

TUNGTHREAD

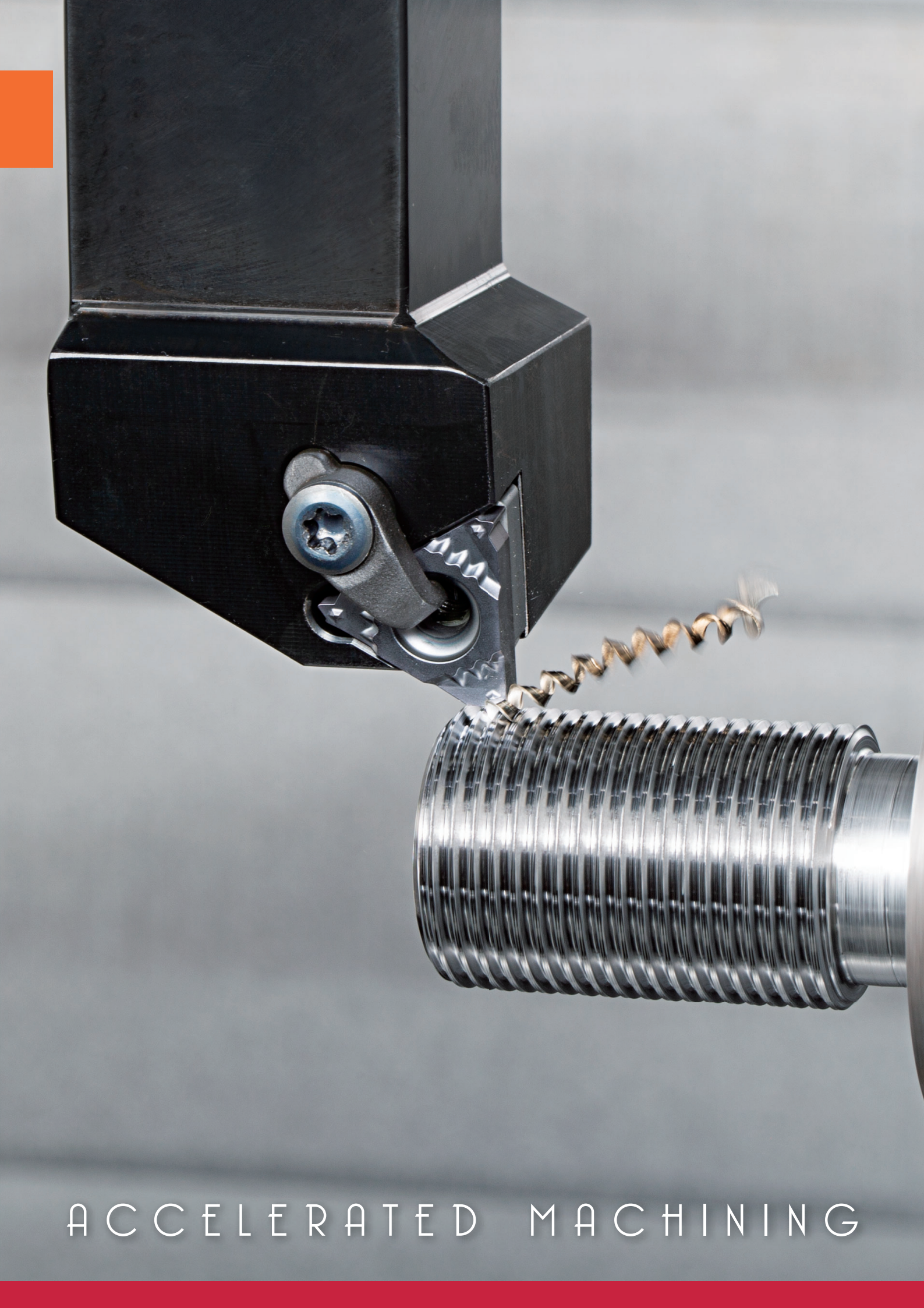
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Tungaloy Report No. 375S1-US

Expansion with high pressure internal coolant external threading tool holder



INDUSTRY 4.0
FEED the SPEED!



