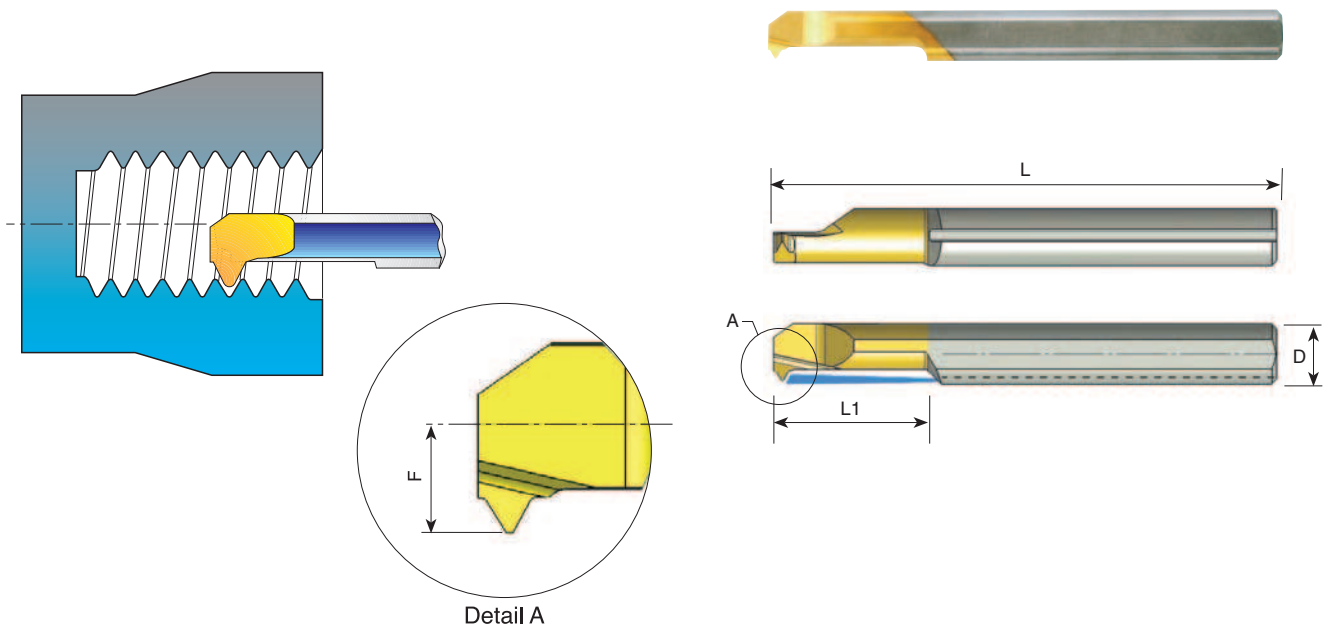


## MIR Bars Threading - with Coolant Channel



### Full Profile – ISO 60°

D	Ordering Code	Pitch mm	L	L1	F	Min. Bore Dia.	Holder*
3.0	<b>MIR 3 L15 0.5 ISO</b>	0.5	39	15	1.4	3.2	SIM 0020 H3
3.0	<b>MIR 3 L15 0.75 ISO</b>	0.75	39	15	1.4	3.2	SIM 0020 H3
4.0	<b>MIR 4 L15 0.5 ISO</b>	0.5	50	15	1.8	4.1	SIM 0020 H4
4.0	<b>MIR 4 L15 0.75 ISO</b>	0.75	50	15	1.8	4.1	SIM 0020 H4
5.0	<b>MIR 5 L15 1.0 ISO</b>	1.0	50	15	2.2	4.9	SIM 0020 H5
6.0	<b>MIR 6 L22 1.25 ISO</b>	1.25	50	22	2.8	6.1	SIM 0020 H6

Order example: MIR 5 L15 1.0 ISO BXC

### Full Profile – UN 60°

D	Ordering Code	Pitch TPI	L	L1	F	Min. Bore Dia.	Holder*
3.0	<b>MIR 3 L15 36 UN</b>	36	39	15	1.4	3.2	SIM 0020 H3
3.0	<b>MIR 3 L15 32 UN</b>	32	39	15	1.4	3.2	SIM 0020 H3
4.0	<b>MIR 4 L15 36 UN</b>	36	50	15	1.8	4.1	SIM 0020 H4
4.0	<b>MIR 4 L15 32 UN</b>	32	50	15	1.8	4.1	SIM 0020 H4
5.0	<b>MIR 5 L15 28 UN</b>	28	50	15	2.2	4.9	SIM 0020 H5
5.0	<b>MIR 5 L18 20 UN</b>	20	50	18	2.3	5.0	SIM 0020 H5

Order example: MIR 4 L15 36 UN BXC

For L.H. bars specify MIL instead of MIR

\* For additional holders see page 156

# Technical Section

Carbide Grade: **BXC (P30 - P50, K25 - K40)**

PVD TiN coated grade for low cutting speed, Works well with a wide range of stainless steels.

## Cutting speed for Tiny Tools

ISO Standard	Materials	Cutting Speed m/min
<b>P</b>	Low & Medium Carbon Steel	20-140
	High Carbon Steel	30-100
	Alloy Steels & Treated Steels	40- 90
<b>M</b>	Stainless Steels	20- 90
	Cast Steels	40- 90
<b>K</b>	Cast Iron	40-120
<b>N</b>	Non-Ferrous & Aluminium	50-120
<b>S</b>	Super alloy and Titanium	15- 30
<b>H</b>	Hard Materials	13- 30

**Recommended Feed Rate: 0.01 - 0.03 mm/rev**

## Threading Passes

Pitch:	mm	0.5	0.7	0.8	1.0	1.25	1.5
	TPI	48	36	32	24	20	16
Number of Passes		6-12	7-14	7-16	8-18	8-20	10-22