



Carmex
Precision Tools Ltd.
x-treme thread cutting™

CMT

Vertical Mill Thread



Metric 2014 - 2015

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CMT Vertical Mill Thread

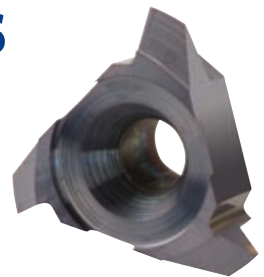
Advantages

- Ground profile inserts for high precision and excellent performance.
- Working at high machining parameters, with high surface quality.
- Solid and accurate clamping method enables full repeatability.
- Same insert and holder for right-hand or left-hand threads.
- Toolholders include weldon shank and coolant bore.

CMT Straight Flute Inserts

Carbide Grade: MT7

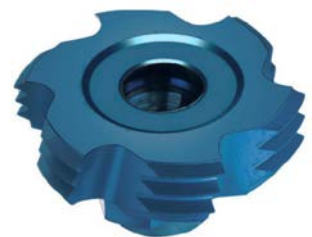
Inserts are available in MT7 Sub-Micron Grade with Titanium Aluminium Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, covering a very wide range of materials.



CMT Spiral Multi Flute Inserts

- Multi flute: 4-8 cutting edges
- Spiral flute for smooth cutting

The new cutters are designed for large range of materials including hardened steel up to 62 HRc. Use with the same CMT tool holders, C18 type.



Advantages

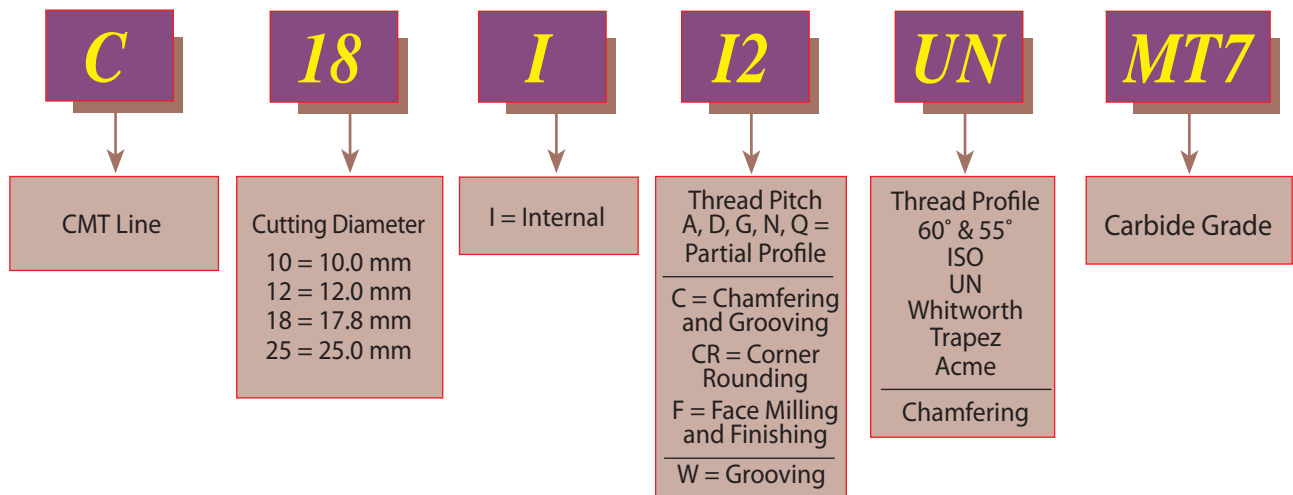
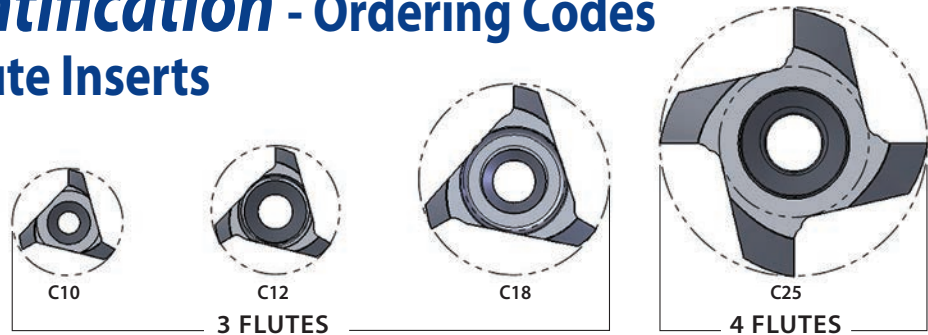
- Longer tool life
- High material removal and higher feeds results increased productivity
- Excellent surface finish
- Reduced cycle time
- Low cutting forces due to the spiral multi flutes

