

NEW

 **Carmex**
Precision Tools Ltd.
x-treme thread cutting™

Slim MT

High productivity, Slim cost



Inch 2019-20

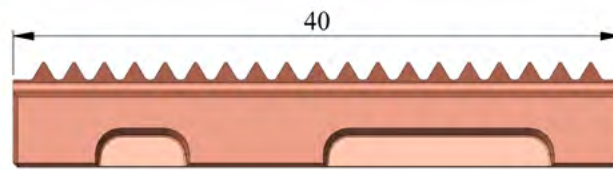
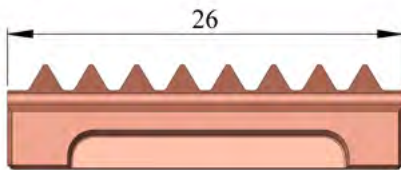
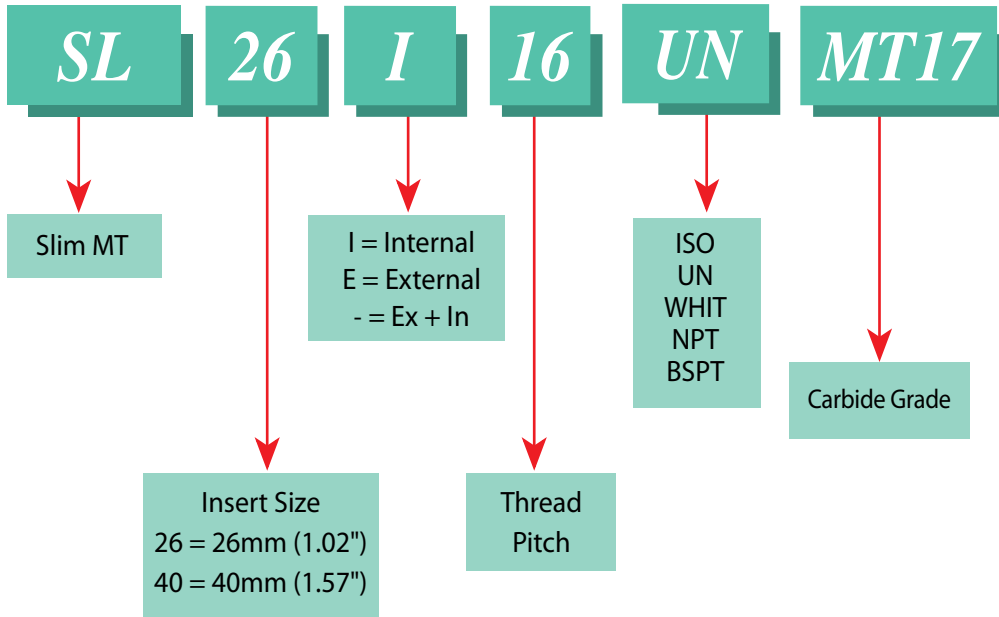
Carmex presents Slim MT ***High productivity, Slim cost.***

A new product line of indexable Mill-Thread inserts and tool holders including multiple straight flutes for machining long threads from small to large diameters.

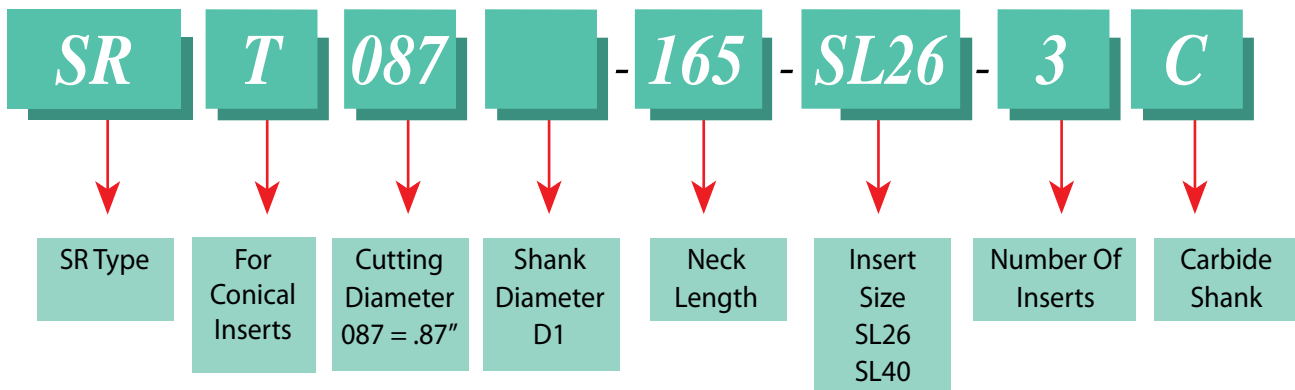
- **Advanced carbide and coating combination for extended tool life and improved productivity.**
- **Most inserts are double sided.**
- **Nickel coated holders for high wear resistance.**
- **Unique clamping mechanism.**
- **Large variety of holders & inserts in accordance to international standards.**

