

# Spiral Mill-Thread



## Advantages of Spiral Mill-Thread Tools

- The spiral designed tools enable a smooth cutting operation at a high feed rate and reduced machining time.
- The tools suit a wide range of applications, from machining small components in small machining centers to heavy-duty applications in high power milling machines.
- Spiral fluted toolholders hold 2 to 9 inserts in a comparatively small cutting diameter.
- The unique clamping method enables optimal indexability.
- Spiral tools reduce vibration and chatter.
- High grade finish is achieved in all applications: threading, end milling roughing and finishing.
- Inserts are available in 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.

### Contents:

Product Identification	162
ISO	163
UN	164-165
Whitworth	165
BSPT	166
NPT	166
NPTF	167
NPS	167

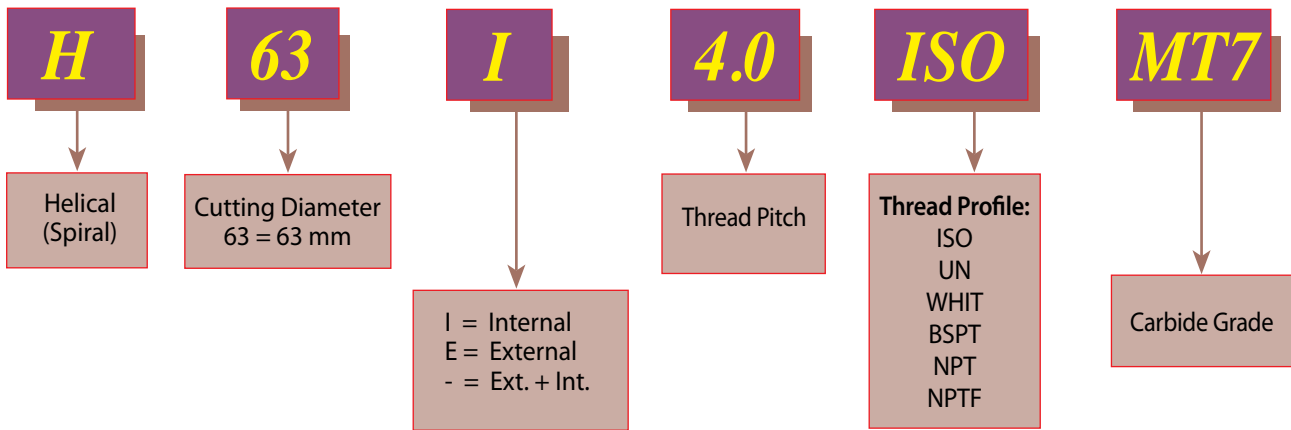
### Page:

### Contents:

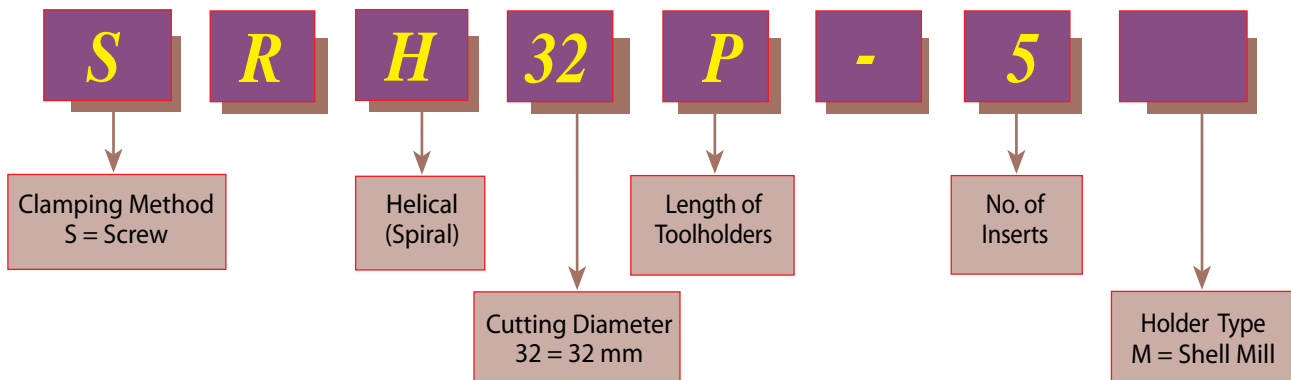
Spiral Finishing Inserts	168
Toolholders	169-170
Special Tools	171