Carbide Grade: MT8

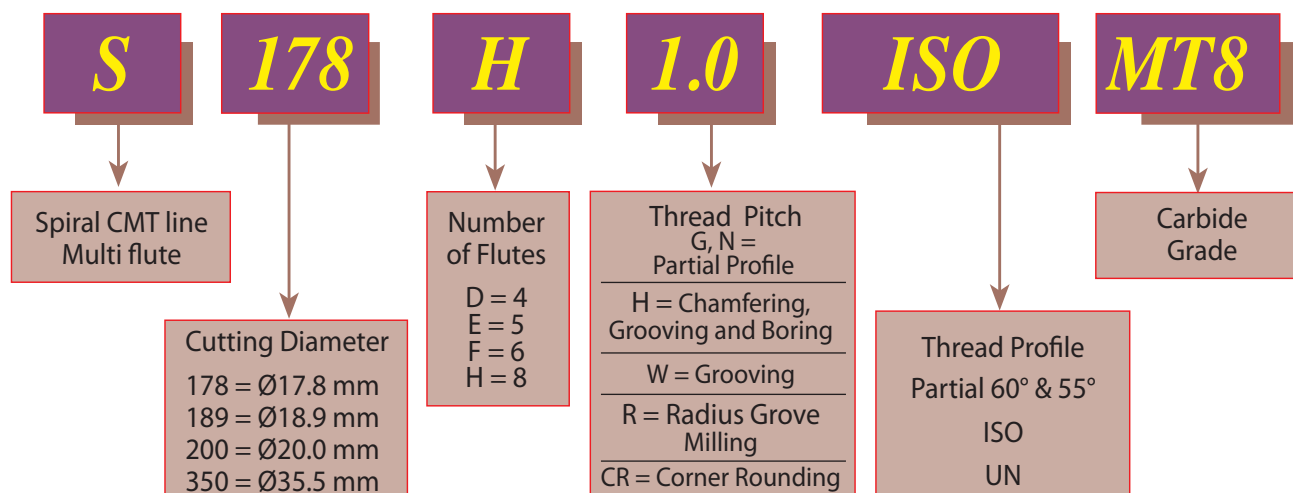
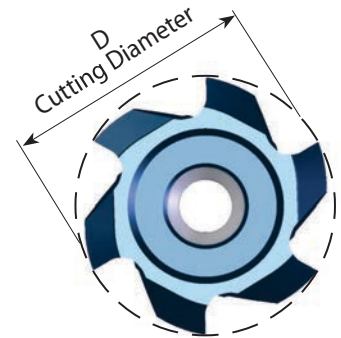
Sub Micron grade with advanced PVD triple coating (ISO K10-K20). Extremely high heat resistant and smooth cutting operation, high performance, for all machining conditions.

