

TurnLine

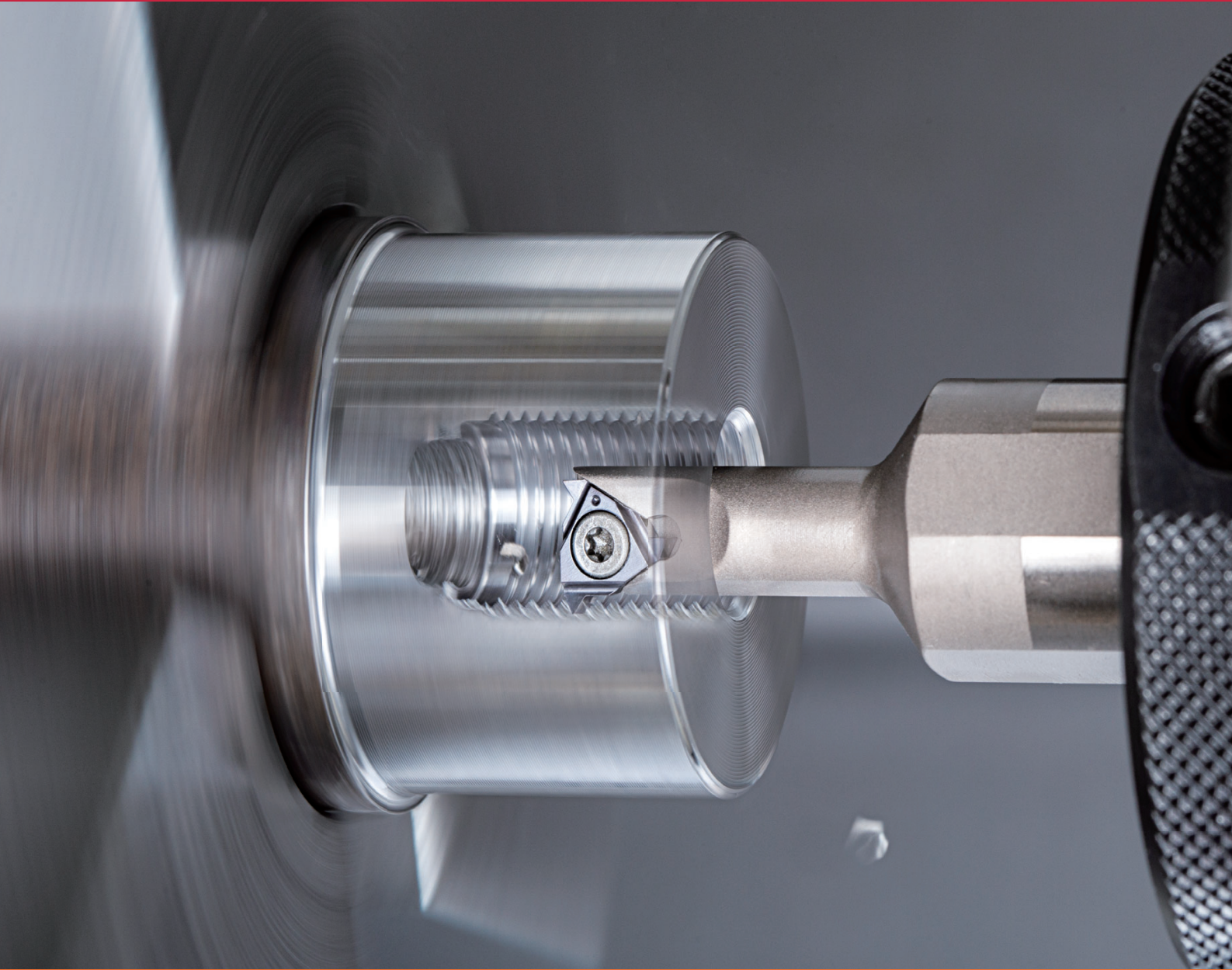


**TUNG**THREAD

[www.tungaloy.com/us](http://www.tungaloy.com/us)

