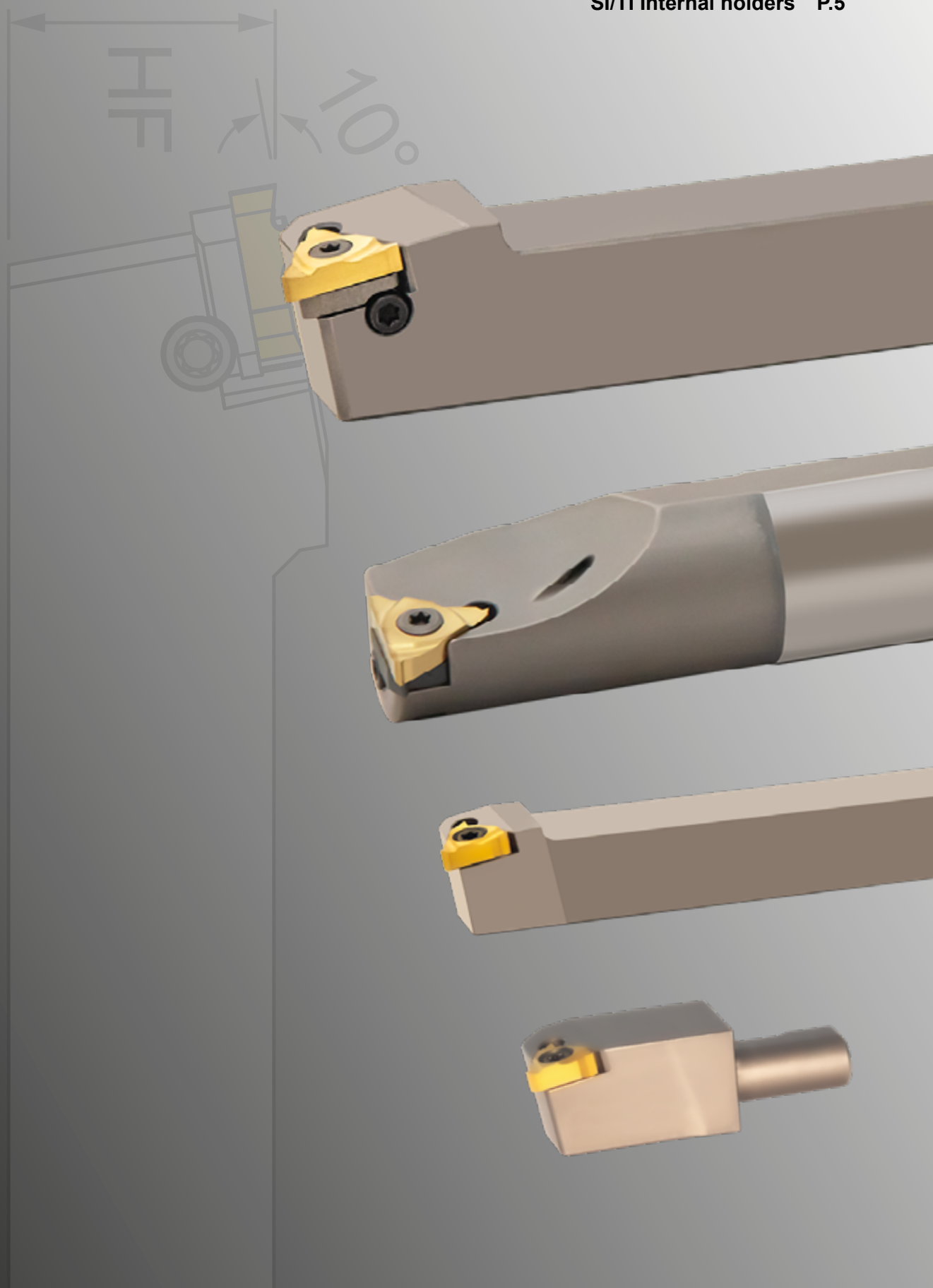


# THREADING HOLDERS



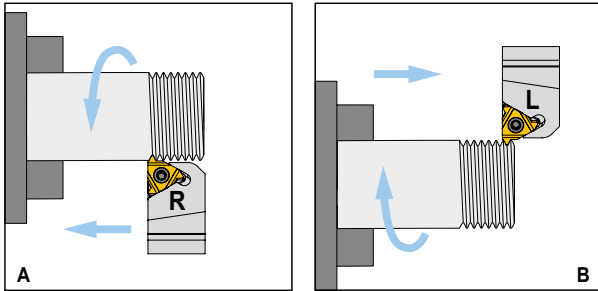
Threading holder information	P.2
SE/TE External holders	P.3
SE-S Swiss auto type holders	P.4
SI/TI Internal holders	P.5



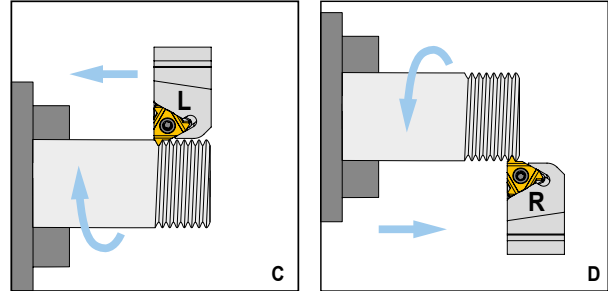


## THREADING INFORMATION

EXTERNAL RIGHT HAND THREADING OPERATION

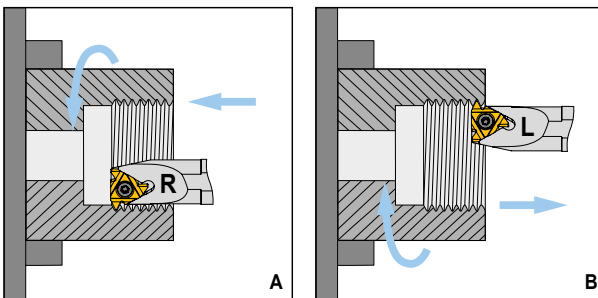