Product Identification - Ordering Codes

CMT Straight Flute Inserts

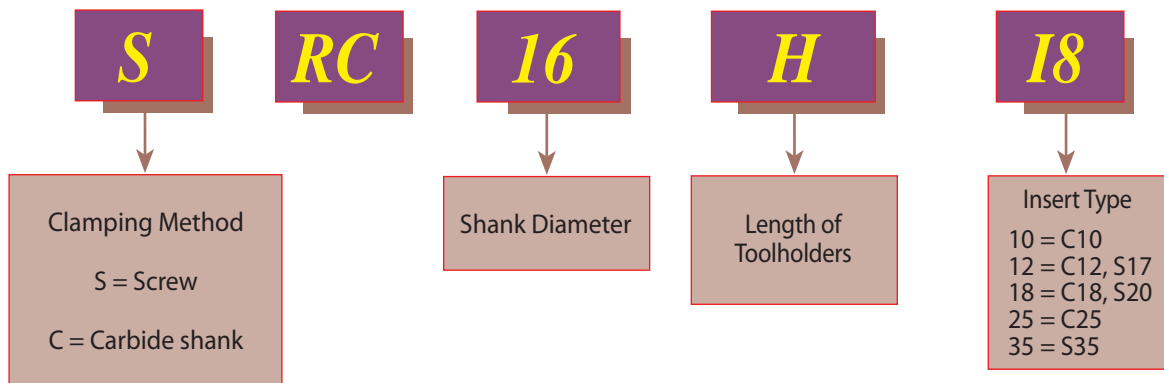


CMT Spiral Multi Flute Inserts



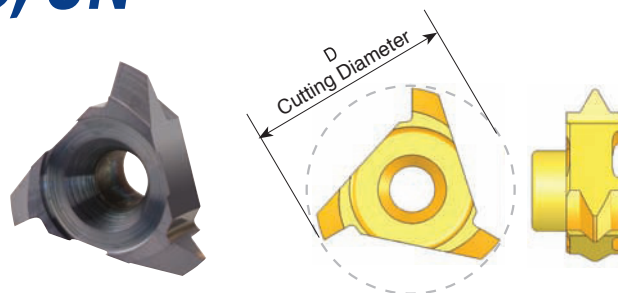
Product Identification - Ordering Codes

CMT Toolholders



Partial Profile 60° - ISO, UN

Same insert for internal and external thread

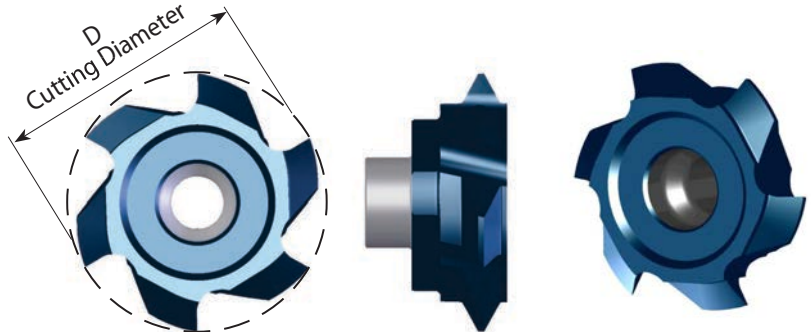


Insert Type	Pitch Range mm	Pitch Range TPI	Ordering Code	D	Thread Diameter (min)		Holder Code
					Pitch Low Range	Pitch High Range	
C10	Int. 0.5 - 0.8	56 - 28	C10 A60	10.0	ø ≥ 11	ø ≥ 12	H1, 2, 12, 13
	Ex. 0.4 - 0.8	64 - 32					
	Int. 1.0 - 2.0	28 - 13	C10 G60		ø ≥ 12	ø ≥ 14	H1, 2, 12
	Ex. 0.8 - 1.75	32 - 15					
C12	Int. 0.5 - 0.8	56 - 28	C12 A60	12.0	ø ≥ 13	ø ≥ 14	H3, 4, 5, 14, 15
	Ex. 0.4 - 0.8	64 - 32					
	Int. 1.0 - 2.0	28 - 13	C12 G60	12.4	ø ≥ 14	ø ≥ 16	
	Ex. 0.8 - 1.75	32 - 15					
C18	Int. 0.5 - 0.8	56 - 28	C18 A60	17.8	ø ≥ 19		H6, 7, 8, 9, 16
	Ex. 0.4 - 0.8	64 - 32					
	Int. 1.0 - 1.75	28 - 14	C18 G60		ø ≥ 20	ø ≥ 21	
	Ex. 0.8 - 1.5	32 - 16					
	Int. 2.0 - 3.0	13 - 8	C18 D60		ø ≥ 21	ø ≥ 23	
	Ex. 1.75 - 2.5	15 - 10					
C25	Int. 1.5 - 2.5	16 - 10	C25 G60	25.0	ø ≥ 28	ø ≥ 30	H10, 11, 17, 18
	Ex. 1.0 - 2.0	28 - 13					
	Int. 3.0 - 5.0	8 - 5	C25 N60		ø ≥ 30	ø ≥ 34	
	Ex. 2.5 - 4.5	10 - 6					
	Int. 5.0 - 6.0	5 - 4	C25 Q60		ø ≥ 34	ø ≥ 35	
	Ex. 4.5 - 5.0	6 - 5					

