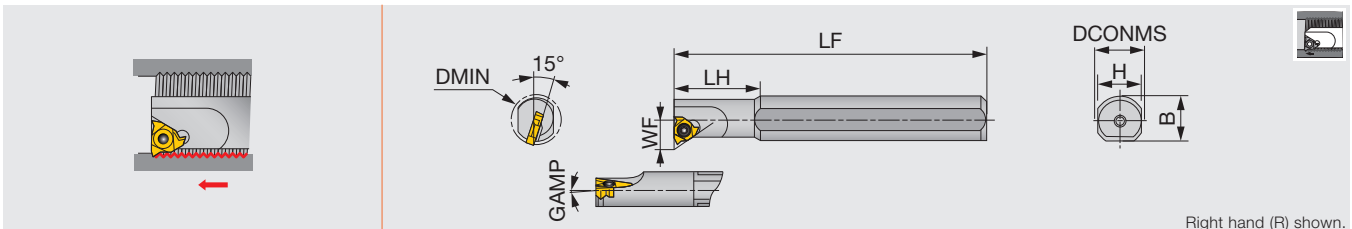
Partial-profile inserts

Insert size	Pitch	TPI	Hand of cut	Internal insert						
				Designation	Grades		IC	PDX	PDY	RE
					Coating					
					AH725	GH330				
06	0.5~1.25	48~20	R	06IRA55			4	0.5	0.5	0.05
08	0.5~1.5	48~16	R	08IRA55			5	0.7	0.6	0.05

New

SIR

Internal threading bars, Screw-on clamp



Designation	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMP	Coolant hole	Insert
SIR0005H06	STEEL	6.4	12	4.3	100	12	11	-	1.5°	Without	06IR...
SIR0007K08	STEEL	7.8	16	5.3	125	18	15	-	1.5°	Without	08IR...
SIR0005H06CB	CARBIDE	6.4	6	4.3	100	25	5	-	1.5°	With	06IR...
SIR0007K08CB	CARBIDE	8	8	5.3	125	30	7	-	1.5°	With	08IR...

Note: The right hand insert (**IR...type) is used for the right hand toolholders (SIR...type).
Recommend over 1 mm clearance between internal diameter of thread and each tools DMIN.

SPARE PARTS

Designation	Clamping screw	Wrench
SIR0005H06...	SR 14-552	T-6F-S
SIR0007K08...	SR 14-558	T-6F-S

Applicable thread size

Description	ISO metric	Unified IRA60 Insert	Parallel pipe IRA55 Insert
SIR0005H06...	≥ M9	≥ 3/8-24 UNF	≥ G1/8
SIR0007K08...	≥ M11	≥ 7/16-20 UNF	≥ G1/4

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