



Thread Turning Toolholders

Vardex Ordering Code System

External Toolholders

A	L	32	-	4	U	C	7	8	9
1	2	3		4	5	6			

1 - Anvil A - Anvil Required N - No Anvil Required O - Miniature Holder	2 - Holder Style L - External V - Miniature Square Shank VR - Miniature Round Shank	3 - Shank Square [mm] 8, 10, 12, 16, 20, 25, 32, 40, 50, 60	4 - Insert Size 2 - IC1/4" 3 - IC3/8" 4 - IC1/2" 5 - IC5/8"
5 - Insert Style U - U style V - Vertical F - F Line M - Multi+ M MF - Multi+ F Line Z - Multi+ Z T - Multi+ T 14D - Multi+ 14D MG - Mega Line	6 - Clamping C - With Clamping	7 - Insert Width (for IC5/8"V) 6, 8, 10	
8 - Tool Type CQ - Drop Head FQ - Off-Set Oil - For API Inserts	9 - RH/LH Holder None - Right Hand LH - Left Hand		

Internal Toolholders

C	A	VR	C	20	6	-	3	9	10	11	12	
1	2	3	4	5	6		7	8	9	10	11	12

1 - Shank Type B - Anti Vibration System C - Carbide Shank S - Mini Holders	2 - Anvil A - Anvil Required N - No Anvil Required O - Miniature Holder	3 - Tool Type VR - Internal Round Shank	5 - Shank Front Dia. 10, 10D, 12, 13, 16 16D, 20, 25, 25D, 32, 40, 50 6.2 (Mini Adjust) 8.0 (Mini Adjust)	6 - Holder Length (Mini Holders) U - Ultra Short S - Short M - Medium L - Long T - Adjustable
7 - Insert Size 5L - IC5.0L mm 4.0K - IC4.0 mm 5.0K - IC5.0 mm 6.0 - IC6.0 mm 2 - IC1/4" 3 - IC3/8" 4 - IC1/2" 5 - IC5/8"	8 - Insert Style U - U style V - Vertical F - F Line M - Multi+ M MF - Multi+ F Line Z - Multi+ Z T - Multi+ T 14D - Multi+ 14D MG - Mega Line	9 - Clamping C - With Clamp	12 - Serial No. 156/... (Coarse Pitch Holder) 206/... (V6 Holder)	
		10 - Oil Field OIL - For API Inserts		
		11 - RH/LH Holder None - Right Hand LH - Left Hand		

Micro, Microscope & Adjustable Toolholders (Sleeves)

M	H	C	20	-	4	-	4F
1	2	3	4		5		6

1 - Holder Shape S - Sleeve (Double Ended) M - Microscope (Single Ended)	2 - Holder Type V - Adjustable Holders for Mini M - Micro (Double Ended) H - Microscope Holder HS - Microscope with Square Shank HD - Microscope with Drop Head	3 - Cooling C - Coolant Channel	4 - Shank Size [mm] 10, 12, 16, 20	5 - Holder Bore Size Micro Size 3, 4, 5, 6, 7, 8, 10 Adjustable Holders (for Mini) 6.2, 8	6 - No. of Flats 4F - 4 Flats None - 2 Flats
---	---	---	--	--	---

V-CAP Toolholders

VCAP	40	-	S	E	R	27	050	-	3
1	2		4	5	6	7	8		9

1 - Holder Style	2 - D (Polygon Size)	3 - Insert Style	4 - External / Internal	5 - RH / LH
VCAP - Vargus Polygon Shank	32,40,50,63	S - Threading	E - External I - Internal	R - Right Hand L - Left Hand

6 - Cutting Radius	7 - Tool Overhang	8 - Insert Size
12-55	40-105	3 - IC3/8"

VG-Cut Toolholders for Threading

VG	E	R	2525	-	3	T12
1	2	3	4		5	6

1 - Line Name	2 - Application Approach	3 - RH / LH	4 - Shank Size
VG - Deep Grooving & Parting Off	E - External	R - Right Hand L - Left Hand	Width-Height

5 - Pocket Size	6 - Depth of Cut
3	T12 - Limit Depth of Cut 12 mm

Mini-V Holders

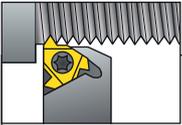
C	V	08	-	12	21	-
1	2	3		4	5	6

1 - Holder Type	2 - Product Line	3 - Insert Style	4 - Shank Diameter	5 - Tool Overhang	6 - RH
C - Carbide Shank None - Steel Shank	V - Mini-V	08, 11, 14, 16	6, 8, 12, 16	12, 21, 29, 30, 42, 50, 56, 64, 80	None - RH

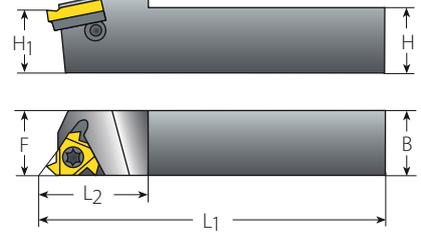
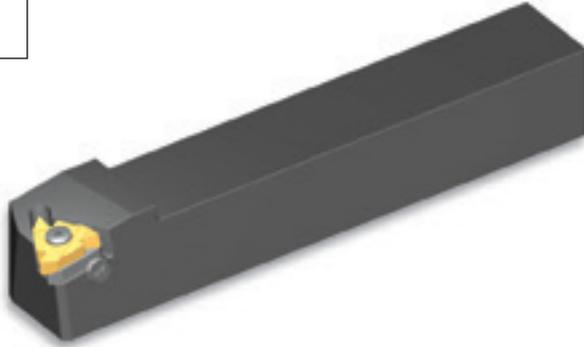
Mini-V Sleeves

MH	C	16	-	6
1	2	3		4

1 - Holder Type	2 - Cooling	3 - Shank Dia.	4 - Sleeve Bore Dia.
MH - Microscope Holder	C - Cooling Channels	12, 16, 20	6, 8



External Toolholders

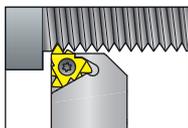


Standard

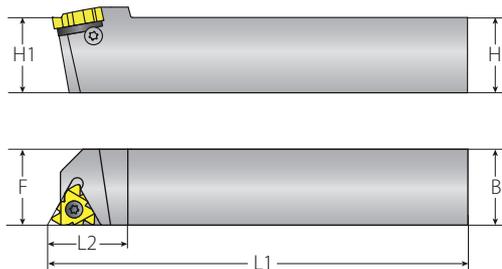
Spare Parts

Insert Size	Ordering Code	Dimensions mm										
		IC	RH/LH	H=H1=B	F	L1	L2	Insert Screw	Anvil Screw	Torx Key	Anvil RH	Anvil LH
1/4"	NL8-2			8	11	136.4	17.5	SN2T	-	K2T	-	-
	NL10-2			10	11	125.0	17.5					
	NL12-2			12	12	125.0	17.5					
3/8"	NL12-3			12	16	83.2	22	SA3T	-	K3T	-	-
	AL3/8-3			9.52	16	63.6	20.5					
	AL12-3			12	16	83.2	22					
	AL16-3			16	16	100.0	20.5					
	AL20-3			20	20	128.6	30					
	AL25-3			25	25	153.6	30					
	AL32-3			32	32	173.6	30					
1/2"	AL25-4			25	25	155.7	36	SA4T	SY4T	K4T	YE4	YI4
	AL32-4			32	32	175.7	36					
	AL40-4			40	40	205.7	36					
5/8"	AL25-5			25	32	151.6	35	SA5T	SY5T	K5T	YE5	YI5
	AL32-5			32	32	176.6	40					
	AL40-5			40	40	206.6	40					
	AL50-5			50	50	256.6	40					

The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.
 The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example AL20-3**LH**).



