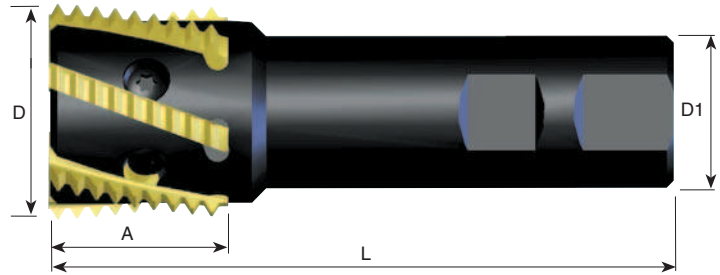


## H45 Toolholder



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

## H45 Threading Inserts

Spiral inserts have one cutting edge



### ISO

Pitch mm	Ordering Code	Thread Size
1.5	H45 I 1.5 ISO	≥ M50
2.0	H45 I 2.0 ISO	≥ M50
3.0	H45 I 3.0 ISO	≥ M56
4.0	H45 I 4.0 ISO	≥ M56

For internal thread

### UN

Pitch TPI	Ordering Code	Thread Size
16	H45 I 16 UN	≥ 2"
12	H45 I 12 UN	≥ 2"
8	H45 I 8 UN	≥ 2 1/4"
6	H45 I 6 UN	≥ 2 1/4"

For internal thread

## Whitworth

Pitch TPI	Ordering Code	Thread Size
11	H45 - 11 W	Internal ≥ G 1 3/4" External ≥ 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
<b>P</b>	Low and Medium Carbon Steels	115-280
	High Carbon Steels	130-200
	Alloy Steels, Treated Steels	105-180
<b>M</b>	Stainless Steels	130-190
	Cast Steels	150-190
<b>K</b>	Cast Iron	80-170
<b>N</b>	Non- Ferrous and Aluminum	180-340
	Synthetics, Duroplastics, Thermoplastics	115-460
<b>S</b>	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
<b>P</b>	Low and Medium Carbon Steels	145-360
	High Carbon Steels	165-255
	Alloy Steels, Treated Steels	135-230
<b>M</b>	Stainless Steels	165-245
	Cast Steels	190-245
<b>K</b>	Cast Iron	100-220
<b>N</b>	Non- Ferrous and Aluminum	230-440
	Synthetics, Duroplastics, Thermoplastics	145-590
<b>S</b>	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.