Partial Profile 60° - ISO, UN

Same insert for internal and external thread

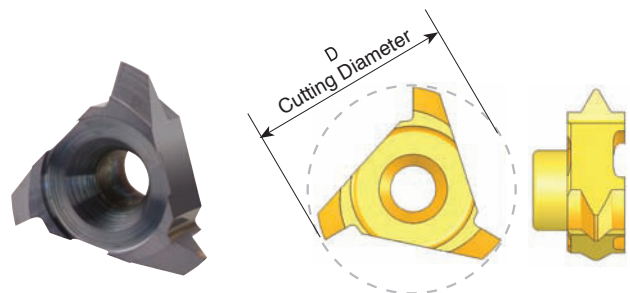
Multi Flute



Insert Type	Ordering Code	Pitch Range mm	Pitch Range TPI	D	No. of Flutes	Thread Dia (min)		Holder Code
						Pitch Low range	Pitch High range	
S20	S200 F G60	Int. 1.5-2.5	16-10	20.0	6	$\varnothing \geq 23$	$\varnothing \geq 25$	H6, 7, 8, 9, 16
		Ex. 1.0-2.0	28-13					
	S200 D N60	Int. 3.0-5.0	8 - 5	20.0	4	$\varnothing \geq 25$	$\varnothing \geq 29$	H16
		Ex. 2.5-4.5	10 - 6					

Partial Profile 60° - NPT

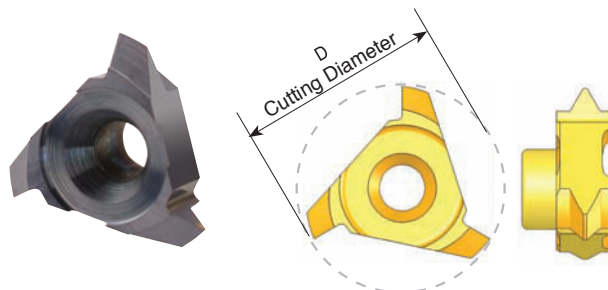
Same insert for internal and external thread



Insert Type	Pitch TPI	Standard	Ordering Code	D	Holder Code
C10	18	1/4 - 3/8	C10 18 NPT	10.0	H1, 2, 12
C18	14	1/2 - 3/4	C18 14 NPT	15.8	H16
C25	11.5	1-2	C25 11.5NPT	25.0	H10, 11, 17, 18
	8	$\geq 2 \frac{1}{2}$	C25 8 NPT		

Partial Profile 55° - BSP(G), BSF, BSW

Same insert for internal and external thread

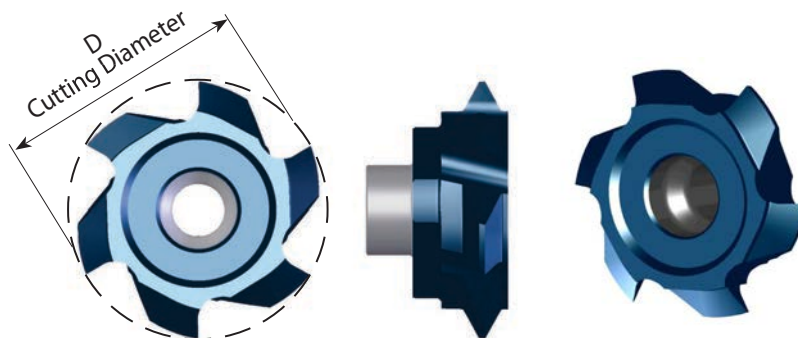


Insert Type	Pitch Range TPI	Ordering Code	D	Thread Dia. (min)	Holder Code
C10	19-14	C10 G55	10.0	$\varnothing \geq 13$	H1, 2, 12
C12	28-19	C12 G55	12.0	$\varnothing \geq 14$	H3, 4, 5, 14, 15
	14-11	C12 N55	12.2	$\varnothing \geq 16$	H3, 4, 5, 14
C18	14 - 8	C18 G55	18.0	$\varnothing \geq 23$	H6, 7, 8, 9, 16
C25	7 - 5	C25 N55	25.0	$\varnothing \geq 31$	H10, 11, 17, 18

