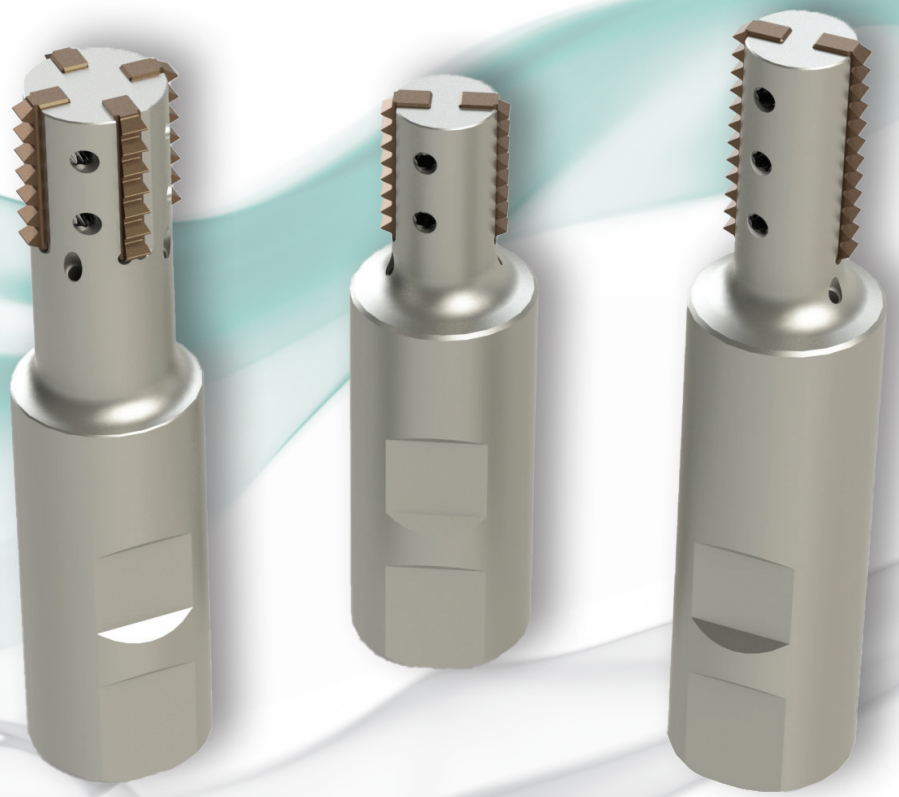
Carmex
Precision Tools Ltd.
x-treme thread cutting™

NEW

Slim MT

High productivity, Slim cost



Metric 2019

Carmex presents Slim MT

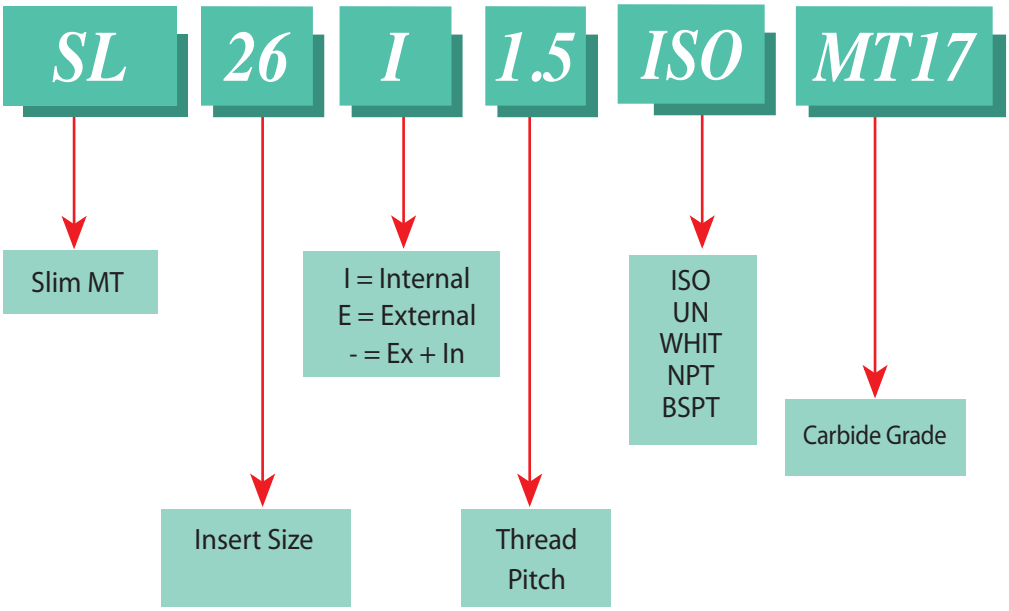
High productivity, Slim cost.