ACCELERATED MACHINING

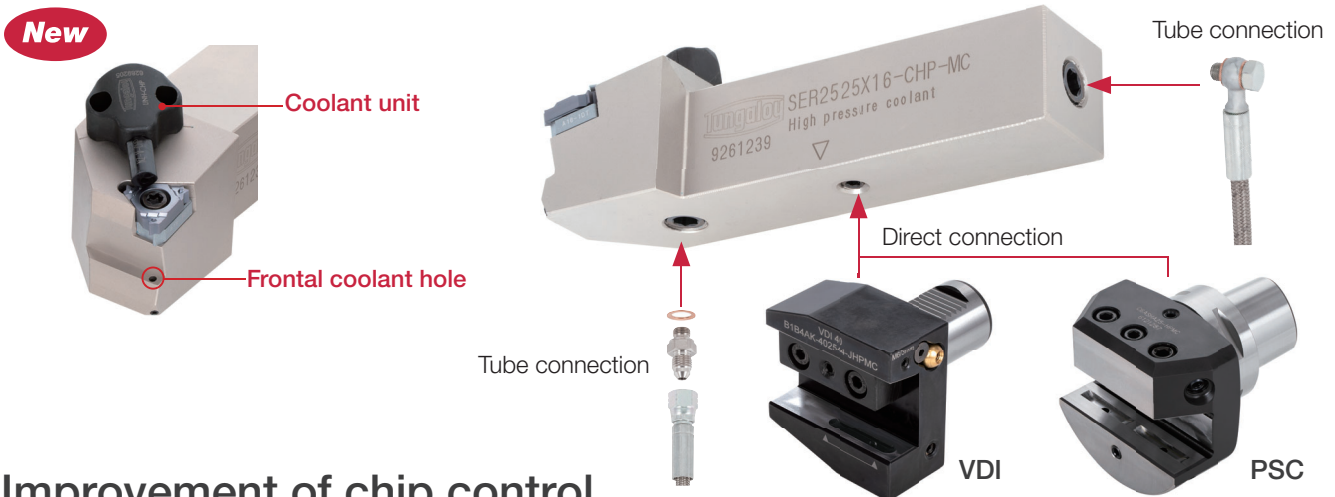


Expansion internal coolant tool holder



For more information

- Optimized two streams of high-pressure coolant jets to maximize productivity
- Applicable direct connection with tube free



Improvement of chip control

P Alloy steel:
External threading

Tool holder : SER2525X16-CHP-MC
Insert : 16ER15ISO AH725
Cutting speed : $V_c = 490$ sfm
Pitch : $P = 0.059''$
Infeed method : Radial infeed (6 pass)

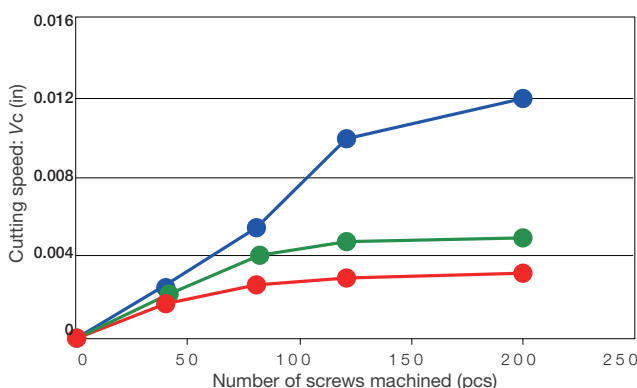
	1 pass	2 pass	3 pass	4 pass	5 pass	6 pass
Internal Coolant 7 MPa						
Internal Coolant 1 MPa						
External coolant						

Good chip, avoid jamming

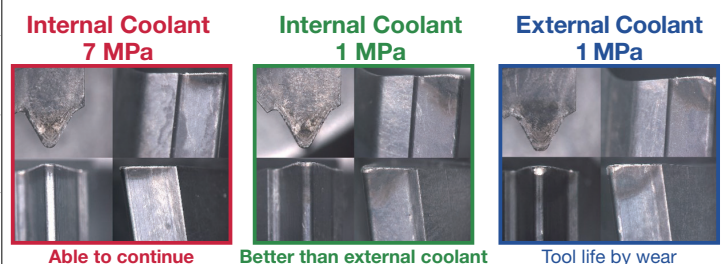
Improvement of tool life

M Stainless steel:
External threading
(304SS)