Partial Profile 55° - BSP(G), BSF, BSW

Same insert for internal and external thread

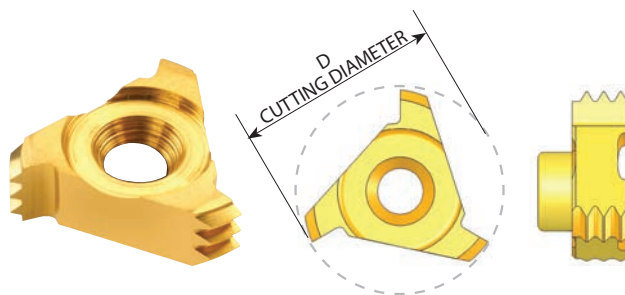
Multi Flute



Insert Type	Ordering Code	Pitch Range TPI	D	No. of Flutes	Thread Dia (min)	Holder Code
S20	S195 F G55	14	19.5	6	$\varnothing \geq 23$	H6, 7, 8, 9, 16
	S200 D N55	8-6	20.0	4	$\varnothing \geq 25$	H16

Full Profile - ISO

Inserts for internal thread

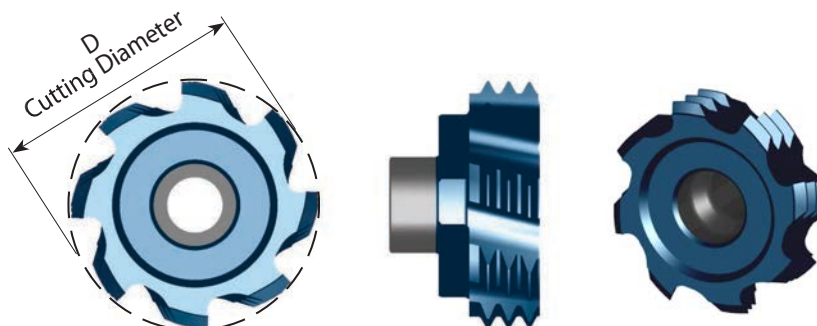


Insert Type	Pitch mm	M coarse	M fine	Ordering Code	Number of Teeth	D	Holder Code
C10	0.5		$\varnothing \geq 10$	C10 I 0.5 ISO	6	9.0	H1, 2, 12, 13
	1.0		$\varnothing \geq 12$	C10 I 1.0 ISO	3	10.0	
	1.5		$\varnothing \geq 13$	C10 I 1.5 ISO	2	10.0	
	1.75	M12	$\varnothing \geq 13$	C10 I 1.75 ISO	1	9.6	H1, 2, 12
	2.0	M14	$\varnothing \geq 14$	C10 I 2.0 ISO	1	10.0	
C12	0.5		$\varnothing \geq 13$	C12 I 0.5 ISO	6	12.0	H3, 4, 5, 14, 15
	0.75		$\varnothing \geq 13$	C12 I 0.75 ISO	4		
	1.0		$\varnothing \geq 14$	C12 I 1.0 ISO	3		
	1.5		$\varnothing \geq 15$	C12 I 1.5 ISO	2		
	2.0	M16	$\varnothing \geq 16$	C12 I 2.0 ISO	1	12.4	H3, 4, 5, 14
	2.5	M18, M20	$\varnothing \geq 17$	C12 I 2.5 ISO	1	12.0	
	3.0		$\varnothing \geq 17$	C12 I 3.0 ISO	1	12.4	
C18	0.5		$\varnothing \geq 19$	C18 I 0.5 ISO	9	17.8	H6, 7, 8, 9, 16
	0.75		$\varnothing \geq 19$	C18 I 0.75 ISO	6		
	1.0		$\varnothing \geq 20$	C18 I 1.0 ISO	5		
	1.5		$\varnothing \geq 20$	C18 I 1.5 ISO	3		
	2.0		$\varnothing \geq 21$	C18 I 2.0 ISO	2		
	2.5	M22	$\varnothing \geq 22$	C18 I 2.5 ISO	2		
	3.0	M24, M27	$\varnothing \geq 23$	C18 I 3.0 ISO	1		
	3.5	M30, M33	$\varnothing \geq 24$	C18 I 3.5 ISO	1		
C25	3.0	M32, M33	$\varnothing \geq 30$	C25 I 3.0 ISO	2	25.0	H10, 11, 17, 18
	4.0	M36, M39	$\varnothing \geq 32$	C25 I 4.0 ISO	1		
	4.5	M45	$\varnothing \geq 33$	C25 I 4.5 ISO	1		
	5.0	M48, M52	$\varnothing \geq 34$	C25 I 5.0 ISO	1		
	5.5	M60	$\varnothing \geq 35$	C25 I 5.5 ISO	1		
	6.0	M64, M68	$\varnothing \geq 36$	C25 I 6.0 ISO	1		

