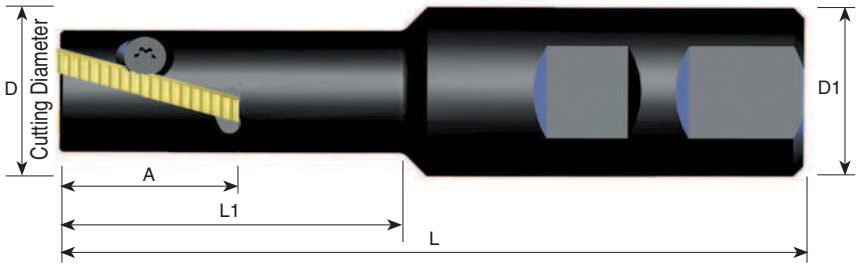
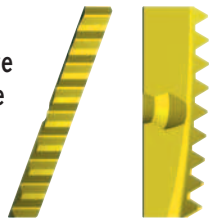
H23 Toolholder



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

Spiral inserts have one cutting edge



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”
20	H23 I 20 UN	≥ 1”
18	H23 I 18 UN	≥ 1 1/16”
16	H23 I 16 UN	≥ 1 1/16”
14	H23 I 14 UN	≥ 1 1/8”
12	H23 I 12 UN	≥ 1 1/8”
8	H23 I 8 UN	≥ 1 3/16”
7	H23 I 7 UN	≥ 1 1/4”

For internal thread

Whitworth

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

Same insert for internal and external thread

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
P	Low and Medium Carbon Steels	115-280
	High Carbon Steels	130-200
	Alloy Steels, Treated Steels	105-180
M	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
P	Low and Medium Carbon Steels	145-360
	High Carbon Steels	165-255
	Alloy Steels, Treated Steels	135-230
M	Stainless Steels	165-245
	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.