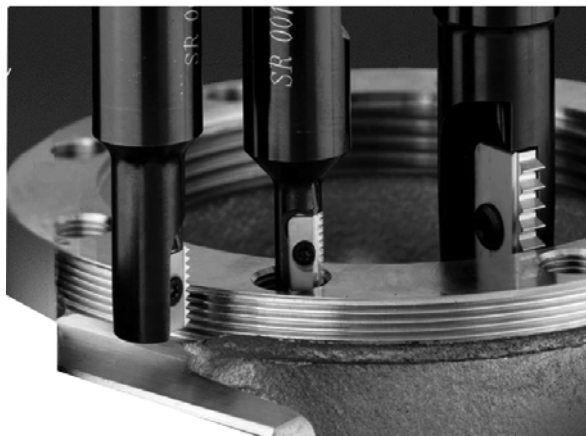


THREADMILLS INSERTS

THREAD MILL INSERTS FOR THREADING ON CNC MILLING MACHINES USING HELICAL INTERPOLATION PROGRAMS

Carmex
Precision Tools Ltd.

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ADVANTAGES OF MILL THREAD TOOLS

- Same toolholder and insert can produce right and left-hand threads
- A single insert & toolholder can produce a given thread on many diameters (external & internal)
- Most inserts are double sided, having two cutting edges.
- Thread is produced in one tool pass.
- Mill Thread tools are capable of producing taper threads.
- Improved productivity thanks to increased cutting speeds and multitooth type carbide inserts
- Threading to one pitch of a shoulder in a blind hole.
- Longer tool life thanks to special multilayer coating process
- Lower tooling costs, considerably less expensive than using taps and dies
- Since lower machine power required, smaller machine can produce larger threads in single operation with less idle time and tool changes.

Inserts are compatible with Kennametal, Stellram, Xactform & Iscar Holders!

GRADE MT7 - Sub micron TiAlN multi layer coated grade general purpose for all materials

Please See Following Page For Holders

FOR ISO METRIC THREADS

INSERT SIZE "A"	Pitch mm	INTERNAL		EXTERNAL	
		Part Number	Price Each	Part Number	Price Each
12	0.50	T-CT12 I 0.5M	\$28.50	-	-
	0.75	T-CT12 I 0.75M	\$28.50	-	-
	1.00	T-CT12 I 1.0M	\$28.50	-	-
	1.25	T-CT12 I 1.25M	\$28.50	-	-
	1.50	T-CT12 I 1.5M	\$28.50	-	-
14	0.50	T-CT14 I 0.5M	\$28.50	-	-
	0.75	T-CT14 I 0.75M	\$28.50	T-CT14 E 0.75M	\$28.50
	1.00	T-CT14 I 1.0M	\$28.50	T-CT14 E 1.0M	\$28.50
	1.25	T-CT14 I 1.25M	\$28.50	T-CT14 E 1.25M	\$28.50
	1.50	T-CT14 I 1.5M	\$28.50	T-CT14 E 1.5M	\$28.50
	1.75	T-CT14 I 1.75M	\$28.50	T-CT14 E 1.75M	\$28.50
	2.00	T-CT14 I 2.0M	\$28.50	T-CT14 E 2.0M	\$28.50
21	2.50	T-CT14 I 2.5M	\$28.50	T-CT14 E 2.5M	\$28.50
	1.00	T-CT21 I 1.0M	\$42.75	T-CT21 E 1.0M	\$42.75
	1.50	T-CT21 I 1.5M	\$42.75	T-CT21 E 1.5M	\$42.75
	1.75	T-CT21 I 1.75M	\$42.75	-	-
	2.00	T-CT21 I 2.0M	\$42.75	T-CT21 E 2.0M	\$42.75
	2.50	T-CT21 I 2.5M	\$42.75	T-CT21 E 2.5M	\$42.75
	3.00	T-CT21 I 3.0M	\$42.75	T-CT21 E 3.0M	\$42.75
30	3.50	T-CT21 I 3.5M	\$42.75	-	-
	1.50	T-CT30 I 1.5M	\$61.75	T-CT30 E 1.5M	\$61.75
	2.00	T-CT30 I 2.0M	\$61.75	T-CT30 E 2.0M	\$61.75
	3.00	T-CT30 I 3.0M	\$61.75	T-CT30 E 3.0M	\$61.75
	3.50	T-CT30 I 3.5M	\$61.75	T-CT30 E 3.5M	\$61.75
	4.00	T-CT30 I 4.0M	\$61.75	T-CT30 E 4.0M	\$61.75
40	4.50	T-CT30 I 4.5M	\$61.75	T-CT30 E 4.5M	\$61.75
	1.50	T-CT40 I 1.5M	\$95.00	T-CT40 E 1.5M	\$95.00
	2.00	T-CT40 I 2.0M	\$95.00	T-CT40 E 2.0M	\$95.00
	3.00	T-CT40 I 3.0M	\$95.00	T-CT40 E 3.0M	\$95.00
	3.50	T-CT40 I 3.5M	\$95.00	-	-
	4.00	T-CT40 I 4.0M	\$95.00	T-CT40 E 4.0M	\$95.00
	4.50	T-CT40 I 4.5M	\$95.00	-	-
40	5.00	T-CT40 I 5.0M	\$95.00	T-CT40 E 5.0M	\$95.00
	5.50	T-CT40 I 5.5M	\$95.00	-	-
	6.00	T-CT40 I 6.0M	\$95.00	T-CT40 E 6.0M	\$95.00
	6.00	T-CT40 I 6.0M	\$95.00	T-CT40 E 6.0M	\$95.00