## Product Identification - Ordering Codes

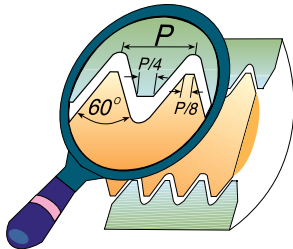
### Spiral-Mill Thread Inserts



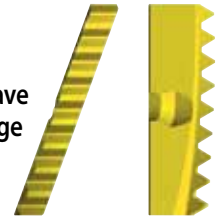
## Spiral-Mill Toolholders



## ISO

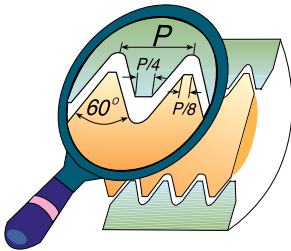


Spiral inserts have one cutting edge

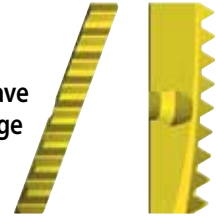


Insert Size	Pitch mm	Ext./ Int.	M coarse	M fine	Ordering code	Toolholder
H13	1.0	Int.		≥ 15	<b>H13 I 1.0 ISO</b>	SRH13...
	1.5	Int.		≥ 16	<b>H13 I 1.5 ISO</b>	
	2.0	Int.	M16	≥ 17	<b>H13 I 2.0 ISO</b>	
H15	1.0	Int.		≥ 17	<b>H15 I 1.0 ISO</b>	SRH15...
	1.5	Int.		≥ 18	<b>H15 I 1.5 ISO</b>	
	2.0	Int.		≥ 19	<b>H15 I 2.0 ISO</b>	
	2.5	Int.	M18	≥ 20	<b>H15 I 2.5 ISO</b>	
H17	1.0	Int.		≥ 19	<b>H17 I 1.0 ISO</b>	SRH17...
	1.5	Int.		≥ 20	<b>H17 I 1.5 ISO</b>	
	2.0	Int.		≥ 21	<b>H17 I 2.0 ISO</b>	
	2.5	Int.	M20, M22	≥ 22	<b>H17 I 2.5 ISO</b>	
H19	2.0	Int.		≥ 23	<b>H19 I 2.0 ISO</b>	SRH19...
	3.0	Int.	M24	≥ 25	<b>H19 I 3.0 ISO</b>	
H23	1.0	Ext.			<b>H23 E 1.0 ISO</b>	SRH23...
	1.0	Int.		≥ 25	<b>H23 I 1.0 ISO</b>	
	1.5	Ext.			<b>H23 E 1.5 ISO</b>	
	1.5	Int.		≥ 26	<b>H23 I 1.5 ISO</b>	
	2.0	Ext.			<b>H23 E 2.0 ISO</b>	
	2.0	Int.		≥ 27	<b>H23 I 2.0 ISO</b>	
	3.0	Ext.			<b>H23 E 3.0 ISO</b>	