External Toolholders



Standard F-Line

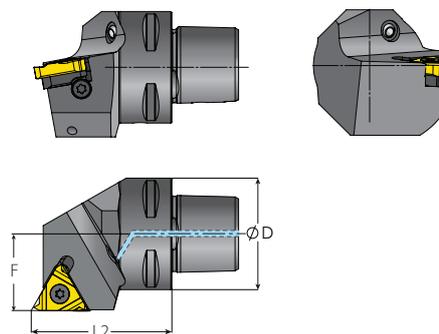
Insert Size	Ordering Code	Dimensions mm			
IC	RH	H=H1=B	F	L1	L2
1/2" F	AL25-4F	25	25	155	33
	AL32-4F	32	32	175	33
	AL40-4F	40	40	205	33

Spare Parts

Insert Screw	Anvil Screw	Torx Key	Anvil RH
SA4T	SY4T	K4T	YE4F



External Toolholders



V-CAP

Insert Size	Ordering Code	Dimensions mm		
IC	RH/LH	D	F	L2
3/8"	VCAP32-SER22040-3	32	22	40
	VCAP40-SER27050-3	40	27	50
	VCAP50-SER35060-3	50	35	60
	VCAP63-SER45065-3	63	45	65

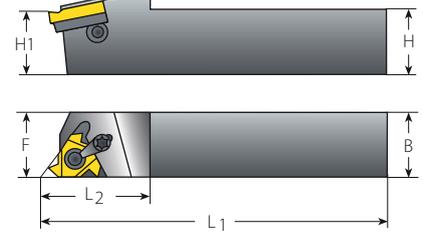
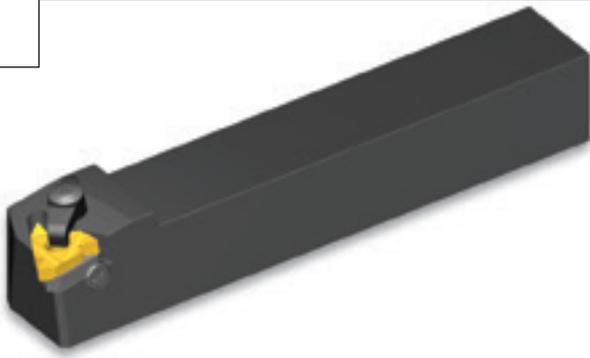
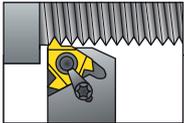
Spare Parts

Insert Screw	Anvil Screw	Torx Key	Coolant Jet	Anvil RH	Anvil LH
SA3T	SY3T	K3T	OD6	YE3	YI3
			OD8		

The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example VCAP32-SER22040-3LH).

The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.

External Toolholders



Standard with Clamp

(Dual System, Screw or Clamp)

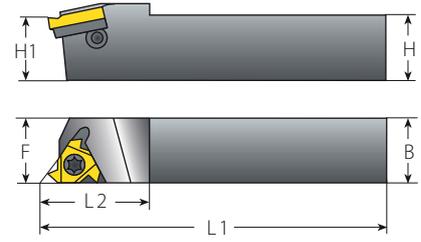
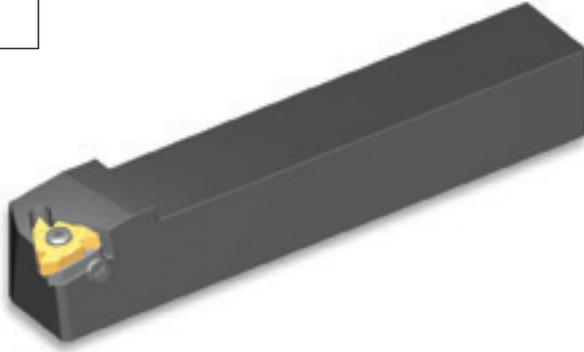
Spare Parts

Insert Size	Ordering Code	Dimensions mm				Spare Parts					
		H=H1=B	F	L1	L2	Insert Screw	Anvil Screw	Clamp	Torx Key	Anvil RH	Anvil LH
3/8"	AL16-3C	16	16	100.0	20.5	SA3T	SY3T	C3	K3CT	YE3	YI3
	AL20-3C	20	20	128.6	30						
	AL25-3C	25	25	153.6	30						
	AL32-3C	32	32	173.6	30						
1/2"	AL25-4C	25	25	155.7	36	SA4T	SY4T	C4	K4T	YE4	YI4
	AL32-4C	32	32	175.7	36						
	AL40-4C	40	40	205.7	36						
5/8"	AL25-5C	25	32	151.6	35	SA5T	SY5T	C5	K5T	YE5	YI5
	AL32-5C	32	32	176.6	40						
	AL40-5C	40	40	206.6	40						
	AL50-5C	50	50	256.6	40						

The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.
 The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example AL16-3CLH).



External Toolholders

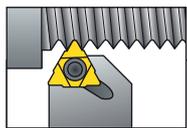


Thread Turning Toolholders

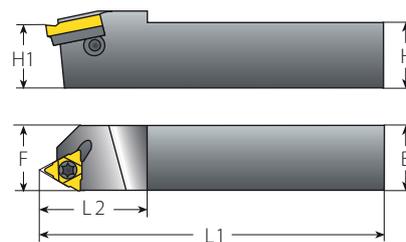
Oil & Gas

Spare Parts

Insert Size	Ordering Code	Thread Form	Connection No. or Size	Dimensions mm				Helix Angle				
				H=H1=B=F	L1	L2			Insert Screw	Anvil Screw	Torx Key	Anvil RH
3/8"	AL32-3 APIRD	APIRD 8	2.375"-20"	32	173.0	28.8	1	SA3T	SY3T	K3T	YEI3 APIRD	
	AL40-3 APIRD	APIRD 10	1.05"-3.5"	40	205.0	37.4	1					
1/2"	AL32-4 5BUT/API	5BUT, V0.038R, V0.050, V0.040, V0.055	4 1/2"-20"	32	177.0	36.6	0	SA4T	SY4T	K4T	YEI4-API-1P YEI4-5BUT	
	AL40-4 5BUT/API		NC10-NC77 all sizes	40	204.0	34.5	0					
5/8"	AL32-5OIL	V0.038R, V0.050	NC23-NC77 all sizes	32	175.9	40.0	1.5	SA5T	SY5T	K5T	YE5OIL	
	AL40-5OIL	V0.038R, V0.050	NC23-NC77 all sizes	40	205.9	40.0	1.5					



External Toolholders

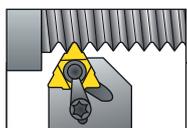


U Style

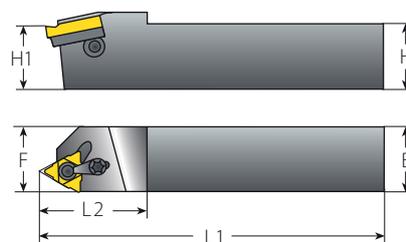
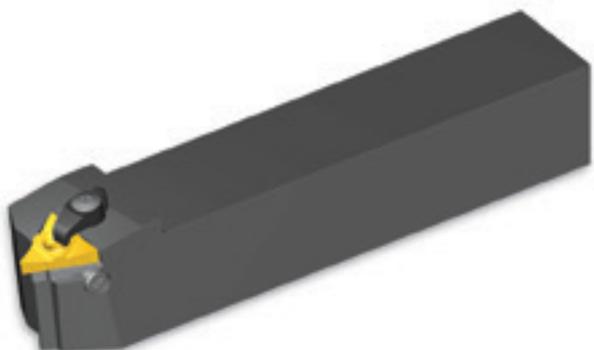
Insert Size	Ordering Code	Dimensions mm				
		IC	RH/LH	H=H1=B	F	L1
1/2"U	AL25-4U	25	25	178.4	38	
	AL32-4U	32	32	178.4	38	
	AL40-4U	40	40	208.4	38	
5/8"U	AL25-5U	25	25	179.1	40	
	AL32-5U	32	32	179.1	40	
	AL40-5U	40	40	209.1	40	
	AL50-5U	50	50	259.1	40	

Spare Parts

Insert Screw	Anvil Screw	Torx Key	Anvil RH	Anvil LH
SA4T	SY4T	K4T	YE4U	YI4U
SA5T	SY5T	K5T	YE5U	YI5U



External Toolholders



U Style with Clamp

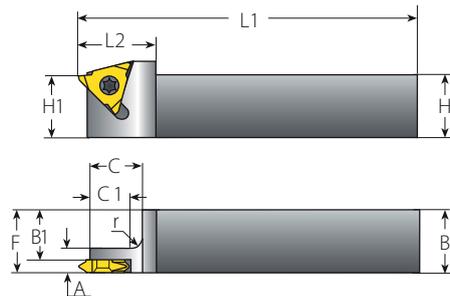
(Dual System, Screw or Clamp)

Insert Size	Ordering Code	Dimensions mm				
		IC	RH/LH	H=H1=B	F	L1
1/2"U	AL32-4UC	32	32	178.4	38	
	AL40-4UC	40	40	208.4	38	
	AL32-5UC	32	32	179.1	40	
5/8"U	AL40-5UC	40	40	209.1	40	
	AL50-5UC	50	50	259.1	40	

Spare Parts

Insert Screw	Anvil Screw	Clamp	Torx Key	Anvil RH	Anvil LH
SA4T	SY4T	C4	K4T	YE4U	YI4U
SA5T	SY5T	C5	K5T	YE5U	YI5U

All U Style Toolholders have a 1.5° helix angle. For other helix angles see page 201.
The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example AL25-4ULH).