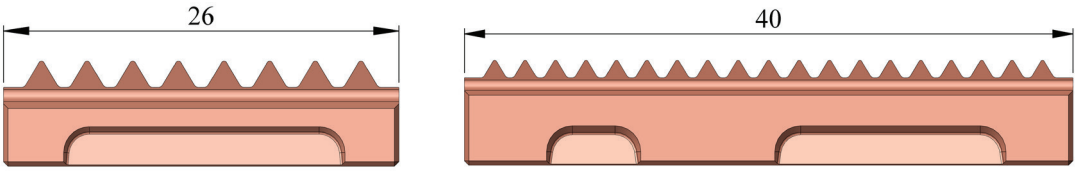
A new product line of indexable Mill-Thread inserts and tool holders including multiple straight flutes for machining long threads from small to large diameters.

- **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.**

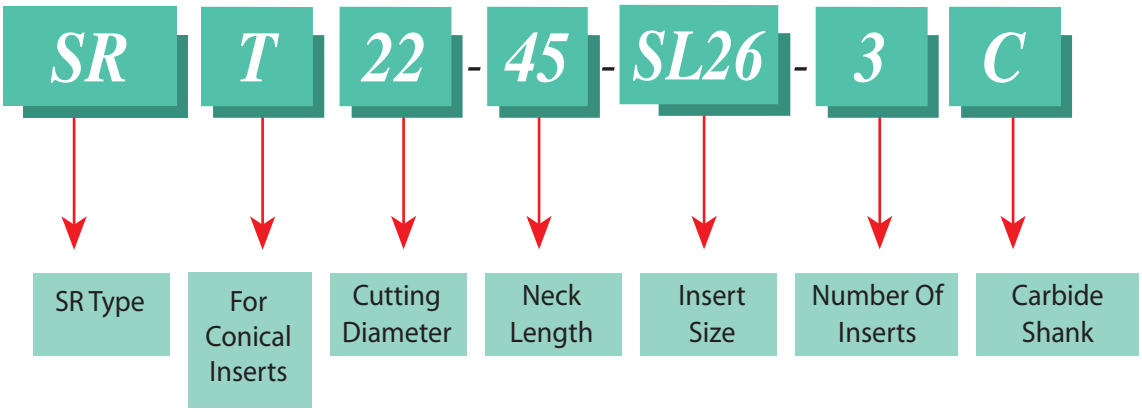
Product Identification

Inserts

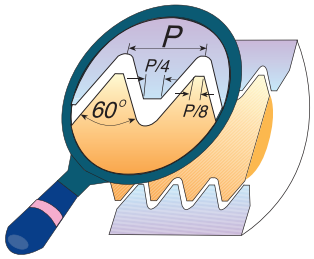




Toolholders



ISO

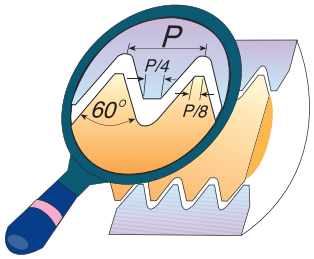


Insert size	Pitch mm	Ex/In	Ordering code	Toolholder
SL 26	0.5	In	**SL26 I 0.5 ISO**	SR ….. - SL26 - …
	0.75	In	**SL26 I 0.75 ISO**	
	1.0	In	**SL26 I 1.0 ISO**	
	1.0	Ex	**SL26 E 1.0 ISO**	
	1.5	In	**SL26 I 1.5 ISO**	
	1.5	Ex	**SL26 E 1.5 ISO**	
	2.0	In	**SL26 I 2.0 ISO**	
	2.0	Ex	**SL26 E 2.0 ISO**	
	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	**SL40 I 1.5 ISO**	SR ….. - SL40 - …
	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 SR17- … -SL26-2

For tool holders see pages 8-9.
For carbide grade and cutting speed see page 10.

UN

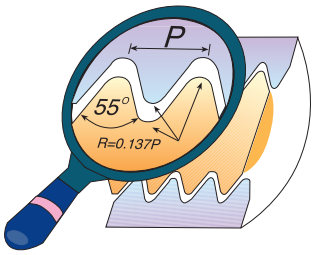


Insert size	Pitch TPI	Ex/In	Ordering code	Toolholder
SL 26	20	In	**SL26 I 20 UN**	SR ….. - SL26 - …
	20	Ex	**SL26 E 20 UN**	
	18	In	**SL26 I 18 UN**	
	18	Ex	**SL26 E 18 UN**	
	16	In	**SL26 I 16 UN**	
	14	In	**SL26 I 14 UN**	
	12	In	**SL26 I 12 UN**	
	12	Ex	**SL26 E 12 UN**	
	10	In	**SL26 I 10 UN**	
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

* Cannot be used with toolholder SR17- … -SL26-2

For tool holders see pages 8-9.
For carbide grade and cutting speed see page 10.