Material : 304SS
Holder : SER2525X16-CHP-MC
Insert : 16ER15ISO AH725
Cutting speed : $V_c = 390$ sfm
Pitch : $P = 0.059''$
Infeed method : Radial infeed (6 pass)

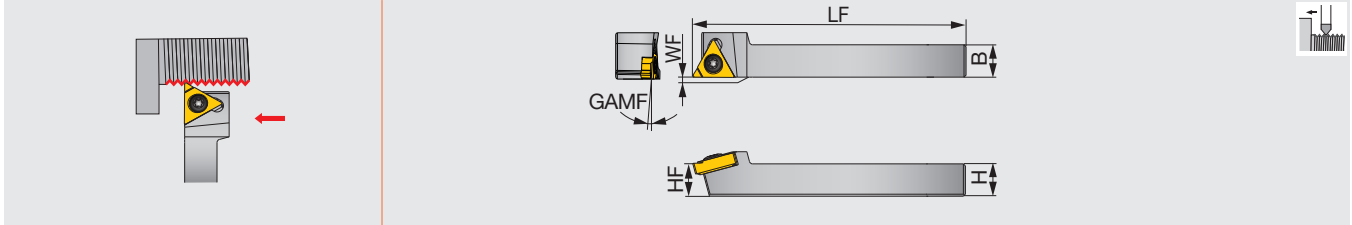


After 200 threads



SER

Screw-on external threading toolholders



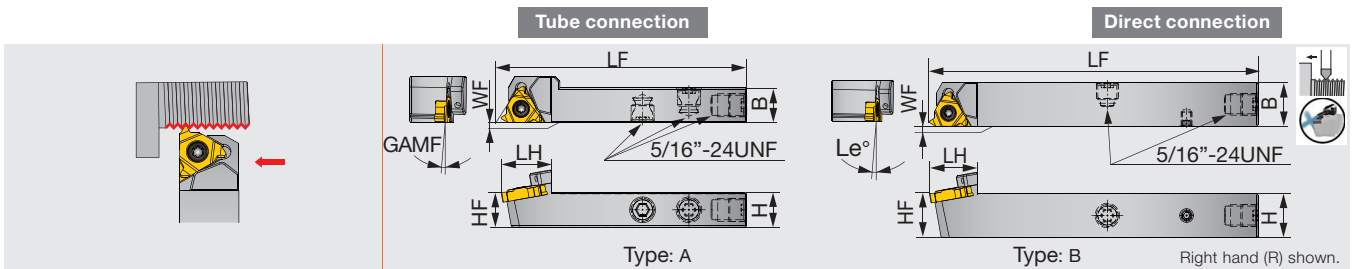
Metric	H	B	LF	HF	WF	GAMF	Insert
SER0808H11	8	8	100	8	0	1.5°	11ER...
SER1010H11	10	10	100	10	0	1.5°	11ER...

SPARE PARTS

Designation	Clamping screw	Wrench
SER**H11	SR M2.6-L6.7-S11	T-8/5

JSE2R16-CHP

Screw-on external threading toolholders. High pressure coolant capability with tube and direct connection



Inch	H	B	LF	LH	HF	WF	GAMF	Type	Insert
JSE2R08F16-CHP	0.500	0.500	3.344	0.748	0.500	0	1°	A	16ER...
JSE2R08X16-CHP	0.500	0.500	4.750	0.748	0.500	0	1°	B	16ER...
JSE2R10X16-CHP	0.625	0.625	4.750	0.748	0.625	0	1°	B	16ER...

Metric	H	B	LF	LH	HF	WF	GAMF	Type	Insert
JSE2R1212F16-CHP*	12	12	85	19	12	0	1°	A	16ER...
JSE2R1212X16-CHP	12	12	120	19	12	0	1°	B	16ER...
JSE2R1616X16-CHP	16	16	120	19	16	0	1°	B	16ER...

SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench
JSE2R**16-CHP	CSTB-3.5	T-15F	SR5/16UNFTL360	P-4

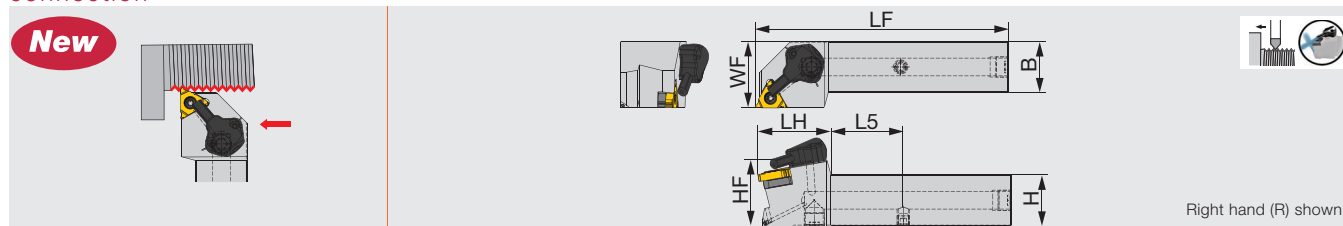
* External coolant tube connection type

SER-X-CHP-MC

Direct connection

Tube connection

Screw-on external threading toolholders. High pressure coolant capability with tube and direct connection



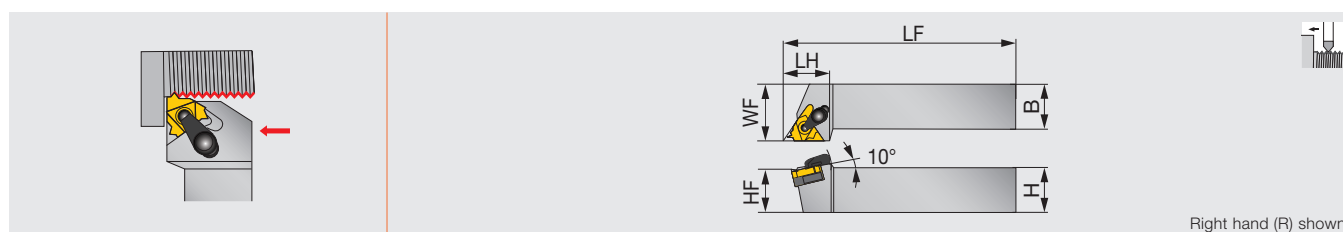
Metric	H	B	LF	LH	HF	WF	L5	Insert
SER2020X16-CHP-MC	20	20	107	36	20	25	27.9	16ER...
SER2525X16-CHP-MC	25	25	122	36	25	32	33.75	16ER...
SER2525X22-CHP-MC	25	25	122	36	25	32	33.75	22ER...

SPARE PARTS

Designation	Clamping screw	Wrench	Shim screw	Shim	Coolant unit	Coolant plug	Wrench
SER**X16-CHP-MC	CSTB-3.5ST	T-15F	DTS5-3.5	A16-1DT	CU-V-CHP	PLUGG1/8-6.5TL360	P-3.5
SER**X22-CHP-MC	CSTB-4ST	T-15F	DTS6-4	GX22-1DT	CU-CW-CHP	PLUGG1/8-6.5TL360	P-4

CER/L

Clamp-on external threading toolholders (screw-on type available as option for -DT type holders)



Inch	H	B	LF	LH	HF	WF	Insert
CER/L123DT	0.750	0.750	5.000	0.870	0.750	1.000	16ER/L...
CER/L163DT	1.000	1.000	6.000	1.000	1.000	1.250	16ER/L...
CER203DT	1.250	1.250	6.000	1.250	1.250	1.500	16ER...
CER164DT	1.000	1.000	6.000	1.000	1.000	1.250	22ER...
CER204DT	1.250	1.250	6.000	1.250	1.250	1.500	22ER...

Metric	H	B	LF	LH	HF	WF	Insert
CER/L1212H16DT	12	12	100	24	12	16	16ER/L...
CER/L1616H16DT	16	16	100	24	16	20	16ER/L...
CER/L2020K16DT	20	20	125	24	20	25	16ER/L...
CER/L2525M16DT	25	25	150	28	25	32	16ER/L...
CER/L2525M22DT	25	25	150	31.3	25	32	22ER/L...
CER3232P16T	32	32	170	32	32	40	16ER...
CER3232P22T	32	32	170	32	32	40	22ER...
CER2525M27T	25	25	150	34	25	32	27ER...
CER3232P27T	32	32	170	34	32	40	27ER...