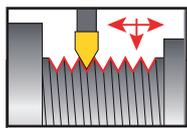


Slim Throat

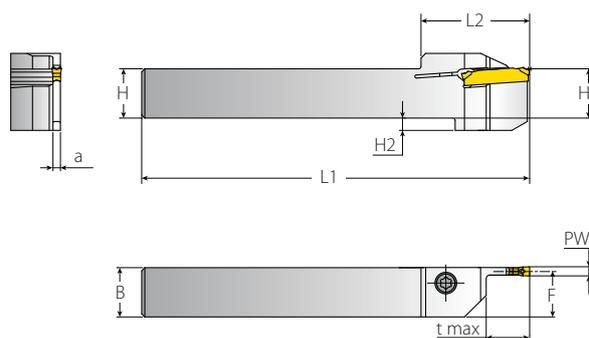
Spare Parts

Insert Size		Ordering Code		Dimensions mm							Spare Parts	
IC	RH/LH	H=B=F	H1	A	B1	C	C1	L1	L2	r	Insert Screw	Torx Key
1/4"V	NL8-2V	8	10	7	4.8	12.5	11.5	60	14.0	1	SN2T	K2T
	NL10-2V	10	10	7	6.8	12.5	11.5	70	14.0	1		
	NL12-2V	12	12	7	8.8	14.5	11.5	80	14.0	3		
	NL16-2V	16	16	7	12.8	14.5	11.5	100	14.0	3		
3/8"V	NL10-3V	10	14	7	6.4	14.5	11.5	70	18.5	3	SN3TV	K3T
	NL12-3V	12	14	7	8.4	14.5	11.5	80	18.5	3		
	NL16-3V	16	16	7	12.4	14.5	11.5	100	25.0	3		
	NL20-3V	20	20	7	16.4	16.5	11.5	125	30.0	3		
	NL25-3V	25	25	7	21.4	16.5	11.5	150	30.0	5		
	NL32-3V	32	32	7	28.4	16.5	11.5	170	30.0	5		
1/2"V	NL40-3V	40	40	7	36.4	16.5	11.5	200	30.0	5	SN4T	K4T
	NL25-4V	25	25	12	20.2	16.5	11.5	150	30.0	5		
	NL32-4V	32	32	12	27.2	16.5	11.5	170	30.0	5		
	NL40-4V	40	40	12	35.2	16.5	11.5	200	30.0	5		

All Slim Throat toolholders have a 1.5° helix angle see page 201.
 The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example NL8-2VLH).



External Toolholders



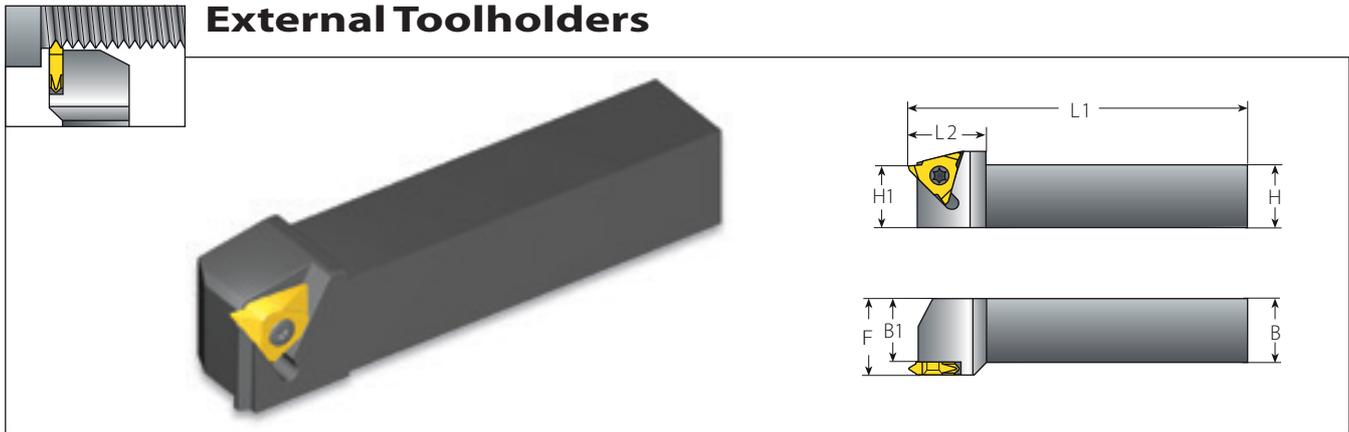
VG-Cut

Spare Parts

Ordering Code		Dimensions mm								Spare Parts	
PW	RH/LH	t max	HxB	H1	F	L1	L2	a	H2		
3	VGER1212-3T12	12	12x12	12	10.8	125	35	2.4	4.0	SM3,5x14-T15	KT-15
	VGEL1212-3T12		12x12	12	10.8	125	35	2.4	4.0		
	VGER1616-3T12		16x16	16	14.8	125	35	2.4	4.0	SM4,0x18-T20	K6T
	VGEL1616-3T12		16x16	16	14.8	125	35	2.4	4.0		
	VGER2020-3T12		20x20	20	18.8	125	35	2.4	-		
	VGEL2020-3T12		20x20	20	18.8	125	35	2.4	-		
	VGER2525-3T12		25x25	25	23.8	125	35	2.4	-		
	VGEL2525-3T12		25x25	25	23.8	125	35	2.4	-		

All VG-Cut tooling have 1.5° helix angle.

External Toolholders

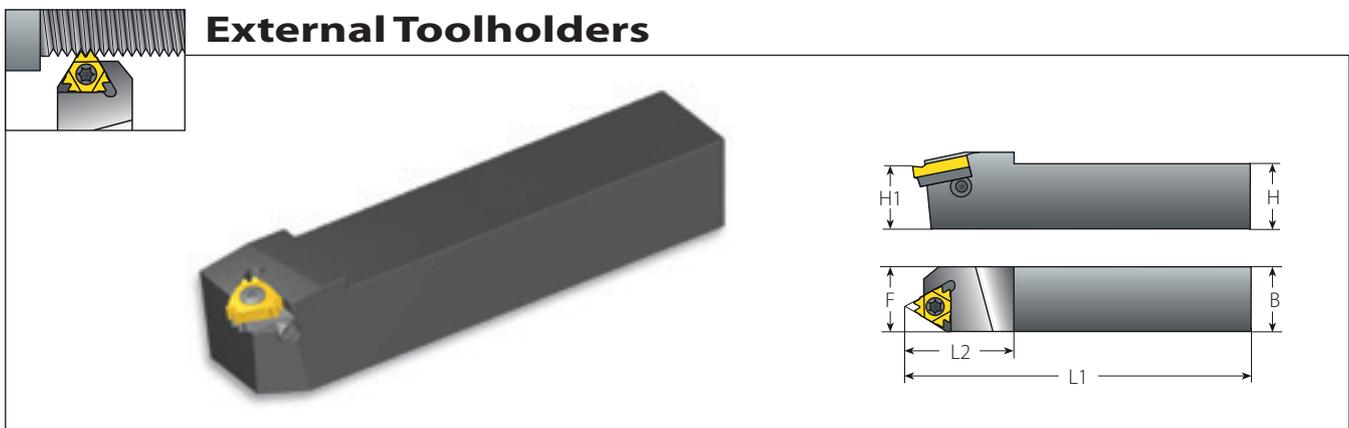


V Style

Insert Size		Ordering Code		Dimensions mm			Spare Parts	
IC	RH/LH	H=H1=B	B1	F	L1	L2	Insert Screw	Torx key
5/8"V	NL32-5V-6	32	25.5	32.0	170	40	SN6T	K6T
	NL32-5V-8	32	25.5	34.1	170	40		
	NL32-5V-10	32	25.5	35.8	170	40		
	NL32-5V-10ABUT*	32	25.5	35.8	170	40		
	NL40-5V-6	40	33.5	40.0	200	40		
	NL40-5V-8	40	33.5	42.1	200	40		
	NL40-5V-10	40	33.5	43.8	200	40		
	NL40-5V-10ABUT*	40	33.5	43.8	200	40		

All V Style toolholders have a 1° helix angle.
 The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example NL32-5V-6 **LH**).
 * To be used only with inserts 5VER2.5ABUT...