Full Profile - ISO

Inserts for internal thread

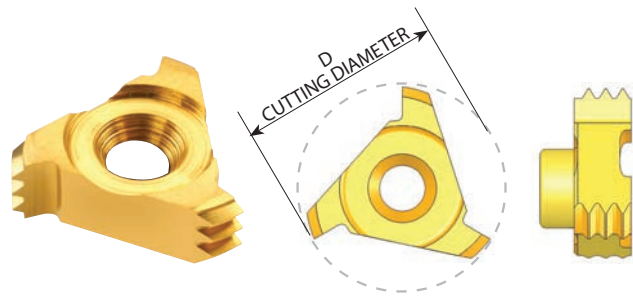
Multi Flute



Insert Type	Ordering Code	Pitch mm	M coarse	M fine	Number of Teeth	D	No. of Flutes	Holder Code
S20	S163 H 1.0 ISO	1.0		$\varnothing \geq 18$	5	16.3	8	H6, 7, 8, 9, 16
	S175 H 1.5 ISO	1.5		$\varnothing \geq 20$	3	17.5	8	
	S186 F 2.0 ISO	2.0		$\varnothing \geq 22$	2	18.6	6	
S17	S160 F 2.5 ISO	2.5	M20	$\varnothing \geq 20$	1	16.0	6	H3, 4, 5, 14, 17
S20	S178 F 2.5 ISO	2.5	M22	$\varnothing \geq 22$	2	17.8	6	H6, 7, 8, 9, 16
	S189 F 3.0 ISO	3.0	M24, M27	$\varnothing \geq 24$	1	18.9	6	
	S200 F 3.5 ISO	3.5	M30, M33	$\varnothing \geq 26$	1	20.0	6	
	S200 F 4.0 ISO	4.0	M36, M39	$\varnothing \geq 27$	1	20.0	6	
	S200 E 4.5 ISO	4.5	M42, M45	$\varnothing \geq 28$	1	20.0	5	
	S200 D 5.0 ISO	5.0	M48, M52	$\varnothing \geq 29$	1	20.0	4	H16
S35	S350 F 6.0 ISO	6.0	M64, M68	$\varnothing \geq 46$	1	35.0	6	H19, 20, 21
	S350 F 8.0 ISO	8.0		$\varnothing \geq 50$	1	35.0	6	

