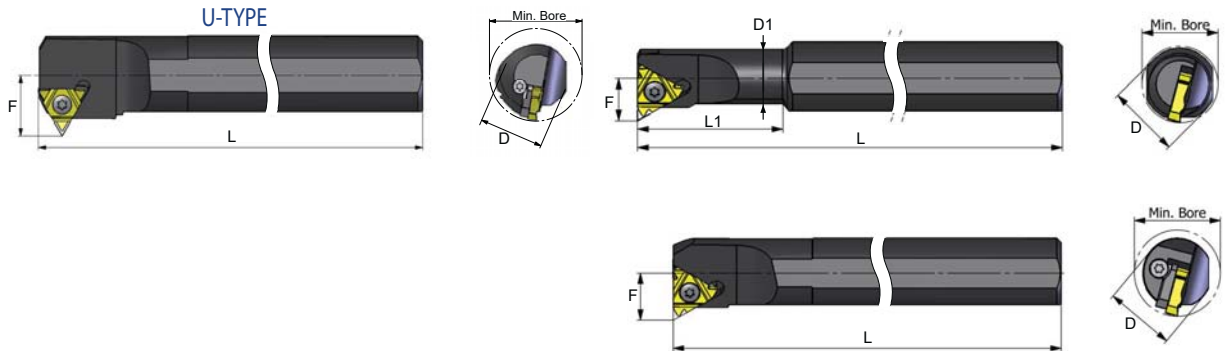



## Internal Toolholders



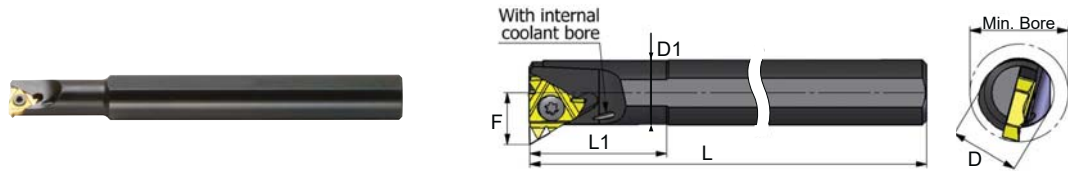
Ordering Code Right Hand		D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SIR 0005 H06	6	12	5.1	6.0	100	12	4.3	S06	-	K06	-	-
*SIR 0007 K08	8	16	6.6	7.8	125	18	5.3	S08	-	K08	-	-
*SIR 0008 K08U	8U	16	7.3	9.0	125	21	6.6	S08	-	K08	-	-
*SIR 0010 H11	11	10	10	12	100	-	7.4	S11	-	K11	-	-
*SIR 0010 K11	11	16	10	12	125	25	7.4	S11	-	K11	-	-
*SIR 0013 L11	11	16	13	15	140	32	8.9	S11	-	K11	-	-
*SIR 0013 M16	16	16	13	16	150	32	10.2	S16S	-	K16	-	-
*SIR 0016 P16	16	20	16	19	170	40	11.7	S16S	-	K16	-	-
SIR 0020 P16	16	20	20	24	170	-	13.7	S16	A16	K16	AI16	AE16
SIR 0025 R16	16	25	25	29	200	-	16.2	S16	A16	K16	AI16	AE16
SIR 0032 S16	16	32	32	36	250	-	19.7	S16	A16	K16	AI16	AE16
SIR 0040 T16	16	40	40	44	300	-	23.7	S16	A16	K16	AI16	AE16
SIR 0050 U16	16	50	50	54	350	-	28.7	S16	A16	K16	AI16	AE16
*SIR 0020 P22	22	20	20	24	170	-	15.6	S22S	-	K22	-	-
SIR 0025 R22	22	25	25	29	200	-	18.1	S22	A22	K22	AI22	AE22
SIR 0032 S22	22	32	32	38	250	-	21.6	S22	A22	K22	AI22	AE22
SIR 0040 T22	22	40	40	46	300	-	25.6	S22	A22	K22	AI22	AE22
SIR 0050 U22	22	50	50	56	350	-	30.6	S22	A22	K22	AI22	AE22
SIR 0032 S22U	22U	32	32	38	250	-	24.4	S22	A22	K22	AI22U	AE22U
SIR 0040 T22U	22U	40	40	46	300	-	28.1	S22	A22	K22	AI22U	AE22U
SIR 0050 U22U	22U	50	50	57	350	-	30.8	S22	A22	K22	AI22U	AE22U
SIR 0032 S27	27	32	32	40	250	-	22.6	S27	A27	K27	AI27	AE27
SIR 0040 T27	27	40	40	48	300	-	26.6	S27	A27	K27	AI27	AE27
SIR 0050 U27	27	50	50	58	350	-	31.6	S27	A27	K27	AI27	AE27
SIR 0060 V27	27	60	60	68	400	-	36.6	S27	A27	K27	AI27	AE27
SIR 0032 S27U	27U	32	32	40	250	-	25.8	S27	A27	K27	AI27U	AE27U
SIR 0040 T27U	27U	40	40	48	300	-	29.4	S27	A27	K27	AI27U	AE27U
SIR 0050 U27U	27U	50	50	58	350	-	34.4	S27	A27	K27	AI27U	AE27U
SIR 0060 V27U	27U	60	60	68	400	-	39.7	S27	A27	K27	AI27U	AE27U
*SIR 0050 U33U	33U	50	50	62	350	-	37.5	S33	-	K33	-	-