Tungaloy Report No. 375S2-US

## Expansion of insert & tool holder for small diameter internal threading



**INDUSTRY 4.0**  
*FEED the SPEED!*



For more information

## Efficient internal thread turning of small diameter holes!



**New**



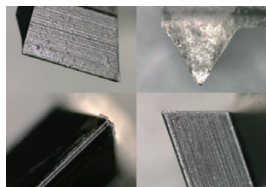
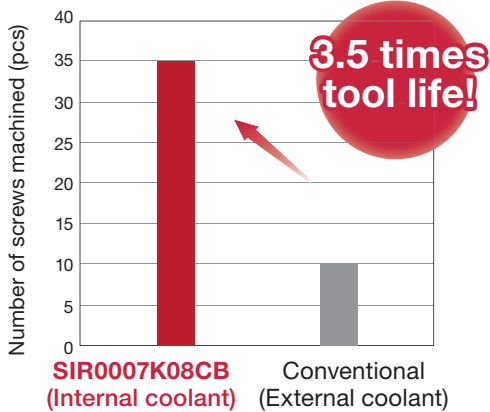
Conventional



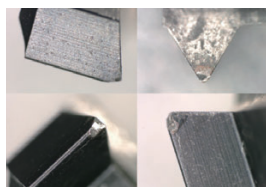
- Economical 3-edged insert
- For small holes in diameters 0.290" and larger
- Through-coolant holders are also available

- Single-edged insert
- For hole diameters in 0.354" and larger
- No through-coolant

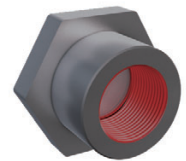
### Cutting performance



SIR0007K08CB  
(Internal coolant)  
After 30 threaded



Conventional  
After 10 threaded

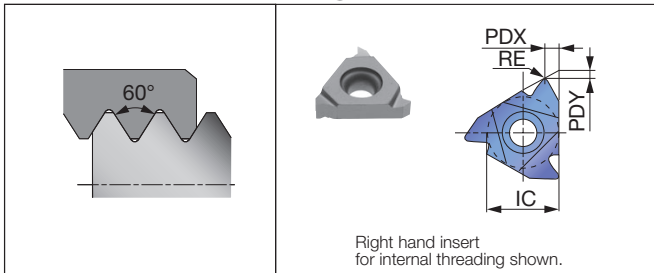


- M** Holder : SIR0007K08CB (Internal coolant)  
 Insert : 08IRA60 AH725  
 Workpiece material : 316SS  
 Cutting speed : Vc = 197 sfm  
 Pitch : 0.030" (0.75 mm)  
 Machining : Internal threading  
 Infeed method : Radial infeed  
 Coolant : Wet

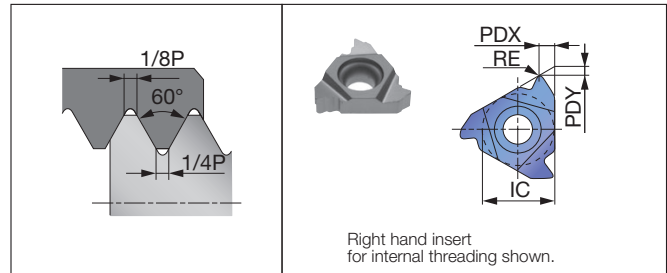
### Standard cutting conditions

ISO	Workpiece materials	Hardness	Cutting speed Vc (sfm)	
			AH725	GH330
<b>P</b>	Carbon steel	< 200 HB	262 - 591	262 - 558
		> 200 HB	197 - 525	197 - 427
<b>M</b>	Stainless steel	-	164 - 427	230 - 394

## 60° thread angle



## ISO metric



### Partial-profile inserts

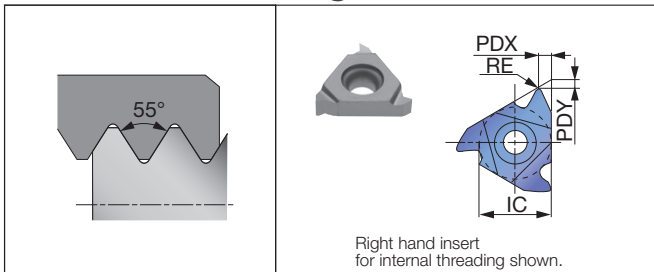
Insert size	Pitch (mm)	TPI	Hand of cut	Internal insert (in)						
				Designation	Grades		IC	PDX	PDY	RE
					Coating					
06	0.5-1.25	48-20	R	<b>06IRA60</b>	AH725	GH330	0.157	0.024	0.024	0.002
08	0.5-1.5	48-16	R	<b>08IRA60</b>			0.197	0.028	0.024	0.002

### Full-profile inserts

Insert size	Pitch (mm)	TPI	Hand of cut	Internal insert (in)						
				Designation	Grades		IC	PDX	PDY	RE
					Coating					
06	0.5		R	<b>06IR05ISO</b>	AH725		0.157	0.035	0.024	0.002
06	0.75		R	<b>06IR075ISO</b>			0.157	0.024	0.024	0.002
06	1		R	<b>06IR10ISO</b>			0.157	0.024	0.024	0.002
06	1.25		R	<b>06IR125ISO</b>			0.157	0.024	0.024	0.003
08	1		R	<b>08IR10ISO</b>			0.197	0.024	0.024	0.002
08	1.25		R	<b>08IR125ISO</b>			0.197	0.028	0.028	0.003
08	1.5		R	<b>08IR15ISO</b>			0.197	0.028	0.028	0.004
08	1.75		R	<b>08IR175ISO</b>			0.197	0.024	0.024	0.004

●: New / Package quantity = 5 pcs.