	3.0	Int.	M27	≥ 29	<b>H23 I 3.0 ISO</b>	
H32	3.5	Int.	M30, M33	≥ 30	<b>H23 I 3.5 ISO</b>	SRH32...
	4.0	Int.	M36	≥ 31	<b>H23 I 4.0 ISO</b>	
	1.0	Int.		≥ 34	<b>H32 I 1.0 ISO</b>	
H32	1.5	Ext.			<b>H32 E 1.5 ISO</b>	SRH32...
	1.5	Int.		≥ 35	<b>H32 I 1.5 ISO</b>	
	2.0	Ext.			<b>H32 E 2.0 ISO</b>	
	2.0	Int.		≥ 36	<b>H32 I 2.0 ISO</b>	
	3.0	Ext.			<b>H32 E 3.0 ISO</b>	
	3.0	Int.		≥ 38	<b>H32 I 3.0 ISO</b>	
	3.5	Int.		≥ 39	<b>H32 I 3.5 ISO</b>	
	4.0	Ext.			<b>H32 E 4.0 ISO</b>	
	4.0	Int.	M39	≥ 40	<b>H32 I 4.0 ISO</b>	
	4.5	Int.	M42, M45	≥ 41	<b>H32 I 4.5 ISO</b>	
5.0	Int.	M48	≥ 42	<b>H32 I 5.0 ISO</b>		
H45	1.5	Ext.			<b>H45 E 1.5 ISO</b>	SRH45...
	1.5	Int.		≥ 48	<b>H45 I 1.5 ISO</b>	
	2.0	Ext.			<b>H45 E 2.0 ISO</b>	
	2.0	Int.		≥ 49	<b>H45 I 2.0 ISO</b>	
	3.0	Int.		≥ 51	<b>H45 I 3.0 ISO</b>	
	3.5	Int.		≥ 52	<b>H45 I 3.5 ISO</b>	
	4.0	Int.		≥ 53	<b>H45 I 4.0 ISO</b>	
	4.5	Int.		≥ 54	<b>H45 I 4.5 ISO</b>	
	5.0	Int.	M52	≥ 55	<b>H45 I 5.0 ISO</b>	
5.5	Int.	M56, M60	≥ 56	<b>H45 I 5.5 ISO</b>		
6.0	Int.	M64, M68	≥ 57	<b>H45 I 6.0 ISO</b>		
H63	1.5	Int.		≥ 66	<b>H63 I 1.5 ISO</b>	SRH63...
	2.0	Int.		≥ 67	<b>H63 I 2.0 ISO</b>	
	3.0	Int.		≥ 69	<b>H63 I 3.0 ISO</b>	
	4.0	Int.		≥ 71	<b>H63 I 4.0 ISO</b>	
	6.0	Int.		≥ 75	<b>H63 I 6.0 ISO</b>	