FOR UN AMERICAN UNIFIED THREADS

INSERT SIZE "A"	TPI	INTERNAL		EXTERNAL	
		Part Number	Price Each	Part Number	Price Each
12	32	T-CT12 I 32UN	\$28.50	-	-
	28	T-CT12 I 28UN	\$28.50	-	-
	24	T-CT12 I 24UN	\$28.50	-	-
	20	T-CT12 I 20UN	\$28.50	-	-
	18	T-CT12 I 18UN	\$28.50	-	-
14	16	T-CT12 I 16UN	\$28.50	-	-
	32	T-CT14 I 32UN	\$28.50	T-CT14 E 32UN	\$28.50
	28	T-CT14 I 28UN	\$28.50	T-CT14 E 28UN	\$28.50
	27	T-CT14 I 27UN	\$28.50	-	-
	24	T-CT14 I 24UN	\$28.50	T-CT14 E 24UN	\$28.50
	20	T-CT14 I 20UN	\$28.50	T-CT14 E 20UN	\$28.50
	18	T-CT14 I 18UN	\$28.50	T-CT14 E 18UN	\$28.50
21	16	T-CT14 I 16UN	\$28.50	T-CT14 E 16UN	\$28.50
	14	T-CT14 I 14UN	\$28.50	T-CT14 E 14UN	\$28.50
	12	T-CT14 I 12UN	\$28.50	T-CT14 E 12UN	\$28.50
	24	T-CT21 I 24UN	\$42.75	T-CT21 E 24UN	\$42.75
	20	T-CT21 I 20UN	\$42.75	T-CT21 E 20UN	\$42.75
	18	T-CT21 I 18UN	\$42.75	T-CT21 E 18UN	\$42.75
	16	T-CT21 I 16UN	\$42.75	T-CT21 E 16UN	\$42.75
	14	T-CT21 I 14UN	\$42.75	T-CT21 E 14UN	\$42.75
	12	T-CT21 I 12UN	\$42.75	T-CT21 E 12UN	\$42.75
	10	T-CT21 I 10UN	\$42.75	T-CT21 E 10UN	\$42.75
30	8	T-CT21 I 8UN	\$42.75	-	-
	20	T-CT30 I 20UN	\$61.75	T-CT30 E 20UN	\$61.75
	18	T-CT30 I 18UN	\$61.75	T-CT30 E 18UN	\$61.75
	16	T-CT30 I 16UN	\$61.75	T-CT30 E 16UN	\$61.75
	14	T-CT30 I 14UN	\$61.75	T-CT30 E 14UN	\$61.75
	12	T-CT30 I 12UN	\$61.75	T-CT30 E 12UN	\$61.75
	10	T-CT30 I 10UN	\$61.75	T-CT30 E 10UN	\$61.75
	8	T-CT30 I 8UN	\$61.75	T-CT30 E 8UN	\$61.75
	6	T-CT30 I 6UN	\$61.75	T-CT30 E 6UN	\$61.75
	40	16	T-CT40 I 16UN	\$95.00	T-CT40 E 20UN
14		T-CT40 I 14UN	\$95.00	T-CT40 E 18UN	\$95.00
12		T-CT40 I 12UN	\$95.00	T-CT40 E 16UN	\$95.00
10		T-CT40 I 10UN	\$95.00	T-CT40 E 14UN	\$95.00
8		T-CT40 I 8UN	\$95.00	T-CT40 E 12UN	\$95.00
6		T-CT40 I 6UN	\$95.00	T-CT40 E 10UN	\$95.00
4.5		T-CT40 I 4.5UN	\$95.00	T-CT40 E 8UN	\$95.00
4		T-CT40 I 4UN	\$95.00	T-CT40 E 6UN	\$95.00

