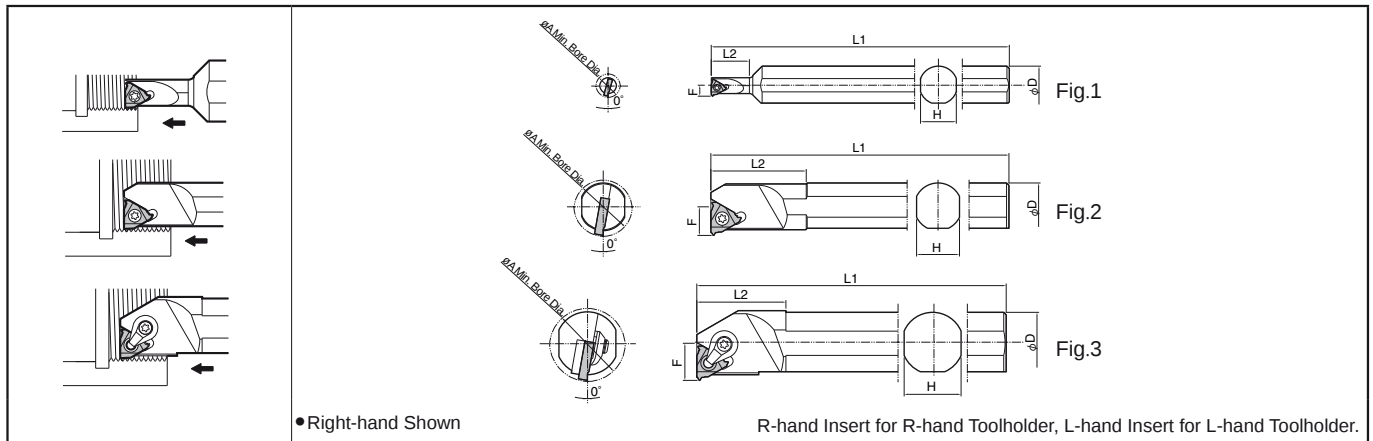


Internal Threading Toolholders

SIN / CIN



Toolholder Dimensions

Description		Std.		Min. Bore Dia.	Dimension (mm)					Drawing	Spare Parts					Applicable Inserts	
		R	L		øA	øD	H	L1	L2		F	Clamp Screw	Clamp Set	Wrench	Shim		Shim Screw
																	
SIN [®] /L	0612S-06E	●		6.4	12	11	100	10	3.8	Fig.1	SB-2040TR	-	FT-6	-	-	06 I [®] /L...	
	0816S-08E	●		7.8	16	15	125	16	4.0		SB-2050TR	-	FT-6	-	-	08 I [®] /L...	
	1216S-11E	●	●	12	16	14	150	25	6.3		SB-2TR	-	FT-8	-	-	11 I [®] /L...	
	1516S-11	●	●	15				30	7.5								
	2016S-16	●	●	20	16	14	150	37	10.0	Fig.2	SB-3.5TR	-	FT-15	-	-	16 I [®] /L...	
	2420S-16	●	●	24	20	18	180	40	12.0		SB-4085TR	-	FT-15	-	-	22 I [®] /L...	
	2420S-22	●		24	20	18	180	40	13.5								
CIN [®] /L	3025S-16	●	●	30	25	23	200	36	15.0	Fig.3	-	CPS-5S	FT-15	TN-32	SP3X8	16 I [®] /L...	
	3732S-16	●		37	32	30	250	45	18.5		-	CPS-6S	LW-3	TN-43	SP3X8	22 I [®] /L...	
	3025S-22	●		30	25	23	200	40	16.5								
	3732S-22	●		37	32	30	250	45	20								

Reference page for applicable inserts

Type of Thread	Full Profile	Partial Profile	Type of Thread	Full Profile	Partial Profile
M: Metric	J7	J13	Rc(PT) (BSPT) Tapered Pipe	J11	J15
UN: Unified	J9	J13	W: Whitworth	J9	J15
UNF: Unified Fine Thread			NPT	J11	-
G (PF): Parallel Pipe	J9	J15	Tr: 30°Trapezoidal	-	J15

Guide for Internal Threading

For the internal threading, pay extra attention to "Stabilizing Bore Dia." and "chip evacuation".

1 "Stabilizing Bore Dia."

Because small pitch internal threading has small corner-R(re), there is variation in the Bore Dia. which may greatly influence the tool life of an insert. In order to eliminate the variation in the Bore Dia., "0" cutting (zero cutting) should be performed as the zero pass, before the first pass in threading. The Bore Dia. is cut with the specified dimension, and the first pass of threading becomes stable.

2 "Chip evacuation"

If cutting process is continued when chips are tangled with a holder and other parts of the machine, it may cause damages to the insert. Therefore, please confirm if there are no tangled chips in the machine by the following method.

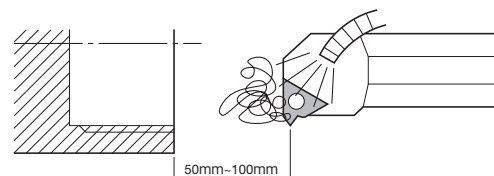
<When processing the first work piece>

Move the program with the single block.

Keep the threading starting point 50mm~100mm away from the side of workpiece, and confirm that coolant is flushing down the chips for each pass.

<When processing the second workpiece and later>

Confirm that chips are not tangled; then, execute continuous run.



● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)