WHIT BSW, BSF, BSP

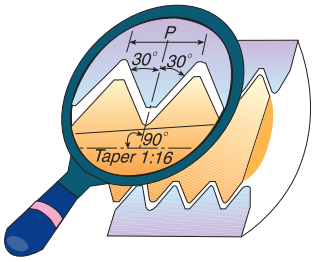


Same insert for External and Internal thread

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 10.

NPT



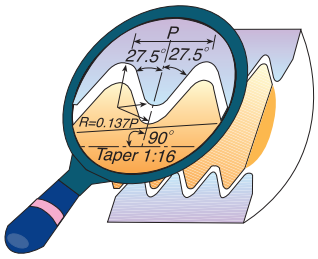
Concial pipe thread inserts are one-sided and may be used for both External and Internal threading

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 SRT17-27-SL26-2

For tool holders see pages 8-9.
For carbide grade and cutting speed see page 10.

BSPT



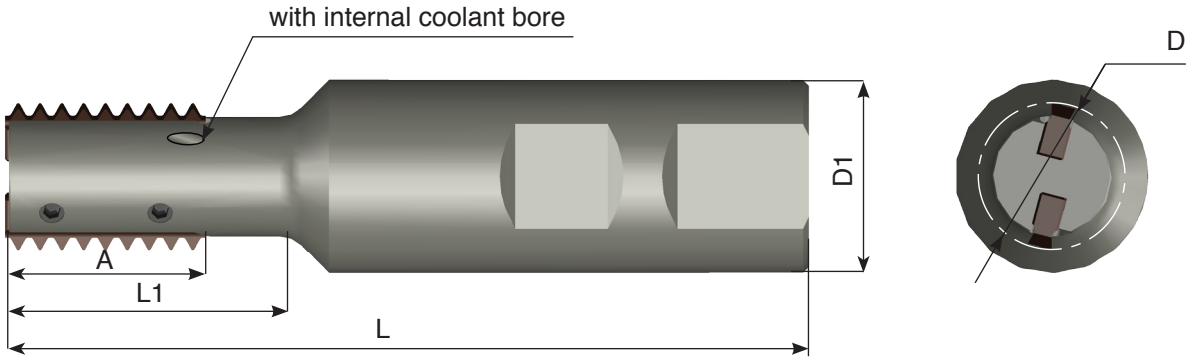
Concial pipe thread inserts are one-sided and may be used for both External and Internal threading

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 SRT17-27-SL26-2

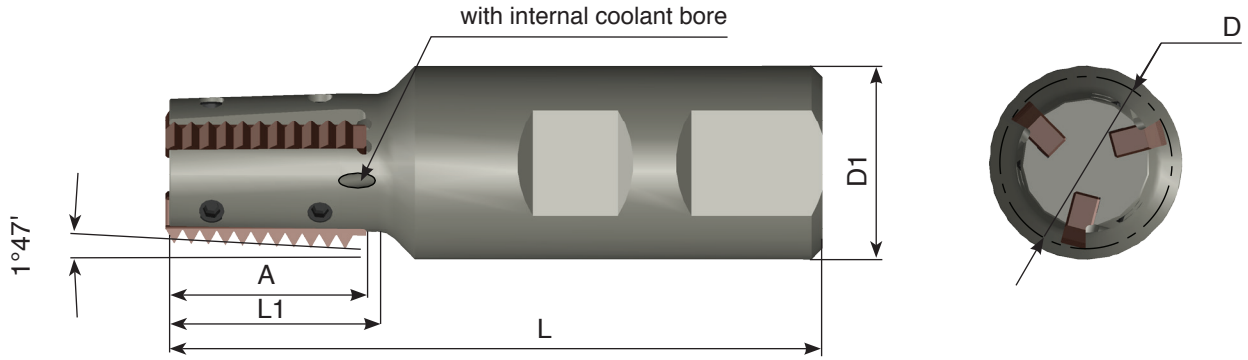
For tool holders see pages 8-9.
For carbide grade and cutting speed see page 10.