Product Identification

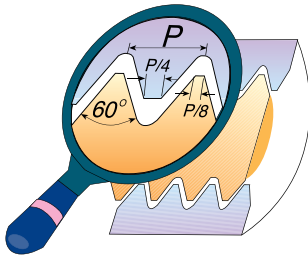
Inserts



Toolholders



ISO



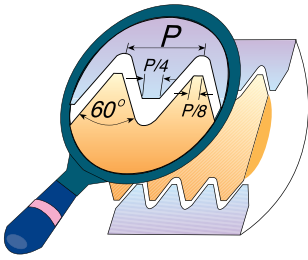
Insert size	Pitch mm	Ex/In	Ordering code	Toolholder
SL 26	0.5	In	SL26 I 0.5 ISO	SR - SL26 - ...
	0.75	In	SL26 I 0.75 ISO	
	1.0	In	SL26 I 1.0 ISO	
	1.0	Ex	SL26 E 1.0 ISO	
	1.5	In	SL26 I 1.5 ISO	
	1.5	Ex	SL26 E 1.5 ISO	
	2.0	In	SL26 I 2.0 ISO	
	2.0	Ex	SL26 E 2.0 ISO	
	2.5	In	SL26 I 2.5 ISO	
	2.5	Ex	SL26 E 2.5 ISO	
	3.0	In	* SL26 I 3.0 ISO	
	3.0	Ex	* SL26 E 3.0 ISO	
	SL 40	1.5	In	
2.0		In	SL40 I 2.0 ISO	
2.5		In	SL40 I 2.5 ISO	
3.0		In	SL40 I 3.0 ISO	

* Cannot be used with toolholder SR067- ... -SL26-2

For tool holders see pages 8-9.

For carbide grade and cutting speed see page 11.

UN



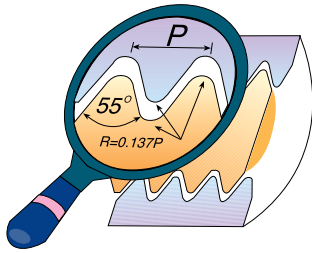
Insert size	Pitch TPI	Ex/In	Ordering code	Toolholder
SL 26	20	In	SL26 I 20 UN	SR - SL26 - ...
	20	Ex	SL26 E 20 UN	
	18	In	SL26 I 18 UN	
	18	Ex	SL26 E 18 UN	
	16	In	SL26 I 16 UN	
	16	Ex	SL26 E 16 UN	
	14	In	SL26 I 14 UN	
	14	Ex	SL26 E 14 UN	
	12	In	SL26 I 12 UN	
	12	Ex	SL26 E 12 UN	
	10	In	SL26 I 10 UN	
	10	Ex	SL26 E 10 UN	
	9	In	* SL26 I 9 UN	
	8	In	* SL26 I 8 UN	
SL 40	16	In	SL40 I 16 UN	SR - SL40 - ...
	14	In	SL40 I 14 UN	
	12	In	SL40 I 12 UN	
	10	In	SL40 I 10 UN	
	8	In	SL40 I 8 UN	

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For carbide grade and cutting speed see page 11.

WHIT BSW, BSF, BSP



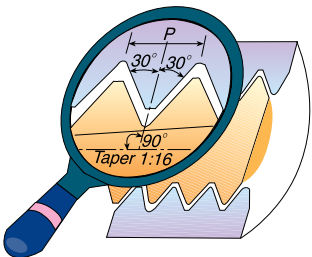
Same insert for External and Internal thread

Insert size	Pitch TPI	Ordering code	Toolholder
SL 26	14	SL 26 - 14 W	SR - SL26 - ...
	11	SL 26 - 11 W	
SL 40	14	SL 40 - 14 W	SR - SL40 - ...
	11	SL 40 - 11 W	

For tool holders see pages 8-9.