## UN

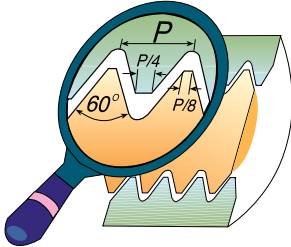


Spiral inserts have one cutting edge

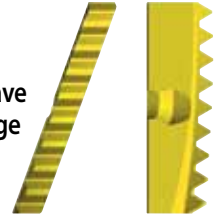


Insert Size	Pitch TPI	Ext./ Int.	UN	UNC	UNF	UNS	Ordering code	Toolholder
H13	16	Int.	5/8, 11/16				<b>H13 I 16 UN</b>	SRH13...
	14	Int.				5/8	<b>H13 I 14 UN</b>	
	12	Int.	11/16				<b>H13 I 12 UN</b>	
H15	16	Int.			3/4		<b>H15 I 16 UN</b>	SRH15...
	14	Int.				3/4	<b>H15 I 14 UN</b>	
	12	Int.	3/4, 13/16				<b>H15 I 12 UN</b>	
	10	Int.				7/8, 1	<b>H15 I 10 UN</b>	
H17	16	Int.	13/16 - 1				<b>H17 I 16 UN</b>	SRH17...
	14	Int.			7/8, 1		<b>H17 I 14 UN</b>	
	12	Int.	7/8				<b>H17 I 12 UN</b>	
	9	Int.		7/8			<b>H17 I 9 UN</b>	
H19	12	Int.	15/16		1		<b>H19 I 12 UN</b>	SRH19...
	8	Int.	1 1/16, 1 1/8	1			<b>H19 I 8 UN</b>	
H23	32	Int.	1			1 - 1 1/4	<b>H23 I 32 UN</b>	SRH23...
	24	Int.					<b>H23 I 24 UN</b>	
	20	Ext.					<b>H23 E 20 UN</b>	
	20	Int.	1 1/16 - 1 5/16				<b>H23 I 20 UN</b>	
	18	Ext.					<b>H23 E 18 UN</b>	
	18	Int.				1	<b>H23 I 18 UN</b>	
	16	Ext.					<b>H23 E 16 UN</b>	
	16	Int.	1 1/16 - 1 5/16				<b>H23 I 16 UN</b>	
	14	Ext.					<b>H23 E 14 UN</b>	
	14	Int.				≥1 1/8	<b>H23 I 14 UN</b>	
	12	Ext.					<b>H23 E 12 UN</b>	
	12	Int.	1 1/16 - 1 3/16		1 1/8		<b>H23 I 12 UN</b>	
	10	Ext.					<b>H23 E 10 UN</b>	
	10	Int.				≥1 1/8	<b>H23 I 10 UN</b>	
8	Ext.					<b>H23 E 8 UN</b>		
8	Int.	1 3/16 - 1 5/16				<b>H23 I 8 UN</b>		
7	Ext.					<b>H23 E 7 UN</b>		
7	Int.		1 1/4			<b>H23 I 7 UN</b>		
H28	12	Int.	1 5/16		1 1/4, 1 3/8		<b>H28 I 12 UN</b>	SRH28...
	8	Int.	1 3/8 - 1 7/16				<b>H28 I 8 UN</b>	
	6	Int.	1 3/8 - 1 9/16	1 1/2			<b>H28 I 6 UN</b>	
H32	24	Ext.				≥1 3/8	<b>H32 E 24 UN</b>	SRH32...
	20	Ext.					<b>H32 E 20 UN</b>	
	20	Int.	≥1 3/8				<b>H32 I 20 UN</b>	
	18	Ext.					<b>H32 E 18 UN</b>	
	18	Int.				≥1 3/4	<b>H32 I 18 UN</b>	
	16	Ext.					<b>H32 E 16 UN</b>	
	16	Int.	1 3/8 - 1 7/8				<b>H32 I 16 UN</b>	
	12	Ext.					<b>H32 E 12 UN</b>	
	12	Int.	1 7/16 - 1 7/8		1 1/2		<b>H32 I 12 UN</b>	
	8	Ext.					<b>H32 E 8 UN</b>	
	8	Int.	1 1/2 - 2				<b>H32 I 8 UN</b>	
6	Ext.					<b>H32 E 6 UN</b>		
6	Int.	1 5/8 - 1 7/8				<b>H32 I 6 UN</b>		
5	Int.		1 3/4			<b>H32 I 5 UN</b>		
H40	6	Int.	1 15/16, 2				<b>H40 I 6 UN</b>	SRH40...
	4.5	Int.		2			<b>H40 I 4.5 UN</b>	