Toolholders



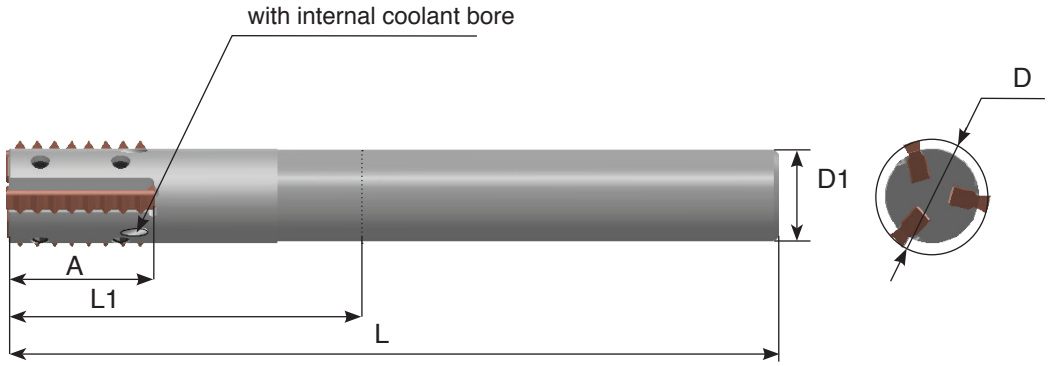
Ordering Code	Insert size=A	D	D1	L	L1	No. of Inserts	Screw	Key
SR17-27-SL26-2	SL 26	17.0	25.0	95	27	2	S4P	K08P
SR17-36-SL26-2		17.0	25.0	105	36	2	S4P	K08P
SR19-27-SL26-2		19.0	25.0	95	27	2	S4P	K08P
SR19-40-SL26-2		19.0	25.0	110	40	2	S4P	K08P
SR20-27-SL26-3		20.5	25.0	95	27	3	S4P	K08P
SR20-40-SL26-3		20.5	25.0	110	40	3	S4P	K08P
SR22-28-SL26-3		22.0	25.0	95	28	3	S4P	K08P
SR22-42-SL26-3		22.0	25.0	110	42	3	S4P	K08P
SR22-42-SL40-3	SL 40	22.0	25.0	110	42	3	S4P	K08P
SR30-42-SL40-4		30.0	32.0	125	42	4	S4P	K08P

Toolholders for Conical Threads



Ordering Code	Insert size=A	D	D1	L	L1	No. of Inserts	Screw	Key
SR T 17-27-SL26-2	SL 26	17.0	25.0	95	27	2	S4P	K08P
SR T 22-27-SL26-3		22.0	25.0	95	27	3	S4P	K08P
SR T 27-27-SL26-4		27.0	25.0	95	27	4	S4P	K08P

Carbide Shank Toolholders



Ordering Code	Insert size=A	D	D1	L	L1	No. of Inserts	Screw	Key
SR 19-70-SL26-2 C	SL 26	19.0	16.0	135	70	2	S4P	K08P
SR 20-70-SL26-3 C		20.5	16.0	135	70	3	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 (m/min)	Feed Rate (mm/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	110-220 100-210 90-150 70-140 55-70	(0.055 * D) / 22
	Low Alloy Steel and Cast Steel (less than 5% alloying elements	Annealed Quenched & Tempered	60-110 60-90	(0.055 * D) / 22
	High Alloy Steel, Cast Steel, and Tool Steel	Annealed	55-90	
		Quenched & Tempered	45-80	
M	Stainless Steel and Cast Steel	Ferritic Martensitic Austenitic	90-200 80-160 60-110	(0.055 * D) / 22
		High alloy Austenitic & Duplex	40-70	(0.045 * D) / 22
K	Cast Iron Nodular (GGG)	Ferritic	90-125	(0.055 * D) / 22
		Pearlitic	90-110	
	Grey Cast Iron (GG)	Ferritic	110-145	
		Pearlitic	80-125	
	Malleable Cast Iron	Ferritic	110-125	
		Pearlitic	80-120	
N	Aluminum-Wrought Alloy	Not Cureable	135-350	(0.05 * D) / 22
		Cured	100-270	
	Aluminum-Cast, Alloyed	Not Cureable ≤ 12% Si 90-270 Cured High Temperature > 12% Si	90-270 90-225 90-180	
	Copper Alloys	Free Cutting > 1% Pb Brass Electrolytic Copper	70-225 70-180 70-270	
	Non Metalic	Duroplastics, Fiber Plastics Hard Rubber	70-270 70-270	
S	High Temperature/Super Alloys (Fe based)	Annealed Cured	30-50	(0.038 * D) / 22
	High Temperature/Super Alloys (Ni or Co based	Annealed	25-45	
		Cured Cast		
	Titanium Alloys	Alpha + Beta Alloys Cured	30-40	

D= Tool holder cutting diameter.

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x-treme thread cutting™

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Carmex Slim MT 01/2019 - Metric

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