\*Toolholders with no anvil

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

Toolholders are made with a **1.5° Helix Angle**. For other Helix Angles please see helix angle chart (page 65) in the technical section of this catalogue.

## Internal toolholders with coolant bore



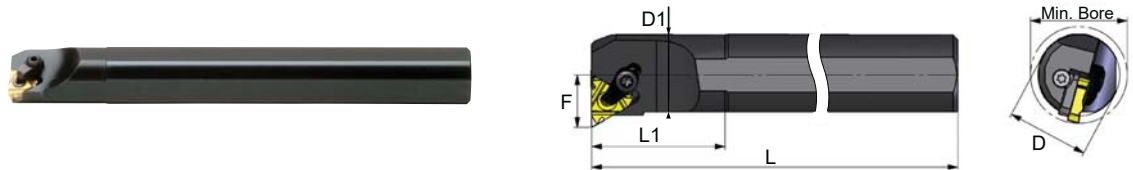
Ordering Code Right Hand	 L	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
*SIR 0010 K11B	11	16	10	12	125	25	7.4	S11	-	K11	-	-
*SIR 0013 M16B	16	16	13	16	150	32	10.2	S16S	-	K16	-	-
*SIR 0016 P16B	16	20	16	19	170	40	11.7	S16S	-	K16	-	-
SIR 0020 P16B	16	20	20	24	170	-	13.7	S16	A16	K16	AI16	AE16
SIR 0025 R16B	16	25	25	29	200	-	16.2	S16	A16	K16	AI16	AE16
SIR 0025 R22B	22	25	25	29	200	-	18.1	S22	A22	K22	AI22	AE22


\*Toolholders without anvil

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

Toolholders are made with a **1.5° Helix Angle**. For other Helix Angles please see helix angle chart (page 65) in the technical section of this catalogue.

## Internal toolholders with top clamp



Ordering Code Right Hand	 L	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Clamp	Anvil Screw	Torx Key	RH Anvil	LH Anvil
DIR 0020 P16	16	20	20	24	170	-	13.7	S16	C16	A16S	K16	AI16	AE16
DIR 0025 R16	16	25	25	29	200	-	16.2	S16	C16	A16S	K16	AI16	AE16
DIR 0032 S16	16	32	32	36	250	-	19.7	S16	C16	A16S	K16	AI16	AE16
*DIR 0025 R22	22	25	25	29	200	-	18.1	S22	C22	A22	K22	AI22	AE22

For **LEFT HAND** toolholders specify **DIL** instead of **DIR**

Two clamping methods can be used: screw or top clamp.

\*Use K21 torx key for C22 clamp

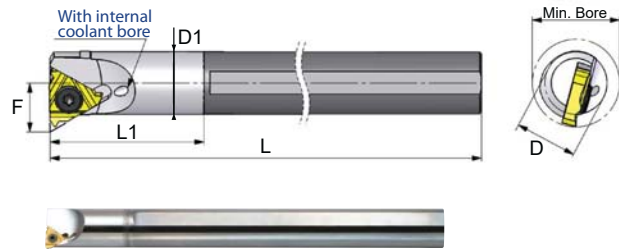
## Toolholders with 3.5° Helix Angle

Ordering Code Right Hand	 L	D	D1	Min Bore Diam. mm	L	L1	F	Insert Screw	Torx Key
SIR 0016 P16B-3.5	16	20	16	19	170	40	13.7	S16S	K16
SIR 0020 P22B-3.5	22	20	20	24	170	-	15.6	S22S	K22

For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

## Carbide Shank Threading Bars With coolant bore

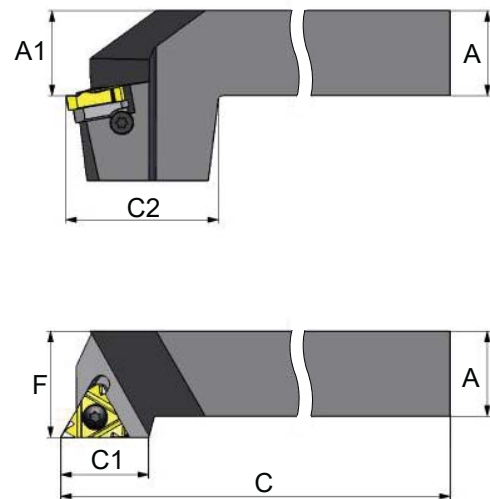
Carbide Shank Threading Bars are used when chatter and deflection are expected due to long overhang in deep small bores.



