

Mini-3 IC 4.0

VARGUS 

Indexable Threading Inserts
for Small Bores

Min. \varnothing 6.1mm

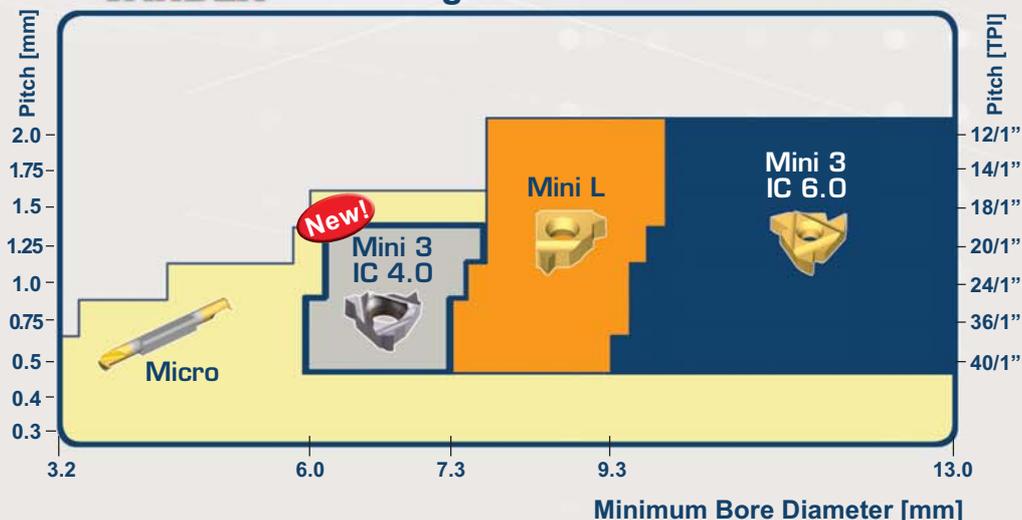
NEW!

Min. Bore \varnothing 6.1mm

Mini-3 Advantages:

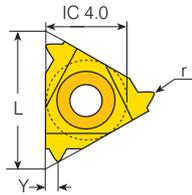
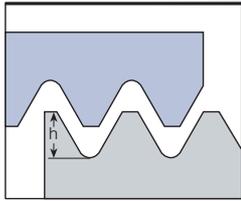
- For threading bores as small as 6.1mm diameter
- 3 cutting edges
- Specialty grades optimized for your application: VBX for Steels; VTX for Stainless Steel
- Rigid carbide shank toolholder with coolant channel

VARDEX Threading Solutions for Small Bores



VARDEX Threading Solutions

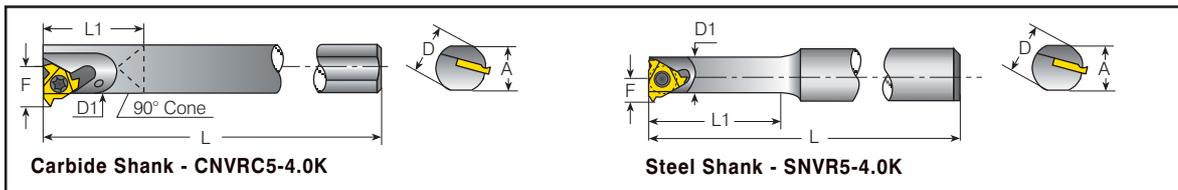
Mini-3 IC 4.0 - Inserts



	Insert Size		Pitch		Ordering Code	Dimensions (mm)				
	IC mm	L mm	mm	tpi	RH	hmin	Y	F	Min Bore Dia. mm	
Partial 60°	4.0	6	0.5-1.25	48-20	4.0KIRA60...	r=0.05	0.6	3.7	6.35	
Partial 55°	4.0	6	0.5-1.25	48-20	4.0KIRA55...	r=0.05	0.6	3.8	6.45	
UN	4.0	6		32	4.0KIR32UN...	0.46	0.5	3.5	6.15	
				28	4.0KIR28UN...	0.52	0.6	3.5	6.15	
				24	4.0KIR24UN...	0.61	0.6	3.6	6.25	
				20	4.0KIR20UN...	0.73	0.6	3.7	6.35	
				18	4.0KIR18UN...	0.81	0.7	3.7	6.35	
ISO Metric	4.0	6		0.5	4.0KIR0.5ISO...	0.29	0.5	3.4	6.05	
				0.75	4.0KIR0.75ISO...	0.43	0.5	3.5	6.15	
				1.0	4.0KIR1.0ISO...	0.58	0.6	3.6	6.25	
			1.25	4.0KIR1.25ISO...	0.72	0.6	3.7	6.35		
NPT	4.0	6		27	4.0KIR27NPT...	0.66	0.6	3.7	6.35	
NPTF	4.0	6		27	4.0KIR27NPTF...	0.64	0.6	3.6	6.25	
W	4.0	6		26	4.0KIR26W...	0.63	0.6	3.6	6.25	
				22	4.0KIR22W...	0.74	0.6	3.7	6.35	
				20	4.0KIR20W...	0.81	0.7	3.7	6.35	
			18	4.0KIR18W...	0.90	0.7	3.7	6.35		
BSPT	4.0	6		28	4.0KIR28BSPT..	0.58	0.6	3.6	6.25	

Left handed tools supplied by request (Example: 4.0KIL32UNVBX)

Mini-3 IC 4.0 - Holders



Spare Parts

Insert Size	Holder Ordering Code	Dimensions (mm)					Min. Bore Dia.	Insert Screw	Torx Key
IC		A	L	L1	D	D1	mm		
4.0mm	CNVRC5-4.0K	5.2	100	26	6	5.1	6.1	SN4MT	K6MT
	SNVR5-4.0K	11.0	100	12	12	5.1	6.1		

For left hand toolholders, add LH to the ordering code (Example: SNVR5-4.0K LH)

Recommended Grades and Cutting Speeds Vc [m/min]

Selected Popular Materials	Hardness Brinell HB	Vc[m/min]	
		VBX	VTX
P Unalloyed steel Medium carbon	150	120-180	130-180
P Low alloy steel Non hardened	180	100-155	110-155
M Stainless steel Austenitic	180	60-100	70-100
K Aluminum alloys & non-ferrous Non aging	60	80-240	90-240

For the complete list of materials & cutting conditions, see the Vardex main catalog.

Grades and Applications

Grade	Application
VBX	TiCN coated carbide grade. Excellent grade for Steels and general use.
VTX	TiAlN coated carbide grade. Ideal for Stainless Steels.

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