## UN



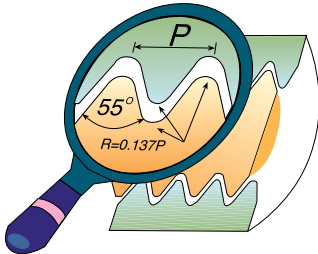
Spiral inserts have one cutting edge



Insert Size	Pitch TPI	Ext./ Int.	UN	UNC	UNF	UNS	Ordering code	Toolholder
H45	16	Int.	1 15/16 - 2 1/2			2 1/16 - 2	<b>H45 I 16 UN</b>	SRH45...
	12	Int.	1 15/16 - 2 5/8				<b>H45 I 12 UN</b>	
	8	Int.	2 1/8 - 2 5/8				<b>H45 I 8 UN</b>	
	6	Int.	2 1/8 - 2 3/4				<b>H45 I 6 UN</b>	
	4.5	Int.		2 1/4			<b>H45 I 4.5 UN</b>	
	4	Int.		2 1/2 - 2 3/4			<b>H45 I 4 UN</b>	
H63	16	Int.	≥ 2 5/8				<b>H63 I 16 UN</b>	SRH63...
	12	Int.	≥ 2 3/4				<b>H63 I 12 UN</b>	
	8	Int.	≥ 2 3/4				<b>H63 I 8 UN</b>	
	6	Int.	≥ 2 7/8				<b>H63 I 6 UN</b>	
	4	Int.		≥ 3			<b>H63 I 4 UN</b>	

## Whitworth

Same insert for internal and external thread



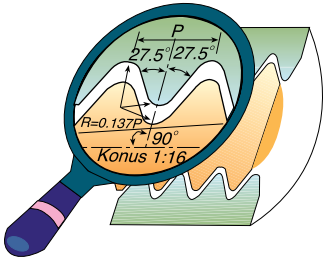
Spiral inserts have one cutting edge



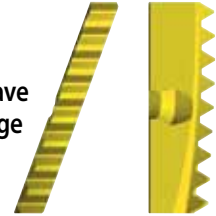
Insert Size	Pitch TPI	Ordering code	Thread Size	Toolholder
H13	19	<b>H13- 19 W</b>	G 3/8	SRH13...
H15	14	<b>H15- 14 W</b>	G 1/2	SRH15...
H17	14	<b>H17- 14 W</b>	G 1/2 - 5/8	SRH17...
	11	<b>H17- 11 W</b>	G ≥ 1"	
H19	14	<b>H19- 14 W</b>	G 3/4 - 7/8	SRH19...
	11	<b>H19- 11 W</b>	G ≥ 1"	
H23	14	<b>H23-14 W</b>	Int. G 7/8" Ext. ≥ G 1/2"	SRH23...
	11	<b>H23-11 W</b>	≥ G 1"	
H32	14	<b>H32-14 W</b>	Ext. ≥ G 1/2"	SRH32...
	11	<b>H32-11 W</b>	Int. ≥ G 1 1/8" Ext. ≥ G 1"	
H45	11	<b>H45-11 W</b>	Int. ≥ G 1 5/8" Ext. ≥ G 1"	SRH45...
H63	11	<b>H63-11 W</b>	Int. ≥ G 2 3/8" Ext. ≥ G 1"	SRH63...

## BSPT

Same insert for internal and external thread



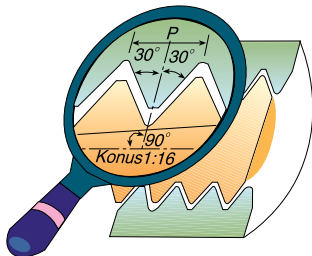
Spiral inserts have one cutting edge



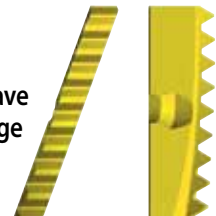
Insert Size	Pitch TPI	Ordering code	Thread Size	Toolholder
H13	19	<b>H13- 19 BSPT</b>	3/8	SRH13...
H15	14	<b>H15- 14 BSPT</b>	1/2 - 3/4	SRH15...
H17	14	<b>H17- 14 BSPT</b>	1/2 - 3/4	SRH17...
H23	11	<b>H23-11 BSPT</b>	≥ 1"	SRH23...
H32	11	<b>H32-11 BSPT</b>	Int. ≥ 1 1/8" Ext. ≥ 1"	SRH32...
H45	11	<b>H45-11 BSPT</b>	Int. ≥ 1 3/4" Ext. ≥ 1"	SRH45...
H63	11	<b>H63-11 BSPT</b>	Int. ≥ 2 1/2" Ext. ≥ 1"	SRH63...