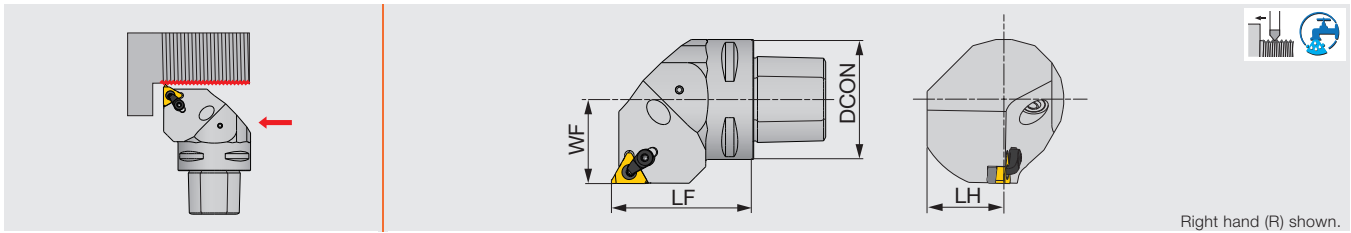
Note: A clamp set for CER/L type consists of a clamp and a clamping screw. A shim set for CER/L type consists of a shim and a shim screw. Standard shims for CER/L type can be used for both left hand and right hand toolholders. Use either of the sides depending on the hand.

SPARE PARTS

Designation	Clamp set	Clamping screw	Screw	Shim	Shim set	Wrench	Wrench 1	Wrench 2
CER/L123-DT	CSP16	CSTB-3.5ST	DTS5 - 3.5	A16 - 1DT	-	P-3.5	T-15F	-
CER/L163-DT	CSP16	CSTB-3.5ST	DTS5 - 3.5	A16 - 1DT	-	P-3.5	T-15F	-
CER203-DT	CSP22	CSTB-4ST	DTS6-4	GX22-1DT	-	P-3.5	T-15F	-
CER164-DT	CSP22	CSTB-4ST	DTS6-4	GX22-1DT	-	P-4	T-20F	-
CER204-DT	CSP22	CSTB-4ST	DTS6-4	GX22-1DT	-	P-4	T-20F	-
CER/L**16DT	CSP22	CSTB-3.5ST	DTS5-3.5	A16-1DT	-	P-3.5	T-15F	-
CER/L2525M22DT	CSP22	CSTB-4ST	DTS6-4	GX22-1DT	-	P-4	T-15F	T-20F
CER3232P16T	CSP16	-	-	-	A16-1	-	T-15F	-
CER3232P22T	CSP22	-	-	-	NXE22-1	-	T-20F	-
CER**27T	CSP27	-	-	-	NXE27-1	P-4	-	-

TUNGCAP**C-CER/L**

Clamp-on external threading toolholders with TungCap connection. High pressure coolant capability



Metric	DCON	LF	LH	WF	RE	Insert
C4CER/L27050-16ERN(2)	40	50	25	27	0.8	16ER/L...
C5CER/L35060-16ER(1)	50	60	32	35	0.8	16ER/L...
C5CER/L35060-16ERN(2)	50	60	32	35	0.8	16ER/L...
C6CER/L45065-16ER(1)	63	65	41	45	0.8	16ER/L...
C6CER/L45065-16ERN(2)	63	65	41	45	0.8	16ER/L...

(1) Applicable for 3 MPa pressure coolant. (2) Applicable for 7 MPa pressure coolant.

SPARE PARTS

Designation	Clamp set	Clamping screw	Coolant parts	Screw	Shim	Wrench	Wrench 1
C5CE*35060-16ER	CSP16	CSTB-3.5ST	EZ104	DTS5-3.5	A16-1DT	P-3.5	T-15F
C5CE*35060-16ERN	CSP16	CSTB-3.5ST	SATZ-M10X1-M5	DTS5-3.5	A16-1DT	P-3.5	T-15F
C6CE*45065-16ER	CSP16	CSTB-3.5ST	EZ104	DTS5-3.5	A16-1DT	P-3.5	T-15F
C6CE*45065-16ERN	CSP16	CSTB-3.5ST	SATZ-M10X1-M5	DTS5-3.5	A16-1DT	P-3.5	T-15F

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To see this product in action visit:

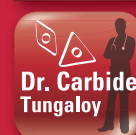
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