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THREAD MILL INSERTS (continued) FOR THREADING ON CNC MILLING MACHINES Using Helical Interpolation Programs

For NPT Threads

INSERT SIZE "A"	TPI	INTERNAL/EXTERNAL	
		Part Number	Price Each
12	18	T-CT12 IE 18NPT	\$28.50
14	18	T-CT14 IE 18NPT	\$28.50
14	14	T-CT14 IE 14NPT	\$28.50
21	14	T-CT21 IE 14NPT	\$42.75
21	11.5	T-CT21 IE 11.5NP	\$42.75
30	11.5	T-CT30 IE 11.5NP	\$61.75
30	8	T-CT30 IE 8NPT	\$61.75
40	11.5	T-CT40 IE 11.5NP	\$95.00
40	8	T-CT40 IE 8NPT	\$95.00

For NPTF DRYSEAL Threads

INSERT SIZE "A"	TPI	INTERNAL/EXTERNAL	
		Part Number	Price Each
12	18	T-CT12 IE 18NPF	\$28.50
14	18	T-CT14 IE 18NPF	\$28.50
14	14	T-CT14 IE 14NPF	\$28.50
21	14	T-CT21 IE 14NPF	\$42.75
21	11.5	T-CT21 IE 11.5NP	\$42.75
30	8	T-CT30 IE 8NPF	\$61.75
40	8	T-CT40 IE 8NPF	\$95.00

THREAD MILL INSERTS HOLDERS FOR THREADING ON CNC MILLING MACHINES Using Helical Interpolation Programs

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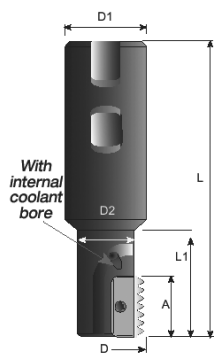