For carbide grade and cutting speed see page 11.

NPT



Conical pipe thread inserts are one-sided and may be used for both External and Internal threading

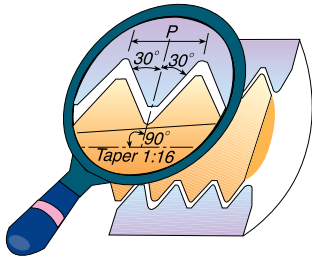
Insert size	Pitch TPI	Ordering code	Toolholder
SL 26	14	SL 26 - 14 NPT	SR - SL26 - ...
	11.5	* SL 26 - 11.5 NPT	

* Cannot be used with toolholder SRT067-...-SL26-2

For tool holders see pages 8-9.

For carbide grade and cutting speed see page 11.

NPTF



Conical pipe thread inserts are one-sided and may be used for both External and Internal threading

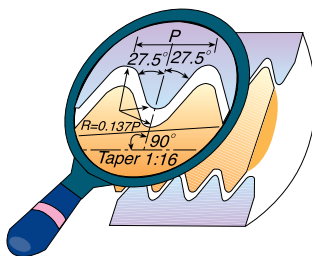
Insert size	Pitch TPI	Ordering code	Toolholder
SL 26	14	SL 26 - 14 NPTF	SR - SL26 - ...
	11.5	* SL 26 - 11.5 NPTF	

* Cannot be used with toolholder SRT067-...-SL26-2

For tool holders see pages 8-9.

For carbide grade and cutting speed see page 11.

BSPT



Conical pipe thread inserts are one-sided and may be used for both External and Internal threading

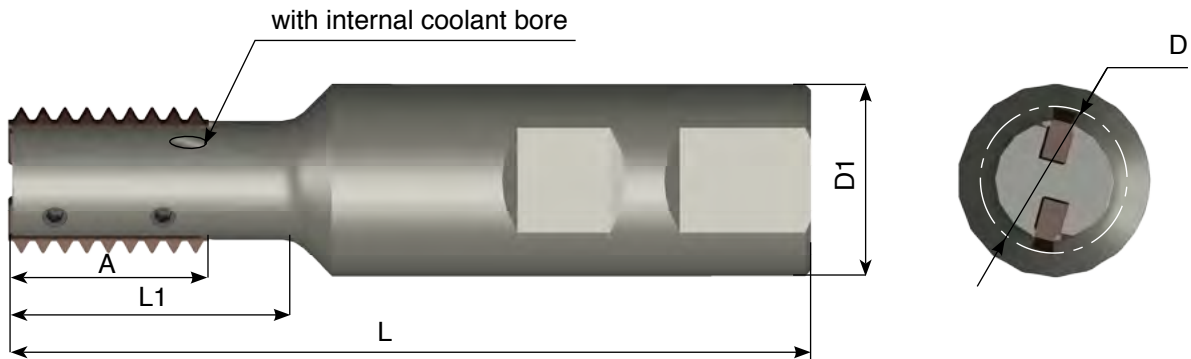
Insert size	Pitch TPI	Ordering code	Toolholder
SL 26	14	SL 26 - 14 BSPT	SR - SL26 - ...
	11	* SL 26 - 11 BSPT	

* Cannot be used with toolholder SRT067-...-SL26-2

For tool holders see pages 8-9.

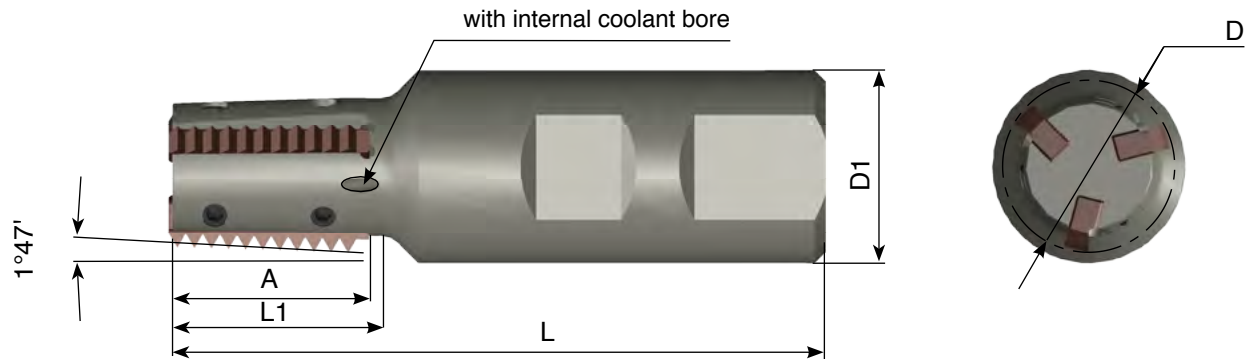
For carbide grade and cutting speed see page 11.