## NPT

Same insert for internal and external thread



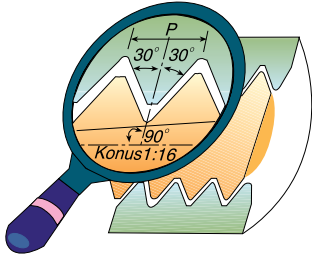
Spiral inserts have one cutting edge



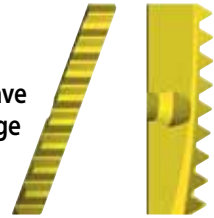
Insert Size	Pitch TPI	Ordering code	Thread Size	Toolholder
H13	18	<b>H13-18 NPT</b>	3/8	SRH13...
H15	14	<b>H15-14 NPT</b>	1/2 - 3/4	SRH15...
H17	14	<b>H17-14 NPT</b>	1/2 - 3/4	SRH17...
H23	11.5	<b>H23-11.5 NPT</b>	1" - 2"	SRH23...
H32	11.5	<b>H32-11.5 NPT</b>	Int. 1 1/4" - 2" Ext. 1" - 2"	SRH32...
H45	11.5	<b>H45-11.5 NPT</b>	Int. ≥ 1 5/8" Ext. ≥ 1"	SRH45...
	8	<b>H45- 8 NPT</b>	≥ 2 1/2"	
H63	11.5	<b>H63-11.5 NPT</b>	Ext. 1-2"	SRH63...
	8	<b>H63- 8 NPT</b>	≥ 3"	

## NPTF

Same insert for internal and external thread



Spiral inserts have one cutting edge



Insert Size	Pitch TPI	Ordering code	Thread Size	Toolholder
H13	18	<b>H13-18 NPTF</b>	3/8	SRH13...
H15	14	<b>H15-14 NPTF</b>	1/2 - 3/4	SRH15...
H17	14	<b>H17-14 NPTF</b>	1/2 - 3/4	SRH17...
H23	11.5	<b>H23-11.5 NPTF</b>	1"-2"	SRH23...
H32	11.5	<b>H32-11.5 NPTF</b>	Int. 1 1/4"-2" Ext. 1" -2"	SRH32...

## NPS

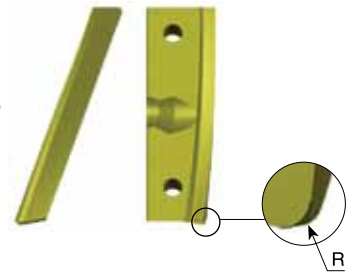
Same insert for internal and external thread



Insert Size	Pitch TPI	Ordering code	Thread Size	Toolholder
H13	18	<b>H13- 18 NPS</b>	3/8	SRH13...
H15	14	<b>H15- 14 NPS</b>	1/2 - 3/4	SRH15...
H17	14	<b>H17- 14 NPS</b>	1/2 - 3/4	SRH17...