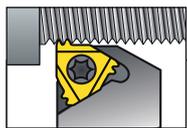
External Toolholders



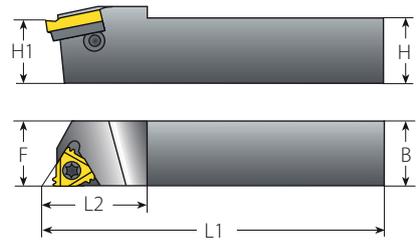
Z+ Style

Insert Size		Ordering Code		Dimensions mm			Spare Parts				
IC	RH	H=H1=B	F	L1	L2	Insert Screw	Anvil Screw	Torx Key	Anvil RH	Anvil LH	
1/2"Z	AL32-4Z	32	32	178.4	38	SA4T	SY4T	K4T	YE4Z	YI4Z	
	AL40-4Z	40	40	208.4	38						
5/8"Z	AL32-5Z	32	32	179.1	40	SA5T	SY5T	K5T	YE5Z	YI5Z	
	AL40-5Z	40	40	209.1	40						
	AL50-5Z	50	50	259.1	40						

All Z Style toolholders have a 1.5° helix angle.



External Toolholders



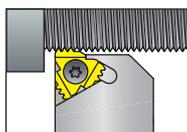
M+ Style

Insert Size	Ordering Code	Dimensions mm			
IC	RH	H=H1=B	F	L1	L2
5/8" M	AL32-5M	32	32	176.6	40
	AL40-5M	40	40	206.6	40
	AL50-5M	50	50	256.6	40

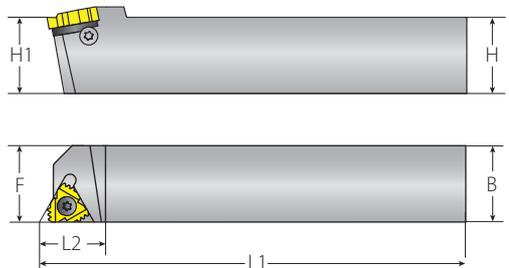
Spare Parts



Insert Screw	Anvil Screw	Torx Key	Anvil RH	Anvil LH
SA5T	SY5T	K5T	YE5M	YI5M



External Toolholders



F-Line M+ Style

Insert Size	Ordering Code	Dimensions mm			
IC	RH	H=H1=B	F	L1	L2
1/2" F	AL32-4MF	32	32	175	33
	AL40-4MF	40	40	205	33

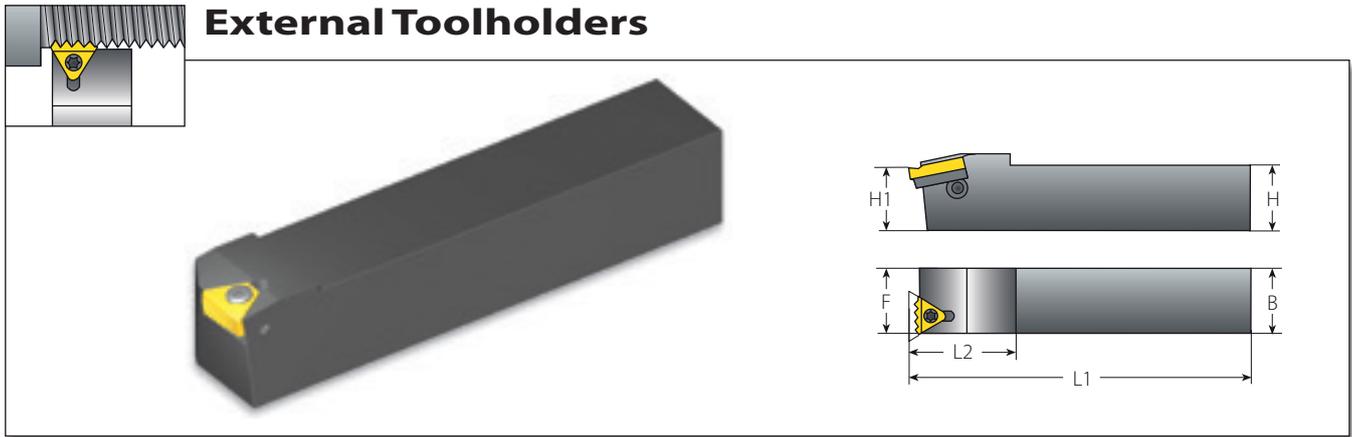
Spare Parts



Insert Screw	Anvil Screw	Torx Key	Anvil RH
SA4T	SY4T	K4T	YE4M2F

The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.

External Toolholders



T+ Style

Insert Size	Ordering Code	Dimensions mm			
IC	RH	H=H1=B	F	L1	L2
1/2" T	AL25-4T	25	27	150	30
	AL32-4T	32	34	170	30
	AL40-4T	40	42	200	30

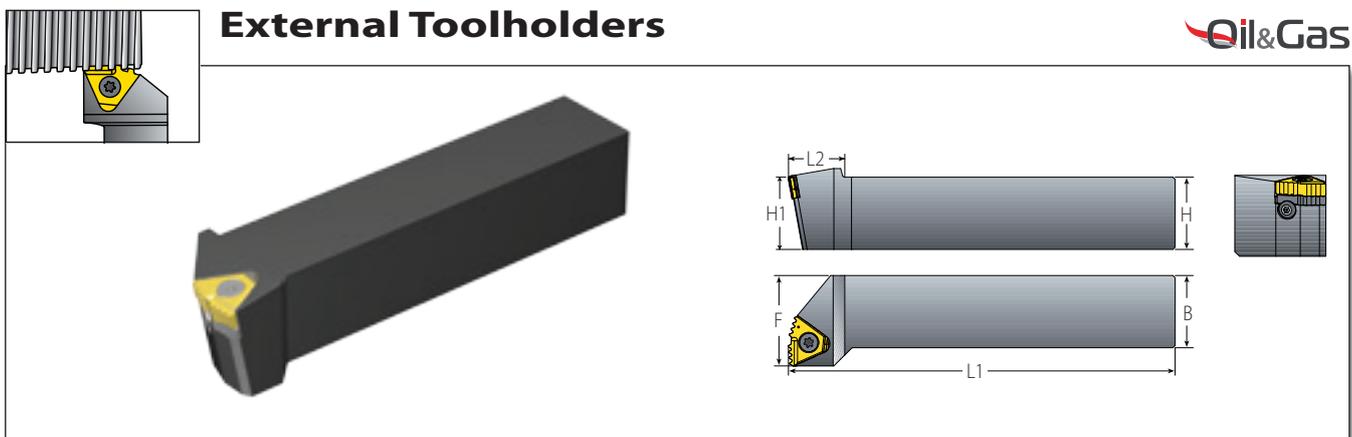
Spare Parts



SA4T	SY4K2	K4T	K2	Y4T
------	-------	-----	----	-----

All T Style toolholders have a 0° helix angle.