Toolholders



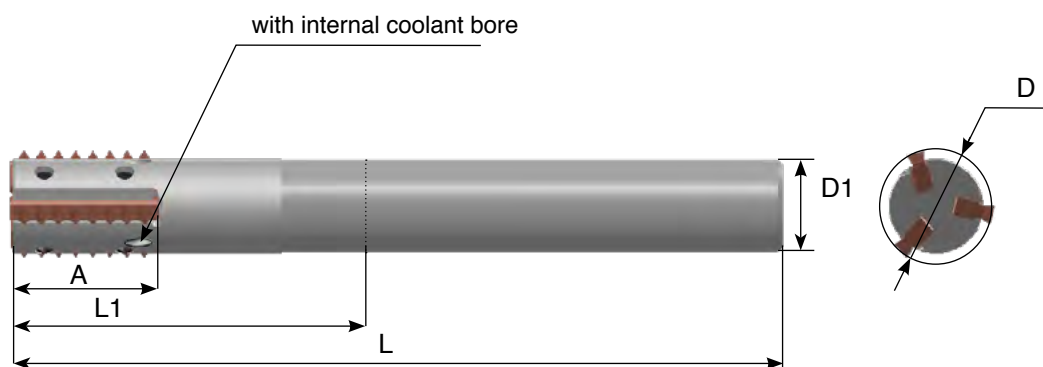
Ordering Code	Insert size=A	D	D1	L	L1	No. of Inserts	Screw	Key
SR 067-075-106-SL26-2	SL 26	.67	.75	3.75	1.06	2	S4P	K08P
SR 067-075-142-SL26-2		.67	.75	4.15	1.42	2	S4P	K08P
SR 067-106-SL26-2		.67	1	3.75	1.06	2	S4P	K08P
SR 067-142-SL26-2		.67	1	4.15	1.42	2	S4P	K08P
SR 075-106-SL26-2		.75	1	3.75	1.06	2	S4P	K08P
SR 075-157-SL26-2		.75	1	4.35	1.57	2	S4P	K08P
SR 081-106-SL26-3		.81	1	3.75	1.06	3	S4P	K08P
SR 081-157-SL26-3		.81	1	4.35	1.57	3	S4P	K08P
SR 081-225-SL26-2		.81	1	5.00	2.25	2	S4P	K08P
SR 087-110-SL26-3		.87	1	3.75	1.10	3	S4P	K08P
SR 087-165-SL26-3		.87	1	4.35	1.65	3	S4P	K08P
SR 087-225-SL26-2		.87	1	5.00	2.25	2	S4P	K08P
SR 118-315-SL26-3		1.18	1	5.90	3.15	3	S4P	K08P
SR 087-165-SL40-3		SL 40	.87	1	4.35	1.65	3	S4P
SR 087-250-SL40-2	.87		1	5.25	2.50	2	S4P	K08P
SR 118-165-SL40-4	1.18		1.25	4.95	1.65	4	S4P	K08P
SR 118-315-SL40-3	1.18		1.25	5.90	3.15	3	S4P	K08P

