

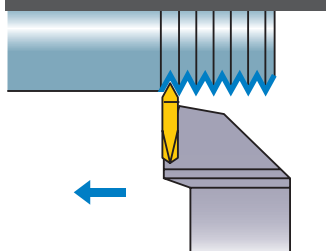
EXTERNAL THREADING

SMG[®] HOLDER

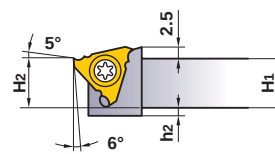
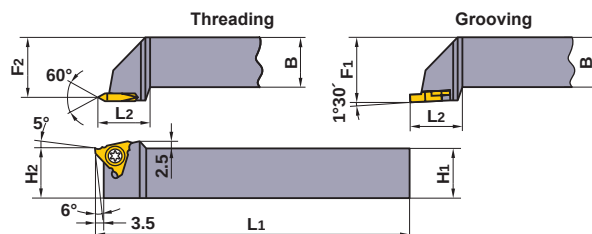
- Screw-on type.
- Positive insert suffers from negligible chattering.
- Suitable for narrow grooving and threading.
- Thread pitch ≤ 2.0 mm.

SMGH

External threading, Grooving



(Note) Cutting in the opposite direction is not possible.



SMGHR1010E16:h2=4
SMGHR1212F16:h2=2

Right hand tool holder only.

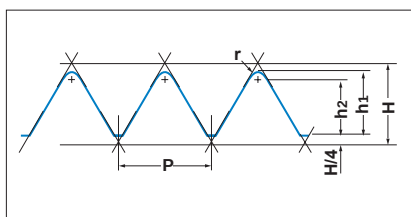
Order Number	Stock	Insert Number		Dimensions (mm)								★	✱
	R	Threading	Grooving	H1	B	L1	L2	H2	F1	F2	Clamp Screw		
SMGHR1010E16	★	SMTTR160360	SMGTR16X2 SMGTR16X2C	10	10	70	16.5	10	12	11.7	FC400890T	TKY10F	✱
1212F16	★			12	12	80	16.5	12	16	15.7	FC400890T		
1616H16	★			16	16	100	20	16	20	19.7	FC400890T		
2020K16	★			20	20	125	20	20	25	24.7	FC400890T		
2525M16	★			25	25	150	20	25	32	31.7	FC400890T		

★ Clamp Torque (N · m) : FC400890T=2.5

THREADING

STANDARD OF DEPTH OF CUT

- The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- When using cermet grades or cutting stainless steel, please increase the number of passes by 2—3 times.



METRIC SCREW THREAD

P (Pitch)		0.75	1.00	1.25	1.50	1.75	2.00
h1		0.46	0.61	0.77	0.92	1.07	1.23
h2		0.35	0.47	0.59	0.70	0.82	0.94
r (Nose Radius)		0.11	0.14	0.18	0.22	0.25	0.29
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	0.25
	2	0.13	0.15	0.18	0.20	0.20	0.25
	3	0.10	0.10	0.12	0.15	0.20	0.20
	4	0.05	0.10	0.12	0.15	0.15	0.15
	5		0.06	0.10	0.10	0.12	0.15
	6			0.05	0.07	0.10	0.10
	7					0.05	0.08
	8						0.05
	9						

(Note) The first pass causes a high load on the cutting edge.
In order to avoid damage, keep the depth of cut to 0.4—0.5mm maximum.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	NX55	200 (150—250)
		UTi20T	120 (100—150)
	Carbon Steel Alloy Steel	NX55	170 (150—200)
		UTi20T	100 (70—120)

	Work Material	Hardness	Grade	Cutting Speed (m/min)
M	Stainless Steel	≤200HB	UTi20T	100 (70—130)
K	Cast Iron	Tensile Strength ≤350MPa	UTi20T	80 (60—100)
			HTi10	100 (70—130)

★ : Inventory maintained in Japan. □ : Non stock, produced to order only.