## 55° thread angle



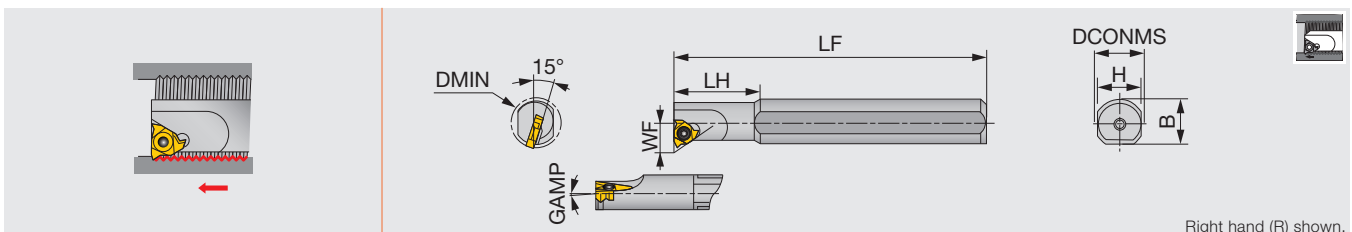
### Partial-profile inserts

Insert size	Pitch (mm)	TPI	Hand of cut	Internal insert (in)						
				Designation	Grades		IC	PDX	PDY	RE
					Coating					
06	0.5-1.25	48-20	R	<b>06IRA55</b>	AH725	GH330	0.157	0.020	0.020	0.002
08	0.5-1.5	48-16	R	<b>08IRA55</b>			0.197	0.028	0.024	0.002

**New**

## SIR

Internal threading bars, Screw-on clamp



Metric	Material	DMIN	DCONMS	WF	LF	LH	H	B	GAMP	Coolant hole	Insert
SIR0005H06	STEEL	6.4	12	4.3	100	12	11	-	1.5°	Without	06IR...
SIR0007K08	STEEL	7.8	16	5.3	125	18	15	-	1.5°	Without	08IR...
SIR0005H06CB	CARBIDE	6.4	6	4.3	100	25	5	-	1.5°	With	06IR...
SIR0007K08CB	CARBIDE	8	8	5.3	125	30	7	-	1.5°	With	08IR...

Note: The right hand insert (\*\*IR...type) is used for the right hand toolholders (SIR...type).  
Recommend over 1 mm clearance between internal diameter of thread and each tools DMIN.

### SPARE PARTS

Designation	Clamping screw	Wrench
SIR0005H06...	SR 14-552	T-6F-S
SIR0007K08...	SR 14-558	T-6F-S

### Applicable thread size

Description	ISO metric	Unified IRA60 Insert	Parallel pipe IRA55 Insert
SIR0005H06...	≥ M9	≥ 3/8-24 UNF	≥ G1/8
SIR0007K08...	≥ M11	≥ 7/16-20 UNF	≥ G1/4

# Tungaloy America, Inc.

3726 N Ventura Drive, Arlington Heights, IL 60004, U.S.A.

Inside Sales: +1-888-554-8394

Technical Support: +1-888-554-8391

Fax: +1-888-554-8392

[www.tungaloy.com/us](http://www.tungaloy.com/us)

## Tungaloy Canada

432 Elgin St. Unit 3, Brantford, Ontario N3S 7P7, Canada

Phone: +1-519-758-5779 Fax: +1-519-758-5791

[www.tungaloy.com/ca](http://www.tungaloy.com/ca)

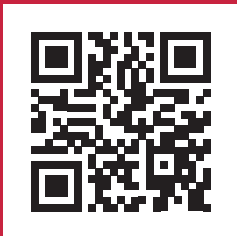
## Tungaloy de Mexico S.A.

C Los Arellano 113, Parque Industrial Siglo XXI

Aguascalientes, AGS, Mexico 20290

Phone: +52-449-929-5410 Fax: +52-449-929-5411

[www.tungaloy.com/mx](http://www.tungaloy.com/mx)



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