Toolholders for Conical Threads



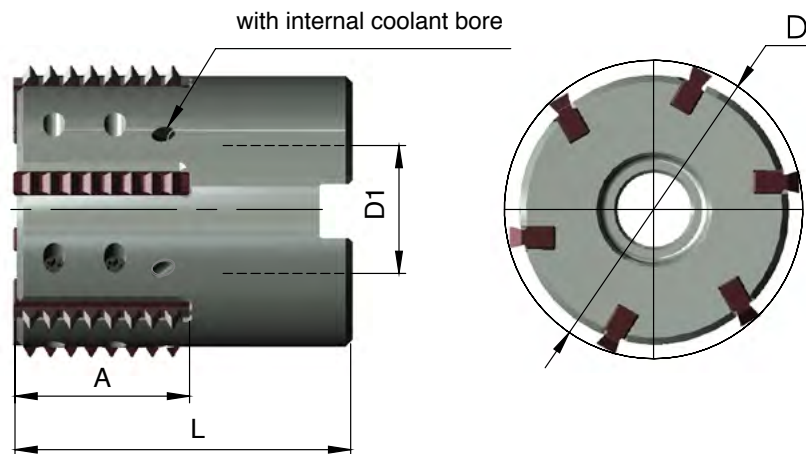
Ordering Code	Insert size=A	D	D1	L	L1	No. of Inserts	Screw	Key
SR T 067-075-106-SL26-2	SL 26	.67	.75	3.75	1.06	2	S4P	K08P
SR T 067-106-SL26-2		.67	1	3.75	1.06	2	S4P	K08P
SR T 087-106-SL26-3		.87	1	3.75	1.06	3	S4P	K08P
SR T 106-106-SL26-4		1.06	1	3.75	1.06	4	S4P	K08P

Carbide Shank Toolholders



Ordering Code	Insert size=A	D	D1	L	L1	No. of Inserts	Screw	Key
SR 075-440-SL26-2 C	SL 26	.75	.625	7.00	4.40	2	S4P	K08P
SR 081-540-SL26-3 C		.81	.625	8.00	5.40	3	S4P	K08P
SR 100-740-SL26-3 C		1.00	.750	10.00	7.40	3	S4P	K08P

Multi-Insert Toolholders



Ordering Code	Insert size=A	D	D1	L	No. of Inserts	Screw	Key
SR 150-050-SL26-5	SL 26	1.50	.50	1.97	5	S4P	K08P
SR 175-075-SL26-6		1.75	.75	1.97	6	S4P	K08P
SR 175-075-SL40-6	SL 40	1.75	.75	2.56	6	S4P	K08P

Cutting Data

MT17 Advanced NEW submicron carbide grade with multi-layer PVD coating, provides high performance in all machining conditions. The new grade ensures high abrasive wear resistance, machining wide range of materials including steels, tough and difficult materials and high alloyed steels.

ISO	Material	Conditions	Cutting Conditions	
			Cutting Speed (ft/min)	Feed Rate (inch/tooth)
P	Non-Alloy Steel and Cast Steel, Free Cutting Steel	Annealed < 0.25% C Annealed ≥ 0.25% C Annealed ≥ 0.55% C Quenched & Tempered < 0.55% C Quenched & Tempered ≥ 0.55% C	360-720 330-690 295-490 230-460 180-230	(.0022 * D) / .87
	Low Alloy Steel and Cast Steel (less than 5% alloying elements)	Annealed Quenched & Tempered	200-360 200-295	(.0022 * D) / .87
	High Alloy Steel, Cast Steel, and Tool Steel	Annealed	180-295	
Quenched & Tempered		150-260		
M	Stainless Steel and Cast Steel	Ferritic Martensitic Austenitic	295-655 260-520 200-360	(.0022 * D) / .87
		High alloy Austenitic & Duplex	130-230	(.0018 * D) / .87
K	Cast Iron Nodular (GGG)	Ferritic	295-410	(.0022 * D) / .87
		Pearlitic	295-360	
	Grey Cast Iron (GG)	Ferritic	360-475	
		Pearlitic	260-410	
	Malleable Cast Iron	Ferritic	360-410	
		Pearlitic	260-390	
N	Aluminum-Wrought Alloy	Not Cureable	440-1150	(.0020 * D) / .87
		Cured	330-885	
	Aluminum-Cast, Alloyed	Not Cureable ≤ 12% Si	295-885	
		Cured	295-740	
		High Temperature > 12% Si	295-590	
	Copper Alloys	Free Cutting > 1% Pb	230-740	
Brass Electrolytic Copper		230-590 230-885		
Non Metallic	Duroplastics, Fiber Plastics Hard Rubber	230-885 230-885		
S	High Temperature/Super Alloys (Fe based)	Annealed Cured	100-160	(.0015 * D) / .87
	High Temperature/Super Alloys (Ni or Co based)	Annealed	80-150	
		Cured Cast		
	Titanium Alloys	Alpha + Beta Alloys Cured	100-130	

D= Cutting diameter.