## Spiral Finishing Inserts

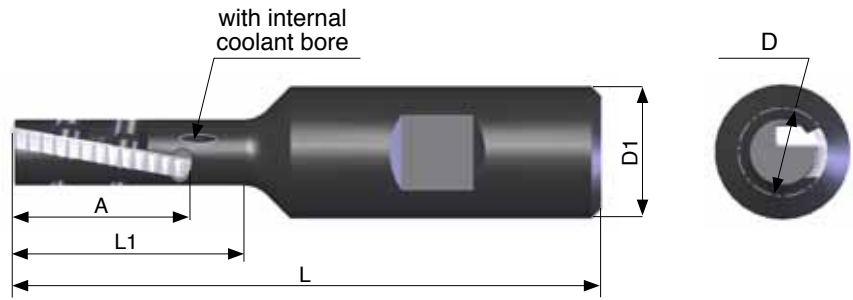
Spiral inserts have one cutting edge



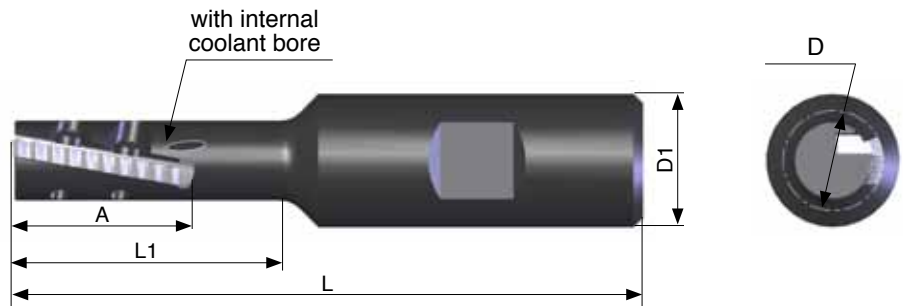
Insert Size	R	Ordering code	Toolholder
H23	0.2	H23 F R 0.2	SRH23...
	0.5	H23 F R 0.5	
	1.0	H23 F R 1.0	
H32	0.2	H32 F R 0.2	SRH32...
	0.5	H32 F R 0.5	
	1.0	H32 F R 1.0	
H45	0.2	H45 F R 0.2	SRH45...
	0.5	H45 F R 0.5	
	1.0	H45 F R 1.0	
	1.5	H45 F R 1.5	
	2.0	H45 F R 2.0	
H63	0.2	H63 F R 0.2	SRH63...
	0.5	H63 F R 0.5	
	1.0	H63 F R 1.0	
	1.5	H63 F R 1.5	
	2.0	H63 F R 2.0	



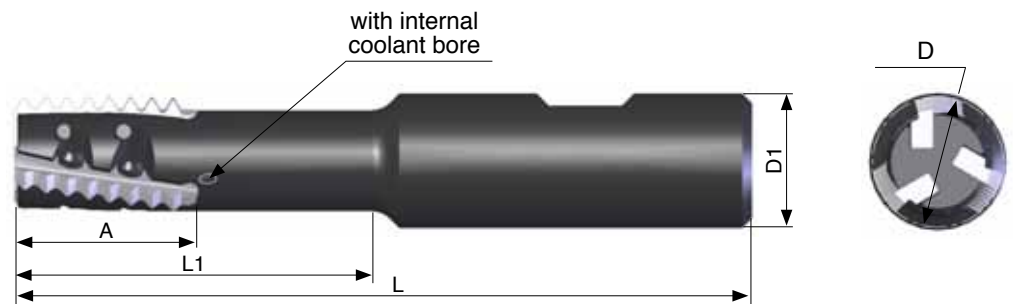
## Toolholders



Ordering Code	Insert size A	D	D1	L1	L	No. of Inserts	Screw	Key
<b>SRH13-1</b>	27	13	20	35	90	1	S13	K16

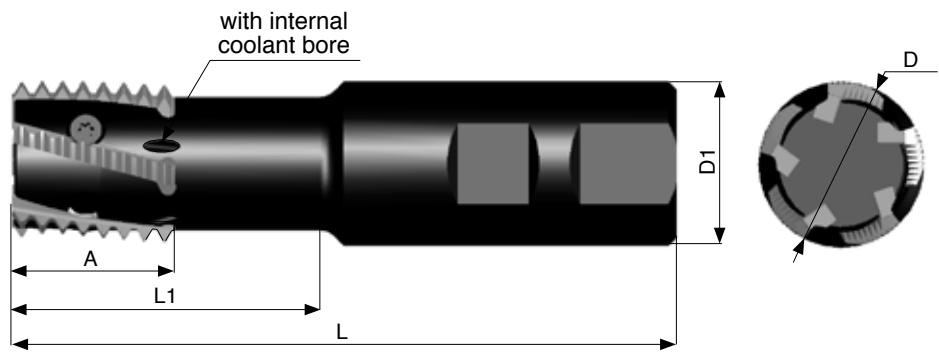


Ordering Code	Insert size A	D	D1	L1	L	No. of Inserts	Screw	Key
<b>SRH15-1</b>	27	15	20	40	95	1	S15	K16