Fig #1

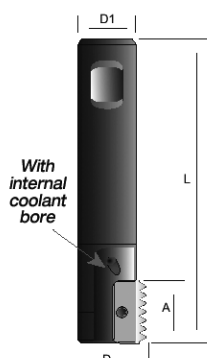


Fig #2

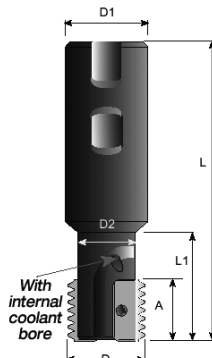


Fig #3

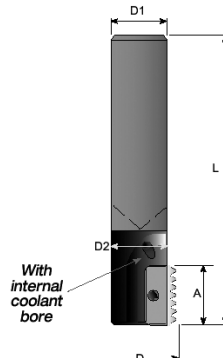


Fig #4

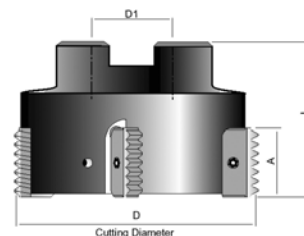


Fig #5

Style	Figure No.	For Insert Size "A"	D	D1	D2	L	L1	No Of Inserts	Coolant Thru	Shank Material	Part Number	Price Each	Insert	Torx
Std Length	1	12	0.37	0.75	0.3	3.35	0.51	1	Yes	Steel	T-CTSR0375H12	\$135.00	S12	K12
		12	0.39	0.75	0.3	3.35	0.51	1	Yes	Steel	T-CTSR0390H12	\$135.00	S12	K12
		14	0.5	0.75	0.37	2.95	0.70	1	Yes	Steel	T-CTSR0500F14	\$135.00	S14	K14
		14	0.54	0.75	0.38	2.98	0.77	1	Yes	Steel	T-CTSR0540F14	\$135.00	S14	K14
		14	0.57	0.75	0.41	3.20	1.00	1	Yes	Steel	T-CTSR0570H14	\$135.00	S14	K14
		14	0.67	0.75	0.53	3.35	1.18	1	Yes	Steel	T-CTSR0670H14	\$135.00	S14	K14
		21	0.79	0.75	0.61	3.70	1.57	1	Yes	Steel	T-CTSR0790H21	\$153.00	S21	K21
		30	1.14	1.00	0.91	4.27	1.85	1	Yes	Steel	T-CTSR1140J30	\$171.00	S30	K30
Long Shnk	2	21	0.94	0.75	5.00	-	-	1	Yes	Steel	T-CTSR0940K21	\$180.00	S21	K21
		30	1.24	1.00	6.00	-	-	1	Yes	Steel	T-CTSR1240M30	\$216.00	S30	K30
		30	1.50	1.25	6.00	-	-	1	Yes	Steel	T-CTSR1500M30	\$252.00	S30	K30
Std Length	3	14	0.79	0.75	0.63	3.66	1.57	2	Yes	Steel	T-CTSR0790H14-2	\$252.00	S14	K14
		21	1.18	1.00	0.95	4.25	1.97	2	Yes	Steel	T-CTSR1180J21-2	\$279.00	S21	K21
		30	1.57	1.25	1.18	5.12	2.80	2	Yes	Steel	T-CTSR1580L30-2	\$306.00	S30	K30
		40	1.97	1.50	1.49	6.02	3.35	2	Yes	Steel	T-CTSR1970M40-2	\$333.00	S40	K40
Long Shnk	4	12	0.39	0.312	0.312	5.00	-	1	Yes	Carbide	T-CTSR0390K12C	\$288.00	S12	K12
		14	0.50	0.375	0.375	6.00	-	1	Yes	Carbide	T-CTSR0500J14C	\$288.00	S14	K14
		14	0.62	0.500	0.500	7.00	-	1	Yes	Carbide	T-CTSR0620K14C	\$315.00	S14	K14
		21	0.82	0.625	0.625	8.00	-	1	Yes	Carbide	T-CTSR0820M21C	\$405.00	S21	K21
Shell Mill	5	21	2.48	0.750	1.970	n/a	n/a	5	No	n/a	T-CTSR2480C21-5	\$675.00	S21	K21
		30	2.48	0.750	1.970	n/a	n/a	4	No	n/a	T-CTSR2480C30-4	\$675.00	S30	K30
		30	3.15	1.000	2.160	n/a	n/a	4	No	n/a	T-CTSR3150D30-4	\$675.00	S30	K30
		30	3.94	1.250	2.360	n/a	n/a	4	No	n/a	T-CTSR3940D30-4	\$675.00	S30	K30
		40	3.15	1.000	2.560	n/a	n/a	4	No	n/a	T-CTSR3150D40-4	\$675.00	S40	K40
		40	3.94	1.250	2.760	n/a	n/a	4	No	n/a	T-CTSR3940E40-4	\$675.00	S40	K40

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