EXTERNAL LEFT HAND THREADING OPERATION

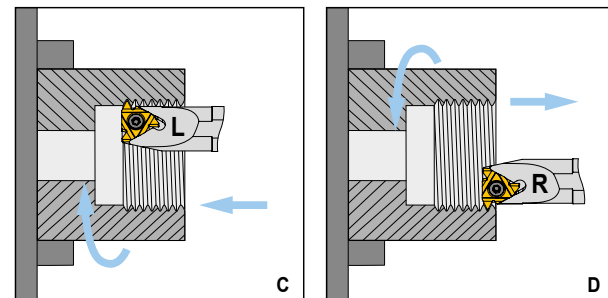


For illustrations B and D, negative shim must be used. This method cannot be used for tools with no shim.

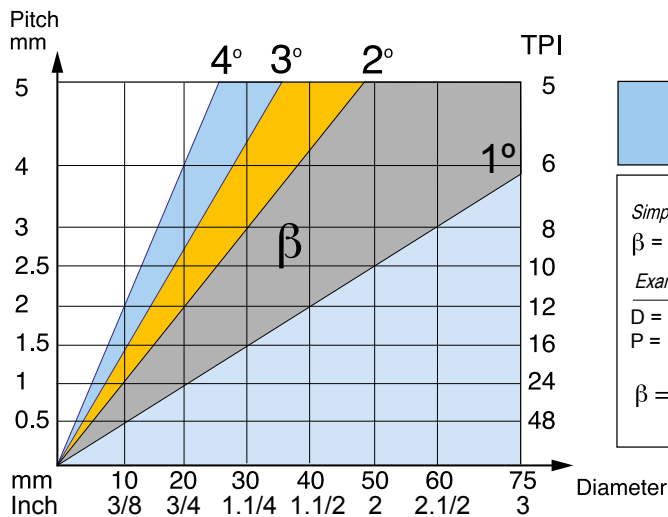
INTERNAL RIGHT HAND THREADING OPERATION



INTERNAL LEFT HAND THREADING OPERATION



For illustrations B and D, negative shim must be used. This method cannot be used for tools with no shim.