Ordering Code Right Hand	L	D	D1	Min Bore Diam.	L	L1	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SIR 0005 H06CB	6	6	5.1	6.0	100	26	4.3	S06	-	K06	-	-
SIR 0007 K08CB	8	8	6.6	7.8	125	31	5.3	S08	-	K08	-	-
SIR 0008K08UCB	8U	8	7.3	9.0	125	35	6.6	S08	-	K08	-	-
SIR 0010 M11CB	11	10	10	12	150	-	7.4	S11	-	K11	-	-
SIR 0012 P11CB	11	12	12	15	170	-	8.4	S11	-	K11	-	-
SIR 0016 R16CB	16	16	16	19	200	-	11.7	S16S	-	K16	-	-
*SIR 0020 S16CB	16	20	20	24	250	-	13.7	S16	A16	K16	AI16	AE16
*SIR 0025 S16CB	16	25	25	29	250	-	16.2	S16	A16	K16	AI16	AE16
SIR 0020 S22CB	22	20	20	24.5	250	-	15.6	S22	-	K22	-	-

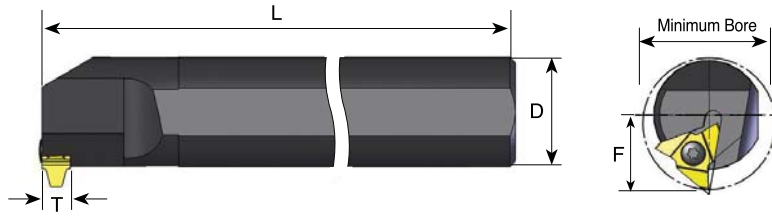
\*Carbide shank Threading bars with anvil  
For **LEFT HAND** toolholders specify **SIL** instead of **SIR**


## Drophead Toolholders



Ordering Code Right Hand	L	A	A1	C	C1	F	C2	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
SER 2020 K16D	16	20	20	125	21.0	25	38	S16	A16	K16	AE16	AI16
SER 2525 M16D	16	25	25	150	21.0	32	38	S16	A16	K16	AE16	AI16
SER 2525 M22D	22	25	25	150	21.0	32	38	S22	A22	K22	AE22	AI22

## Vertical Toolholders



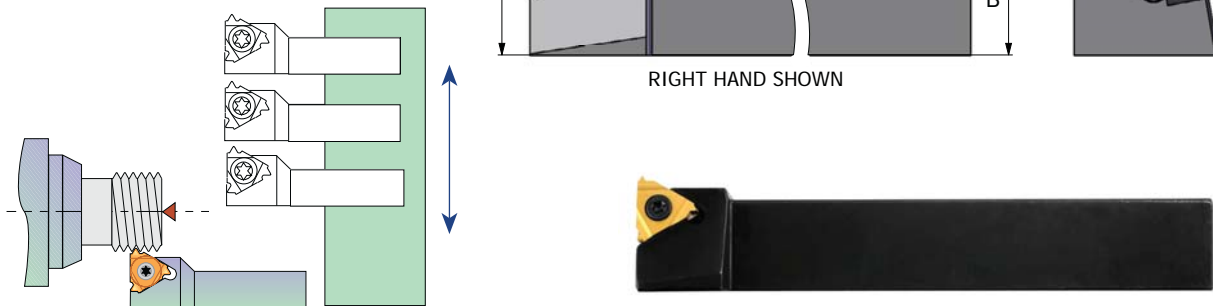
Ordering Code Right Hand	 L	D	* Min Bore Diam.	L	F	Insert Screw	Torx Key
<b>SIR 0040T27V-T10</b>	27	40	48	300	29	S27	K27
<b>SIR 0050U27V-T10</b>	27	50	58	350	34	S27	K27


For **LEFT HAND** toolholders specify **SIL** instead of **SIR**

\* To be compare with given minimum bore profile.

## Gang Toolholders

Gang Toolholders are External Holders, used in small automatic machines with a gang tool post.



Ordering Code Right Hand	 L	B=H	L	F	Insert Screw	Anvil Screw	Torx Key	RH Anvil	LH Anvil
<b>*SER 8 8 H11G</b>	11	8	100	12.0	S11	-	K11	-	-
<b>*SER 10 10 H11G</b>	11	10	100	14.0	S11	-	K11	-	-
<b>SER 16 16 K16G</b>	16	16	125	21.7	S16	A16	K16	AE16	AI16
<b>SER 20 20 K16G</b>	16	20	125	26.2	S16	A16	K16	AE16	AI16

\*Toolholders with no anvil

For **LEFT HAND** toolholders specify **SEL** instead of **SER**