External Toolholders



14D Standard

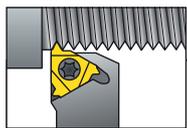
Insert Size	Ordering Code	Dimensions mm			
IC	RH	H=H1=B	F	L1	L2
14D	AL25-14D	25	32	150	25
	AL32-14D	32	40	170	25
	AL40-14D	40	40	200	30

Spare Parts

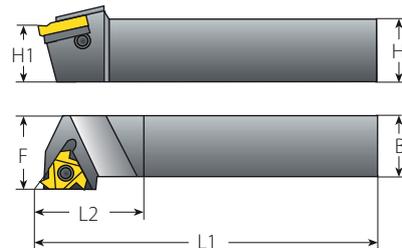
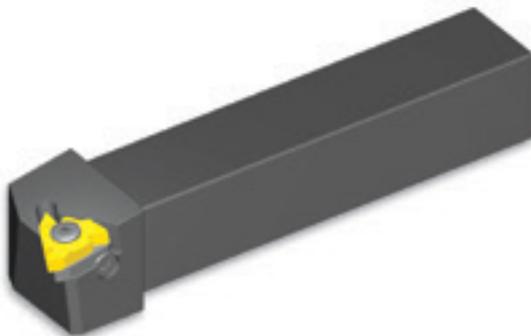


SA5T	M4x6(14D)	KT15	K5T
------	-----------	------	-----

14D holders are supplied without anvils. For specific applications, please use the anvils indicated in the table on page 202.



External Toolholders

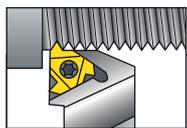


Off-Set Qualified (FQ)

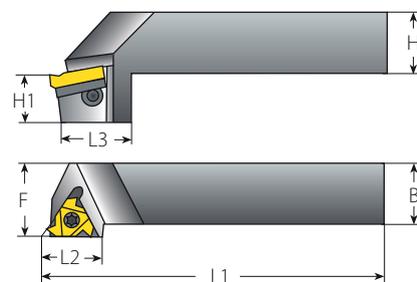
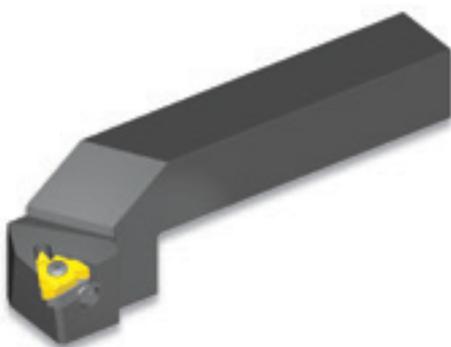
Spare Parts

Insert Size	Ordering Code	Dimensions mm			
IC	RH/LH	H=H1=B	F	L1	L2
3/8"	AL20-3FQ	20	25	125	25
	AL25-3FQ	25	32	150	25
	AL32-3FQ	32	40	170	32
1/2"	AL25-4FQ	25	32	150	30
	AL32-4FQ	32	40	170	30
5/8"	AL32-5FQ	32	40	170	35

Insert Screw	Anvil Screw	Torx Key	Anvil RH	Anvil LH
SA3T	SY3T	K3T	YE3	YI3
SA4T	SY4T	K4T	YE4	YI4
SA5T	SY5T	K5T	YE5	YI5



External Toolholders



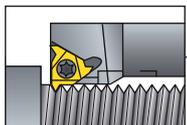
Drop Head-Qualified (CQ)

Spare Parts

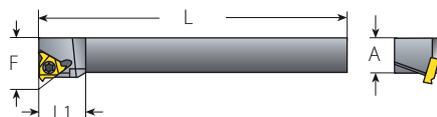
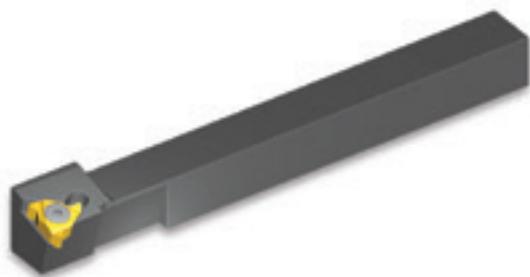
Insert Size	Ordering Code	Dimensions mm						
IC	RH/LH	H=B	F	L1	L2	L3	H1	
3/8"	AL20-3CQ	20	25	125	24	38	17.5	
	AL25-3CQ	25	32	150	24	38	22.2	
	AL32-3CQ	32	40	170	24	38	22.2	
1/2"	AL25-4CQ	25	32	150	30	38	22.2	
	AL32-4CQ	32	40	170	30	38	22.2	
5/8"	AL32-5CQ	32	40	170	33	43	25.4	

Insert Screw	Anvil Screw	Torx Key	Anvil RH	Anvil LH
SA3T	SY3T	K3T	YE3	YI3
SA4T	SY4T	K4T	YE4	YI4
SA5T	SY5T	K5T	YE5	YI5

The above toolholders have a 1.5° helix angle. For other helix angles see page 201.
 The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example AL20-3FQLH).

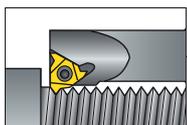


External + Internal Toolholders



Miniature Square Shank*

Miniature Square Shank*							Spare Parts	
Insert Size	Ordering Code	Dimensions mm				Min. Bore Dia.		
IC	RH/LH	A	L	L1 (max)	F	mm	Insert Screw	Torx Key
1/4"	OV8-2	8	100	25	12	29.2	SN2T	K2T
	OV10-2	10	100	25	14	36.1		



External + Internal Toolholders



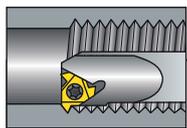
Miniature Round Shank*

Miniature Round Shank*								Spare Parts		
Insert Size	Ordering Code	Dimensions mm					Min. Bore Dia.			
IC	RH/LH	A	L	L1 (max)	D	D1	F	mm	Insert Screw	Torx Key
1/4"	OVR12-2	11.4	100	25	12	10	7.4	13	SN2T	K2T
	OVR15-2	14.3	100	32	15	13	8.9	16		
	OVR16D-2	15.3	100	32	16	13	8.9	16		

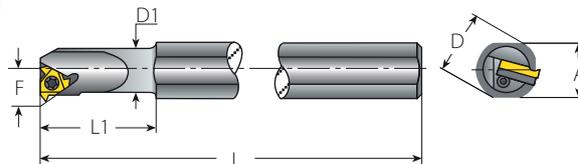
* Miniature square and round toolholders are designed for use on automatic lathes for the optical and other precision industries. They can be used for both external and internal threading, as follows:

Thread	ER	EL	IR	IL
Insert	ER	EL	IR	IL
Holder	LH	RH	RH	LH

Miniature toolholders have a 0.5° helix angle.
The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example OV8-2LH).