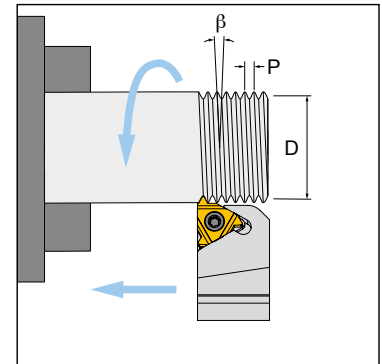


## THREAD HELIX ANGLE

$$\tan \beta = \frac{P}{\pi \times D}$$

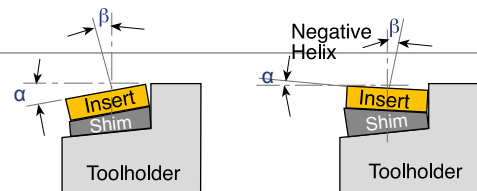
Simplified Formula  
 $\beta = 18.2 P/D$

Example:  
 $D = 25 \text{ mm (0.98")}$   
 $P = 1.5 \text{ mm (16 TPI)}$   
 $\beta = \frac{18.2 \times 1.5}{25} = 1.09^\circ$



## ALTERNATIVE SHIMS

Threading tool insert seats are produced with 1.5° helix angle as standard. If a different helix angle is required it will be necessary to change the shim. Shims with negative helix angle are for producing left-hand threads with right-hand tools.

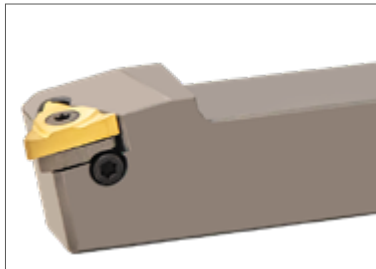


INSERT SIZE	TOOL TYPE	INSERT SEAT ANGLE						
		4.5°	3.5°	2.5°	1.5°	0.5°	-0.5°	-1.5°
16 (3/8)	EXT RH or INT LH	HTS16E4.5	HTS16E3.5	HTS16E2.5	HTS16E	HTS16E0.5	HTS16E-0.5	HTS16E-1.5
16 (3/8)	EXT LH or INT RH	HTS16I4.5	HTS16I3.5	HTS16I2.5	HTS16I	HTS16I0.5	HTS16I-0.5	HTS16I-1.5
22 (1/2)	EXT RH or INT LH	HTS22E4.5	HTS22E3.5	HTS22E2.5	HTS22E	HTS22E0.5	HTS22E-0.5	HTS22E-1.5
22 (1/2)	EXT LH or INT RH	HTS22I4.5	HTS22I3.5	HTS22I2.5	HTS22I	HTS22I0.5	HTS22I-0.5	HTS22I-1.5

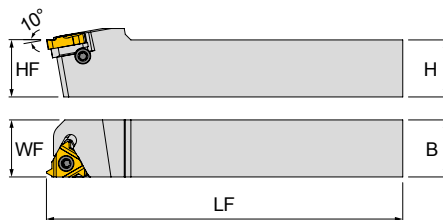
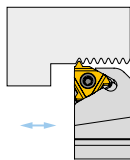



