Spiral Mill - 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

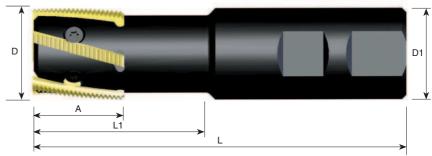
NPTF

ISO

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

Same insert for internal and external thread

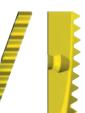
H32 Toolholder



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

Spiral inserts have one cutting edge



Pitch mm	Ordering Code	Thread Size		
1.5	H32 I 1.5 ISO	≥ M35		
2.0	H32 I 2.0 ISO	≥ M36		
3.0	H32 I 3.0 ISO	≥ M38		
4.0	H32 I 4.0 ISO	≥ M40		
For internal thread				

Mill - Thread Technical Section



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
	Low and Medium Carbon Steels	115-280
Ρ	High Carbon Steels	130-200
	Alloy Steels, Treated Steels	105-180
М	Stainless Steels	130-190
	Cast Steels	150-190
K	Cast Iron	80-170
N	Non- Ferrous and Aluminum	180-340
	Synthetics, Duroplastics, Thermoplastics	115-460
S	Nickel Alloys, Titanium Alloys	25- 90

Recommended FEED RATE : 0.05 - 0.15 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
	Low and Medium Carbon Steels	145-360
Ρ	High Carbon Steels	165-255
	Alloy Steels, Treated Steels	135-230
В Д	Stainless Steels	165-245
M	Cast Steels	190-245
K	Cast Iron	100-220
N	Non- Ferrous and Aluminum	230-440
	Synthetics, Duroplastics, Thermoplastics	145-590
S	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.