Internal Toolholders



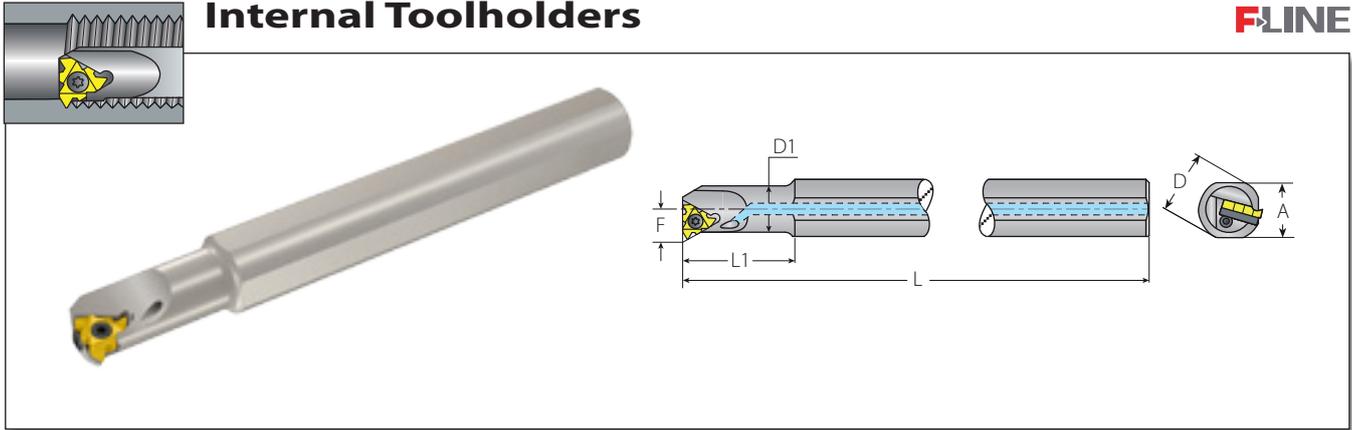
Standard

Spare Parts

Insert Size	Ordering Code	Dimensions mm							Min. Bore Dia.	Spare Parts				
		IC	RH/LH	A	L	L1 (max)	D	D1		F	mm	Insert Screw	Anvil Screw	Torx Key
1/4"	NVR10D-2	9.5	100	40	10	10.0	7.3	13						
	NVR10-2	18.0	180	25	20	10.0	7.3	13	SN2T	-	K2T	-	-	
	NVR13-2	18.0	180	32	20	13.0	8.9	16						
3/8"	NVR13-3	18.0	180	32	20	12.7	10.3	17						
	NVR16-3	18.0	180	40	20	16.0	11.5	20	SN3T	-	K3T	-	-	
	NVR16D-3	15.2	150	64	16	16.0	11.3	20						
	AVR20-3	18.0	180	80	20	20.0	13.4	24						
	AVR25-3	29.0	250	60	32	25.0	16.3	29						
	AVR25D-3	22.6	200	100	25	24.6	16.1	29	SA3T	SY3T	K3T	YI3	YE3	
	AVR32-3	29.0	250	128	32	32.0	19.6	36						
1/2"	AVR40-3	36.0	300	160	40	40.0	23.8	44						
	NVR20-4	18.0	180	80	20	20.0	15.6	27	SN4T	-	K4T	-	-	
	AVR25-4	29.0	250	60	32	25.0	17.4	32						
	AVR25D-4	22.6	200	45	25	24.6	17.2	32						
	AVR32-4	29.0	250	128	32	32.0	21.5	39	SA4T	SY4T	K4T	YI4	YE4	
	AVR40-4	36.0	300	160	40	40.0	25.8	47						
5/8"	AVR50-4	45.0	350	200	50	50.0	30.8	57						
	AVR32-5	29.0	250	128	32	32.0	22.4	40	SN5T	SY5T	K5T	YI5	YE5	
	AVR40-5	36.0	300	160	40	40.0	26.4	48						
	AVR50-5	45.0	350	200	50	50.0	31.4	58	SA5T	SY5T	K5T	YI5	YE5	
	AVR60-5	54.0	400	240	60	60.0	36.4	69						

- The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.
- Toolholders with prefix "N" cannot be used with an anvil.
- Holders with coolant channel are available as standard (Example NVRC10D-2).
- The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example NVR10D-2LH).

Internal Toolholders



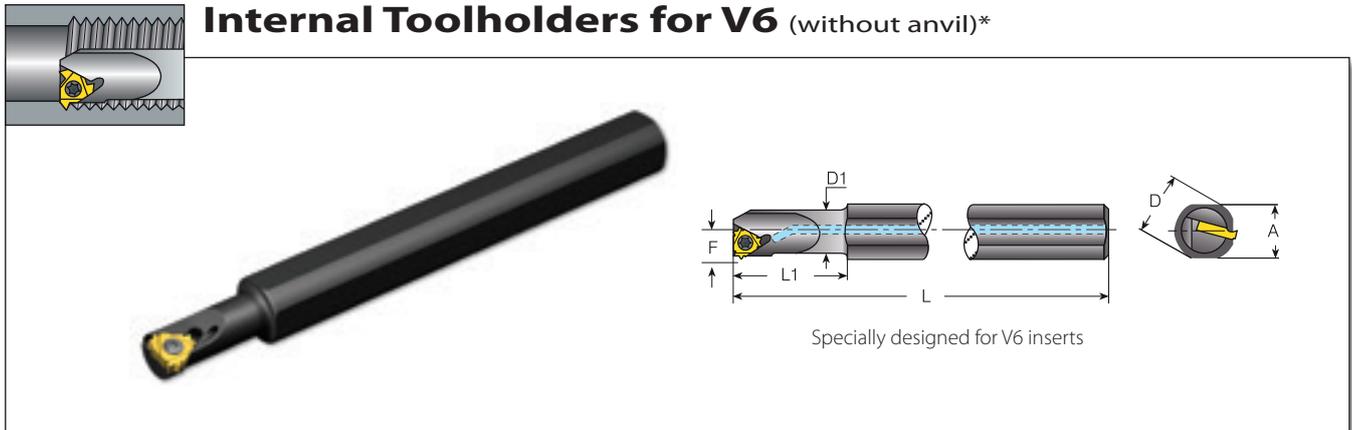
Standard F-Line

Spare Parts

Insert Size	Ordering Code	Dimensions mm							Min. Bore Dia.				
IC	RH	A	L	L1 (max)	D	D1	F	mm	Insert Screw	Anvil Screw	Torx Key	Anvil RH	
1/2" F	AVRC25-4F	29.0	250	60	32	25.0	17.9	32	SA4T	SY4T	K4T	Y14F	
	AVRC25D-4F	22.6	200	100	25	24.6	17.9	32					
	AVRC32-4F	29.0	250	128	32	32.0	21.6	39					
	AVRC40-4F	36.0	300	160	40	40.0	25.4	47					
	AVRC50-4F	45.0	350	200	50	50.0	30.6	57					

The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.

Internal Toolholders for V6 (without anvil)*



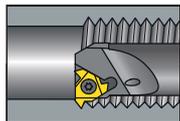
V6 Style

Spare Parts

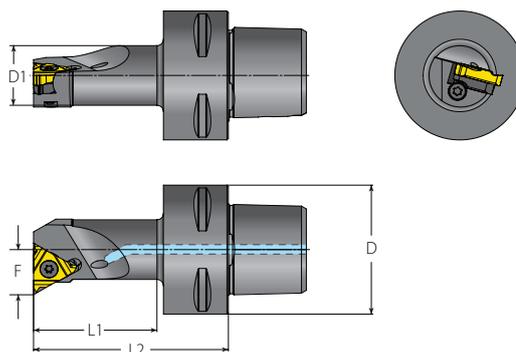


Insert Size	Ordering Code	Dimensions mm							Min. Bore Dia.		
IC	RH	A	L	L1 (max)	D	D1	F	mm	Insert Screw	Torx Key	
3/8" V6	NVRC13-3-206/001	18	180	32	20	12.7	10.3	17	SN3TM	K3T	
	NVRC16-3-206/002	18	180	40	20	16	11.5	20	SN3T		
	NVRC16D-3-206/003	15.2	150	64	16	16	11.3	20			

* V6 inserts cannot be used on standard internal toolholders without anvil. For this purpose you must use one of these special V6 toolholders. The above toolholders have a 1.5° helix angle.