## EXTERNAL HOLDERS

**SER/L**  
**TER/L**



Right hand holder shown



Insert	
	11ER/L 16ER/L 22ER/L

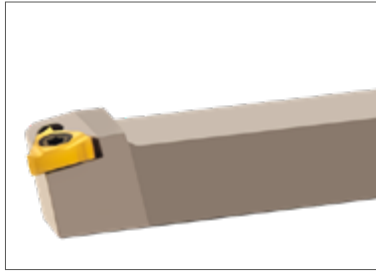
EDP Code	Description	H	HF	B	LF	WF	Insert	Right Shim	Left Shim	Shim Screw	Washer	Insert Screw	Wrench
THH0016	<b>SER/L 1010 E11</b>	10	10	10	70	11	11ER/L	-	-	-	-	TXS2506	TXW08
THH0017	<b>SER/L 1212 F11</b>	12	12	12	80	12							
THH0018	<b>SER/L 1616 H11</b>	16	16	16	100	16							
THH0019	<b>SER/L 2020 H11</b>	20	20	20	100	20							
THH0001	<b>TER/L 1616 H16</b>	16	16	16	100	16	16ER/L	HTS16E	HTS16I	TXS4045	TTBR-4	TXS40122	TXW10
THH0002	<b>TER/L 2020 K16</b>	20	20	20	125	20							
THH0003	<b>TER/L 2525 M16</b>	25	25	25	150	25							
THH0020	<b>TER/L 3232 P16</b>	32	32	32	170	32							
THH0004	<b>TER/L 2525 M22</b>	25	25	25	150	25	22ER/L	HTS22E	HTS22I	TXS3255	TTBR-5	TXS3215	TXW20F
THH0005	<b>TER/L 3232 P22</b>	32	32	32	170	32							
THH0021	<b>TER/L 4040 S22</b>	40	40	40	250	40							

To order left hand add L to EDP code. Example: SEL 1010 E11 = THH0016L

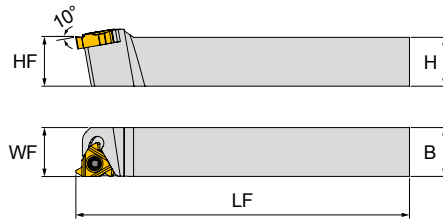
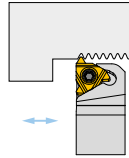


## EXTERNAL HOLDERS FOR AUTOMATIC LATHES

### SER/L



Right hand holder shown



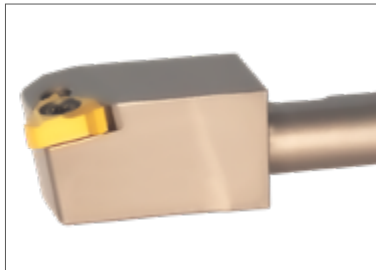
Insert	
	11ER/L
	16ER/L

EDP Code	Description	H	HF	B	LF	WF	Insert	Right Shim	Left Shim	Shim Screw	Washer	Insert Screw	Wrench
THH0022	<b>SER/L 1010 K11-S</b>	10	10	10	125	10	11ER/L	-	-	-	-	TXS2506	TXW08
THH0023	<b>SER/L 1212 K11-S</b>	12	12	12	125	12		-	-	-	-	TXS2506	TXW08
THH0034	<b>SER/L 1212 K16-S</b>	12	12	12	125	12	16ER/L	HTS16RL		HSAV35.1	-	TXS3514	TXW15

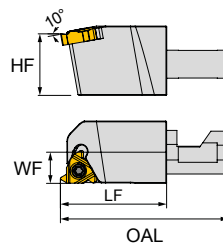
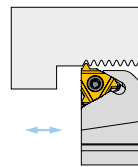
To order left hand add L to EDP code. Example: SEL 1010 K11-S = THH0022L

## EASY CHANGE HOLDERS FOR AUTOMATIC LATHES

### SER/L



Repeatability ±0.01mm. Right hand holder shown



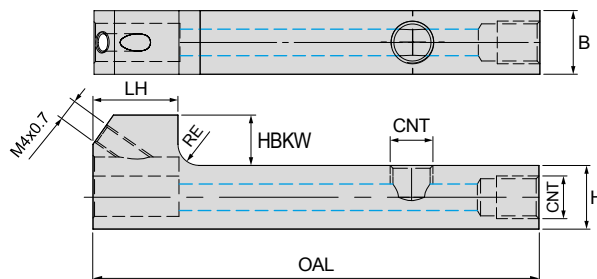
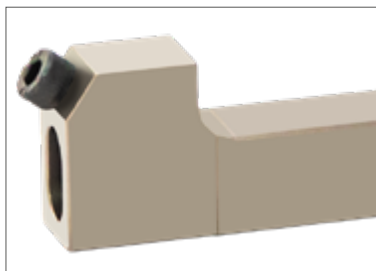
Insert	
	11ER/L