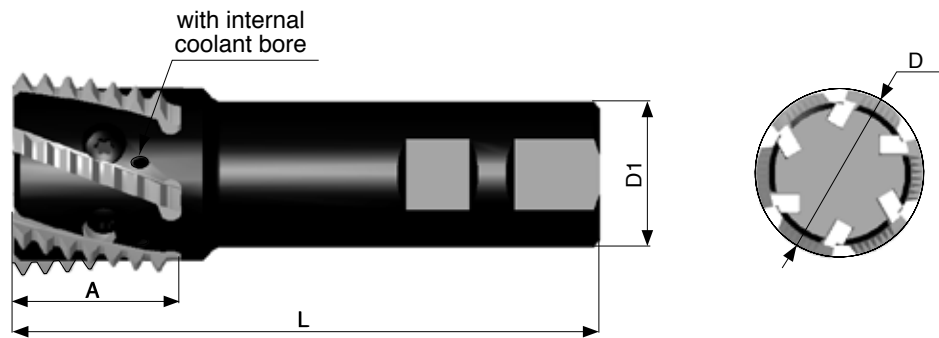


Ordering Code	Insert size A	D	D1	L1	L	No. of Inserts	Screw	Key
<b>SRH17-2</b>	27	17	20	45	100	2	S17	K16
<b>SRH19-3</b>	27	19	20	55	110	3	S19	K16

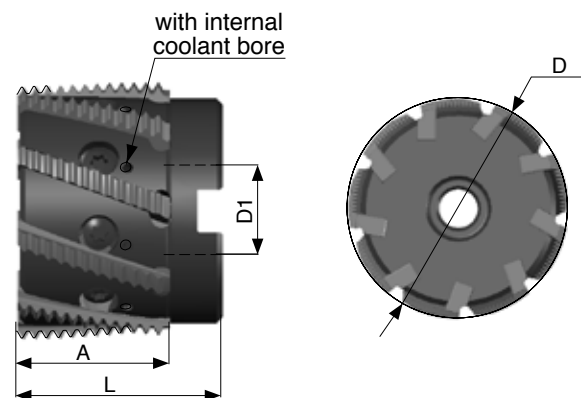
# Spiral Mill - Thread Toolholders



Ordering Code	Insert Type	Insert size A	D	D1	L	L1	No. of Inserts	Screw	Key
<b>SRH23-2</b>	H23	27	23	25	110	50	2	S23	K21
<b>SRH23M-2</b>	H23	27	23	25	150	75	2	S23	K21
<b>SRH28-3</b>	H28	32	28	32	150	75	3	S32S	K22
<b>SRH32-5</b>	H32	32	32	32	130	60	5	S32	K22
<b>SRH32P-5</b>	H32	32	32	32	-	90	5	S32	K22



Ordering Code	Insert Type	Insert size A	D	D1	L	No. of Inserts	Screw	Key
<b>SRH40-4</b>	H40	37	40	32	180	4	S45S	K40
<b>SRH45-6</b>	H45	37	45	32	130	6	S45	K40



Ordering Code	Insert Type	Insert size A	D	D1	L	No. of Inserts	Screw	Key
<b>SRH32-5M</b>	H32	32	32	16	52	5	S32S	K22
<b>SRH45-6M</b>	H45	37	45	22	60	6	S45S	K40
<b>SRH63-9M</b>	H63	38	63	22	50	9	S63S	K40

**MT7** Inserts are available in MT7 Sub-Micron Grade with Titanium Aluminium Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials.

## Special Tools

In addition to standard products, Carmex manufactures special tools and inserts according to customers' requests. The toolholders are multi-purpose, making them suitable for both roughing and finishing inserts. Special tools are supplied in short delivery times.