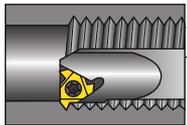
Internal Toolholders



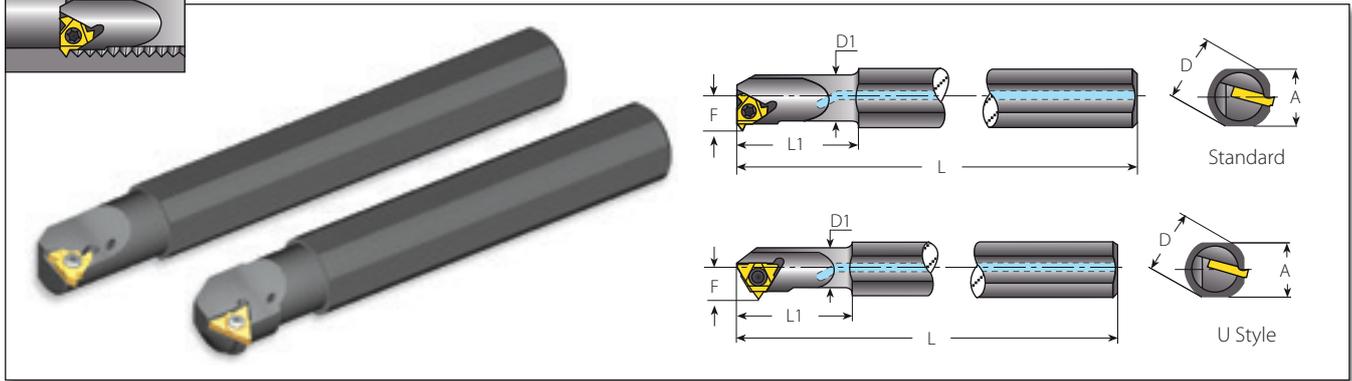
V-CAP

Insert Size		Ordering Code						Min. Bore Dia.	Spare Parts					
IC	RH/LH	D1	D	F	L2	L1 (max)	mm							
3/8"	VCAP40-SIR12060-3	15.5	40	12	60	37	20	SN3T	-	K3T	OD6	-	-	
	VCAP40-SIR14060-3	18.5		14	60	38	25	SA3T	SY3T	K3T	OD6	YI3	YE3	
	VCAP40-SIR17070-3	24.5		17	70	48	32							
	VCAP40-SIR22090-3	32.0		22	90	69	40							
	VCAP40-SIR27080-3	39.5	27	80	60	50	SN3T	-	K3T	OD6	-	-		
	VCAP50-SIR12060-3	15.5	50	12	60	35	20	SA3T	SY3T	K3T	OD6	YI3	YE3	
	VCAP50-SIR14060-3	18.5		14	60	36	25							
	VCAP50-SIR17070-3	24.5		17	70	47	32							
	VCAP50-SIR22090-3	32.0		22	90	68	40							
	VCAP50-SIR27105-3	40.0	27	105	84	50	SA3T	SY3T	K3T	OD8	YI3	YE3		
	VCAP63-SIR14070-3	18.5	63	14	70	42							25	
	VCAP63-SIR17075-3	24.5		17	75	48							32	
VCAP63-SIR22090-3	32.0	22		90	64	40								
VCAP63-SIR27105-3	40.0	27		105	80	50								

The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.
The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example VCAP40-SIL12060-3**LH**).



Internal Toolholders

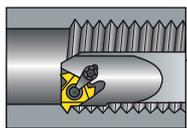


Standard for Coarse Pitch

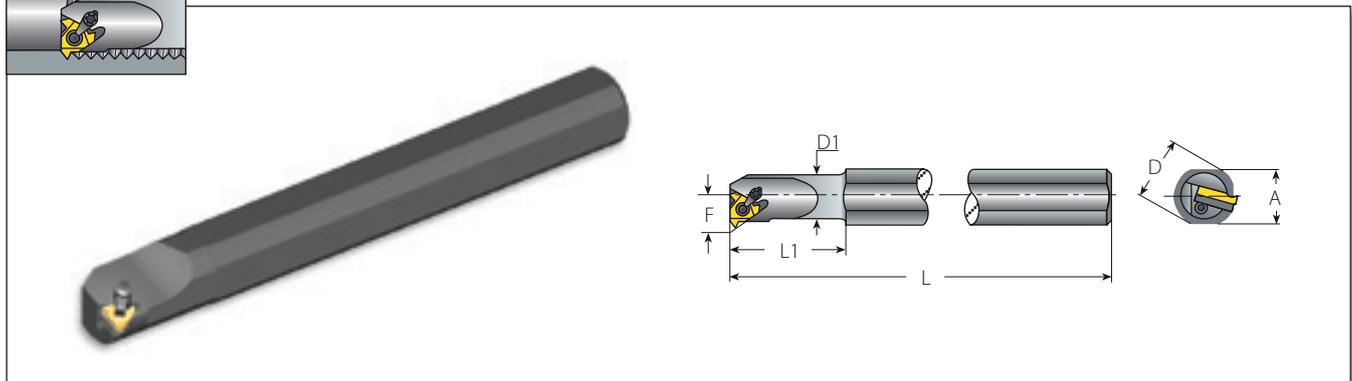
Standard for Coarse Pitch										Spare Parts	
Insert Size	Ordering Code		Dimensions mm				F to Insert	Holder Helix			
IC	RH	LH	A	L	L1 (max)	D	D1	mm	Deg.	Insert Screw	Torx Key
1/4"	NVRC10-2-156/001	NVRC10-2LH-156/036	18.0	180	25.0	20	10.1	6.53	3.0	SN2T	K2T
3/8"	NVRC11-3-156/005	NVRC11-3LH-156/025	18.0	180	25.4	20	11.2	8.30	4.5	SN3TM	K3T
	NVRC13-3-156/006	NVRC13-3LH-156/028	18.0	180	32.0	20	13.0	9.05	4.0	SN3T	K3T
	NVRC13-3-156/016	NVRC13-3LH-156/026	18.0	180	34.0	20	13.8	8.90	2.5		
1/2"	NVRC17-4-156/007	NVRC17-4LH-156/023	18.0	180	40.0	20	16.7	11.45	4.0	SN4TM	K4T
	NVRC20-4-156/008	NVRC20-4LH-156/024	18.0	180	50.0	20	19.6	12.55	3.5	SN4T	K4T
	NVRC20-4-156/009	NVRC20-4LH-156/033	18.0	180	50.0	20	19.6	12.55	3.0		
5/8"	NVRC25-5-156/012	NVRC25-5LH-156/017	29.0	250	60.0	32	25.0	16.78	3.3	SN5TM	K5T
	NVRC28-5-156/010	NVRC28-5LH-156/034	29.0	250	50.0	32	28.0	17.80	3.5		

U Style for Coarse Pitch

U Style for Coarse Pitch										Spare Parts	
Insert Size	Ordering Code		Dimensions mm				F to Insert	Holder Helix			
IC	RH	LH	A	L	L1 (max)	D	D1	mm	Deg.	Insert Screw	Torx Key
6.0U	NVRC8-6.0U-156/003	NVRC8-6.0ULH-156/037	18.0	180	24.0	20	8.0	5.86	4.0	SN6MT	K6MT
1/4"U	NVRC10-2U-156/004	NVRC10-2ULH-156/038	18.0	180	32.0	20	10.0	7.40	4.0	SM2T8	K2T
	NVRC11-2U-156/002	NVRC11-2ULH-156/035	18.0	180	32.0	20	11.2	7.30	3.0		
3/8"U	NVRC11-3U-156/020	NVRC11-3ULH-156/029	18.0	180	32.0	20	11.0	8.23	4.5		
	NVRC14-3U-156/018	NVRC14-3ULH-156/030	18.0	180	38.0	20	13.4	9.99	4.5	SN3TM	K3T
	NVRC15-3U-156/019	NVRC15-3ULH-156/031	18.0	180	38.0	20	15.4	10.99	4.0		
1/2"U	NVRC20-4U-156/011	NVRC20-4ULH-156/021	18.0	180	40.0	20	19.2	13.68	4.0	SN4T	K4T
	NVRC25-4U-156/013	NVRC25-4ULH-156/032	29.0	250	60.0	32	25.0	17.63	3.5		
	NVRC32-4U-156/014	NVRC32-4ULH-156/022	29.0	250	60.0	32	29.7	18.76	3.3	SA4T	K4T
5/8"U	NVRC32-5U-156/015	NVRC32-5ULH-156/027	29.0	250	60.0	32	31.6	20.96	3.2	SN5T	K5T



Internal Toolholders



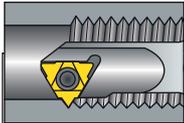
Standard with Clamp

(Dual System, Screw or Clamp)