EDP Code	Description	HF	WF	LF	OAL	Insert	Insert Screw	Wrench
THH0014	<b>SER/L 12-11</b>	11.8	8	27.3	43.3	11ER/L	TXS2506	TXW08
THH0015	<b>SER/L 16-11</b>	15.8	8	27.3	43.3			

To order left hand add L to EDP code. Example: SEL 12-11 = THH0014L

### MSTB-EC

#### Through Coolant holder



EDP Code	Description	H	B	RE	HBKW	LH	OAL	CNT	Screw	Set Screw
TTH0234	<b>MSTB 1212-EC</b>	12	12	4	9.5	16	84	M8 x 1.0	M4X12IMC	HXS0805
TTH0235	<b>MSTB 1616-EC</b>	16	16	1	5.5	16	90			

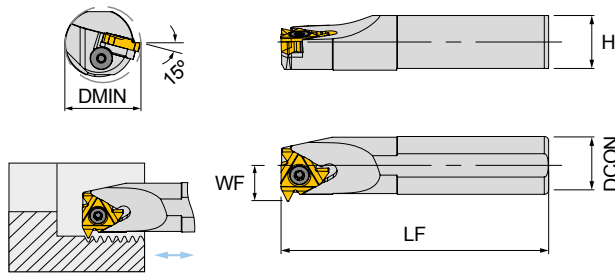


## INTERNAL HOLDERS

**SIR/L**  
**TIR/L**



Right hand holder shown



Insert



11IR/L  
16IR/L  
22IR/L

EDP Code	Description	⚡	DCON	LF	WF	DMIN	Insert	Right Shim	Left Shim	Shim Screw	Washer	Insert Screw	Wrench
THH0006	<b>SIR/L S10H 11</b>	<b>x</b>	10	100	7.4	12	11IR/L	-	-	-	-	TXS2506	TXW08
THH0007	<b>SIR/L S12K 11</b>	<b>x</b>	12	125	8.4	16		-	-	-	-	-	-
THH0008	<b>SIR/L S16M 11</b>	<b>x</b>	16	150	11.7	19		-	-	-	-	-	-
THH0009	<b>SIR/L S16M 16</b>	<b>x</b>	16	150	11.7	19	16IR/L	-	-	-	-	TXS3511	TXW15
THH0010	<b>SIR/L S20P 16</b>	<b>x</b>	20	170	13.7	24		-	-	-	-	-	-
THH0033	<b>TIR/L A20P 16</b>	💧	20	170	18	24	16IR/L						
THH0030	<b>TIR/L A25R 16</b>	💧	25	200	16.2	29		HTS16E	HTS16I	TXS4045	TTBR-4	TXS40122	TXW10
THH0031	<b>TIR/L A32S 16</b>	💧	32	250	19.7	36							
THH0032	<b>TIR/L A40T 16</b>	💧	40	300	23.7	44							
THH0011	<b>TIR/L S25R 16</b>	<b>x</b>	25	200	16.2	29	16IR/L	HTS16E	HTS16I	TXS4045	TTBR-4	TXS40122	TXW10
THH0025	<b>TIR/L S32S 16</b>	<b>x</b>	32	250	19.7	36							
THH0026	<b>TIR/L S40T 16</b>	<b>x</b>	40	300	23.7	44							
THH0027	<b>TIR/L S50U 16</b>	<b>x</b>	50	350	28.7	54							
THH0012	<b>TIR/L S25R 22</b>	<b>x</b>	25	200	18.1	29	22IR/L						
THH0013	<b>TIR/L S32S 22</b>	<b>x</b>	32	250	21.6	38		HTS22E	HTS22I	TXS3255	TTBR-5	TXS3215	TXW20F
THH0028	<b>TIR/L S40T 22</b>	<b>x</b>	40	300	25.6	46							
THH0029	<b>TIR/L S50U 22</b>	<b>x</b>	50	350	30.5	58							

To order left hand add L to EDP code. Example: SIL S10H 11 = THH0006L