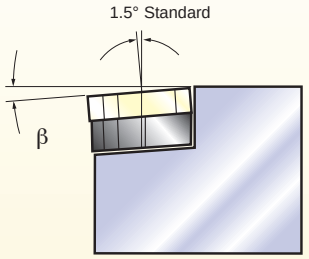
STELLRAM

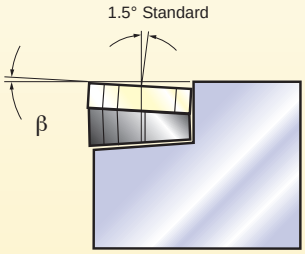
With the Stellram threading system, a wide range of thread helix angles can be obtained without changing or modifying toolholders. This is obtained by simply changing the carbide anvil.

Most toolholders are produced with 1.5° helix machined into the body. These tools are supplied with this angle as standard.

Interchangeable anvils allow helix variations between +4.5° and -1.5° with the insert cutting edge remaining constant.

Negative helix angles are used for producing right hand threads with left hand holders or left hand threads with right hand holders.





Negative Helix

			ß Helix Angle							
Insert size		Toolholder	4.5°	3.5°	2.5°	1.5°	0.5°	0°	-0.5°	-1.5°
mm	Inch		Anvil Part Numbers							
16	3/8"	EX RH / IN LH	YE33P	YE32P	YE31P	YE3	YE31N	YE31.5N	YE32N	YE33N
		EX LH / IN RH	YI33P	YI32P	YI31P	YI3	YI31N	YI31.5N	YI32N	YI33N
22	1/2"	EX RH / IN LH	YE43P	YE42P	YE41P	YE4	YE41N	YE41.5N	YE42N	YE43N
		EX LH / IN RH	YI43P	YI42P	YI41P	YI4	YI41N	YI41.5N	YI42N	YI43N
22U	1/2"	EX RH / IN LH	YE4U3P	YE4U2P	YE4U1P	YE4U	YE4U1N	YE4U1.5N	YE4U2N	YE4U3N
		EX LH / IN RH	YI4U3P	YI4U2P	YI4U1P	YI4U	YI4U1N	YI4U1.5N	YI4U2N	YI4U3N
27	5/8"	EX RH / IN LH	YE53P	YE52P	YE51P	YE5	YE51N	YE51.5N	YE52N	YE53N
		EX LH / IN RH	YI53P	YI52P	YI51P	YI5	YI51N	YI51.5N	YI52N	YI53N
27U	5/8"	EX RH / IN LH	YE5U3P	YE5U2P	YE5U1P	YE5U	YE5U1N	YE5U1.5N	YE5U2N	YE5U3N
		EX LH / IN RH	YI5U3P	YI5U2P	YI5U1P	YI5U	YI5U1N	YI5U1.5N	YI5U2N	YI5U3N

Note: Standard toolholders are supplied with 1.5° helix angle as standard.

Calculation of thread helix angle for a given thread

$$\text{Helix angle - } \tan^{-1}\theta = \frac{\text{Lead of the Thread}}{\text{Pitch/Effective Diameter x } \pi}$$