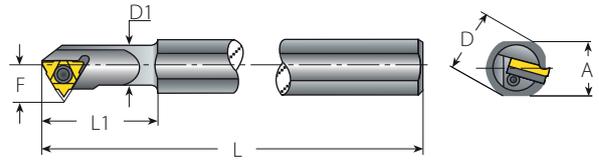
Spare Parts

Insert Size		Ordering Code		Dimensions mm					Min. Bore Dia.	Spare Parts					
IC	RH/LH	A	L	L1 (max)	D	D1	F	mm							
3/8"	AVR20-3C	18.0	180	80	20	20.0	13.4	24	SA3T	SY3T	C3	K3CT	YI3	YE3	
	AVR25-3C	28.0	250	60	32	25.0	16.3	29							
	AVR25D-3C	22.6	200	100	25	24.6	16.1	29							
	AVR32-3C	29.0	250	128	32	32.0	19.6	36							
1/2"	AVR40-3C	36.0	300	160	40	40.0	23.8	44	SA4T	SY4T	C4	K4T	YI4	YE4	
	AVR25-4C	29.0	250	128	32	25.0	17.4	32							
	AVR25D-4C	22.6	200	100	25	24.6	17.2	32							
	AVR32-4C	29.0	250	128	32	32.0	21.5	39							
5/8"	AVR40-4C	36.0	300	160	40	40.0	25.8	47	SN5T	SY5T	C5	K5T	YI5	YE5	
	AVR32-5C	29.0	250	128	32	32.0	22.4	40							
	AVR40-5C	36.0	300	160	40	40.0	26.4	48							
	AVR50-5C	45.0	350	200	50	50.0	31.4	58							
	AVR60-5C	54.0	400	240	60	60.0	36.4	69	SA5T	SY5T	C5	K5T	YI5	YE5	

- The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.
- Holders with coolant channel available as standard (Example AVR**C**20-3C).
- The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example AVR20-3**CLH**).



Internal Toolholders



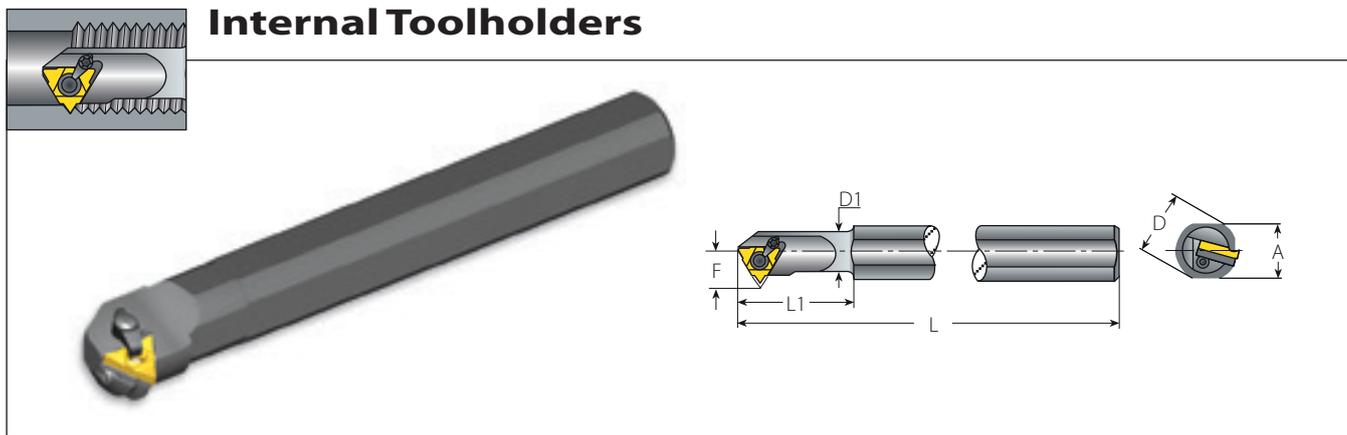
U Style

Spare Parts

Insert Size		Ordering Code							Dimensions mm					Min. Bore Dia.	Spare Parts				
IC	RH/LH	A	L	L1 (max)	D	D1	F	mm	Insert Screw	Anvil Screw	Torx Key	Anvil RH	Anvil LH						
1/2"U	AVR32-4U	29	250	128	32	32	25.5	42	SA4T	SY4T	K4T	YI4U	YE4U						
	AVR40-4U	36	300	160	40	40	29.5	51											
5/8"U	NVR32-5U	29	250	128	32	32	24.7	42	SN5T	-	K5T	-	-						
	AVR40-5U	36	300	160	40	40	29.4	51											
	AVR50-5U	45	350	200	50	50	34.3	63	SA5T	SY5T	K5T	YI5U	YE5U						
	AVR60-5U	54	400	240	60	60	39.3	74											

- The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.
- Holders with coolant channel available as standard (Example AVRC32-4U).
- The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example AVR32-4ULH).

Internal Toolholders



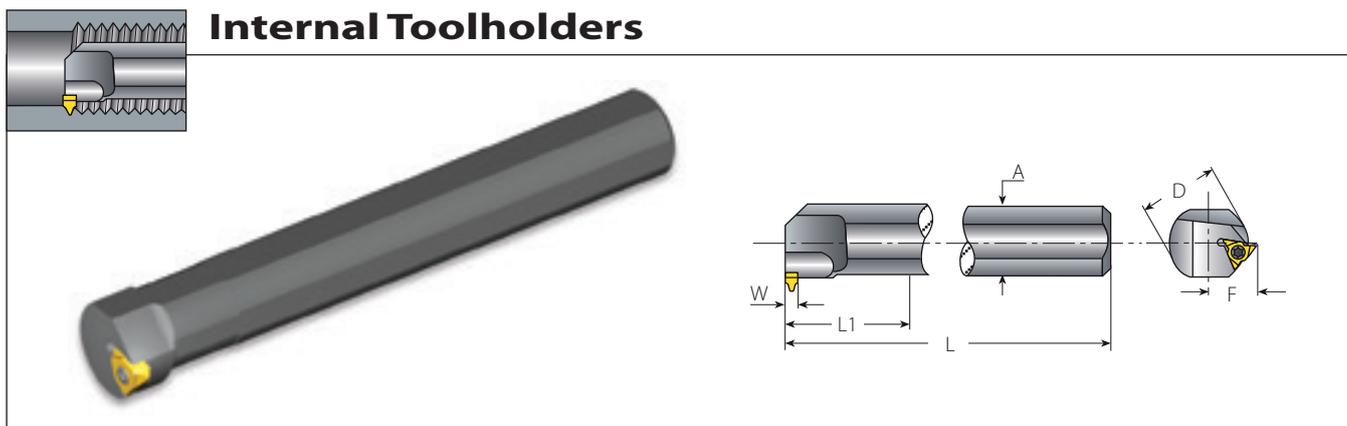
U style with Clamp (Dual System, Screw or Clamp)

Spare Parts

Insert Size		Ordering Code							Dimensions mm						Min. Bore Dia.
IC	RH/LH	A	L	L1 (max)	D	D1	F	mm	Insert Screw	Anvil Screw	Clamp	Torx Key	Anvil RH	Anvil LH	
1/2"U	AVR32-4UC	29.0	250	128	32	32.0	25.5	42	SA4T	SY4T	C4	K4T	Y14U	YE4U	
	AVR40-4UC	36.0	300	160	40	40.0	29.5	51							
5/8"U	AVR40-5UC	36.0	300	160	40	40.0	29.4	53	SA5T	SY5T	C5	K5T	Y15U	YE5U	
	AVR50-5UC	45.0	350	200	50	50.0	34.4	63							
	AVR60-5UC	54.0	400	240	60	60.0	39.3	74							

The above toolholders have a 1.5° helix angle. For other helix angles, see page 201.

Internal Toolholders



V Style

Spare Parts

Insert Size		Ordering Code							Dimensions mm	
IC	RH/LH	A	L	L1 (max)	D	F	W	Insert Screw	Torx Key	
5/8"V	NVR40-5V	36	300	160	40	28.4	6.5	SN6T	K6T	
	NVR50-5V	45	350	200	50	33.4	6.5			
	NVR60-5V	54	400	240	60	38.0	6.5			

The above toolholders have a 1.0° helix angle.

Minimum Bore Diameter

	Pitch mm	6.0 ISO	8.0 ISO	10.0 ISO
Holder	Pitch tpi	4 UN	3 UN	2.5 W
NVR40-5V		48	54	62
NVR50-5V		58	58	62
NVR60-5V		68	68	68

The above toolholders are for RH inserts. For LH inserts, add LH to the toolholder's ordering code (Example AVR32-4UCLH). Holders with coolant channel available as standard (Example AVR32-4UC).