Full Profile - UN

Inserts for internal thread

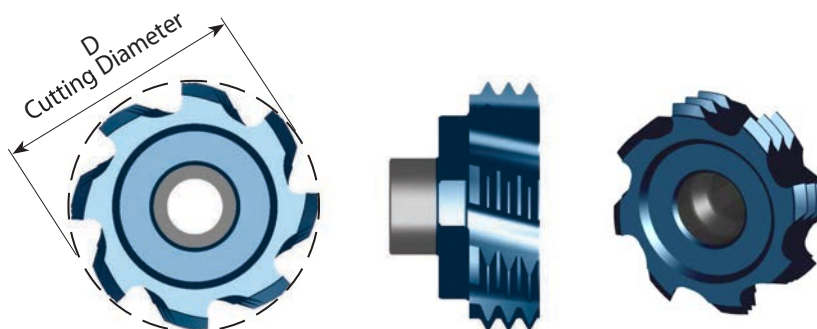


Insert Type	Pitch TPI	Nominal Size	UNC	UNF	UNEF	Ordering Code	Number of Teeth	D	Holder Code
C10	20			1/2		C10 I 20 UN	2	10.0	H1, 2, 12, 13
	18			9/16		C10 I 18 UN	2		
	13		1/2			C10 I 13 UN	1	10.0	H1, 2, 12
	12	5/8, 11/16, 3/4	9/16			C10 I 12 UN	1		
C12	32	9/16, 5/8				C12 I 32 UN	3	12.0	H3, 4, 5, 14, 15
	28	9/16, 5/8, 11/16				C12 I 28 UN	3		
	24				9/16, 5/8, 11/16	C12 I 24 UN	2		
	20	9/16, 5/8, 11/16			3/4	C12 I 20 UN	2		
	18			5/8		C12 I 18 UN	2		
	16	5/8, 11/16		3/4		C12 I 16 UN	1		
	11		5/8			C12 I 11 UN	1	12.0	H3, 4, 5, 14
C18	10		3/4			C12 I 10 UN	1		
	32	3/4, 13/16, 7/8				C18 I 32 UN	6	17.8	H6, 7, 8, 9, 16
	28	3/4, 13/16, 7/8				C18 I 28 UN	5		
	24					C18 I 24 UN	4		
	20	11/16, 11/8			13/16, 7/8, 15/16	C18 I 20 UN	3		
	18					C18 I 18 UN	3		
	16	7/8, 1				C18 I 16 UN	3		
	14			7/8		C18 I 14 UN	2		
	12	7/8		1, 11/8		C18 I 12 UN	2		
	11					C18 I 11 UN	2		
	9		7/8			C18 I 9 UN	1		
	8		1			C18 I 8 UN	1		
C25	8	13/16, 11/4, 15/16				C25 I 8 UN	2	25.0	H10, 11, 17, 18
	7		11/4			C25 I 7 UN	1		
	6	17/16, 19/16	13/8, 11/2			C25 I 6 UN	1		
	5		1 3/4			C25 I 5 UN	1		
	4		2 1/2, 2 3/4			C25 I 4 UN	1		

Full Profile - UN

Inserts for internal thread

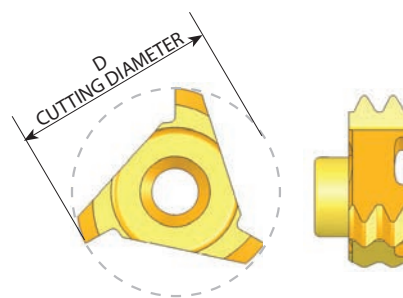
Multi Flute



Insert Type	Ordering Code	Pitch TPI	Nominal size	UNC	UNF	UNEF	Number of Teeth	D	No. of Flutes	Holder Code
S20	S160 H 24 UN	24				11/16	4	16.0	8	H6, 7, 8, 9, 16
	S169 H 20 UN	20				3/4, 13/16, 7/8, 15/16, 1	4	16.9	8	
	S164 F 16 UN	16	7/8, 15/16, 1		3/4		3	16.4	6	
	S191 F 14 UN	14			7/8		2	19.1	6	
	S186 F 12 UN	12	7/8, 15/16		1		2	18.6	6	
	S178 F 9 UN	9		7/8			1	17.8	6	
	S200 F 8 UN	8	1 1/8	1			1	20.0	6	
	S200 F 7 UN	7		1 1/8, 1 1/4			1	20.0	6	
	S200 E 6 UN	6	1 7/16	1 3/8, 1 1/2			1	20.0	5	
	S200 D 5 UN	5		1 3/4			1	20.0	4	H16
S35	S350 F 4 UN	4		2 1/2, 2 3/4, 3			1	35.0	6	H19, 20, 21

G 55° BSW, BSF, BSP

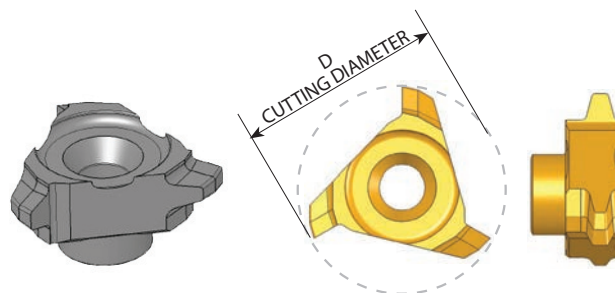
Same Insert for internal and external thread



Insert Type	Pitch TPI	Standard	Ordering Code	Number of Teeth	D	Holder Code
C10	19	G 1/4	C10 19 W	2	10.0	H1, 2, 12, 13
C12	19	G 3/8	C12 19 W	2	12.0	H3, 4, 5, 14, 15
C18	14	G 7/8	C18 14 W	2	17.8	H6, 7, 8, 9, 16
	11	G ≥ 1	C18 11 W	2		

Trapez - DIN 103

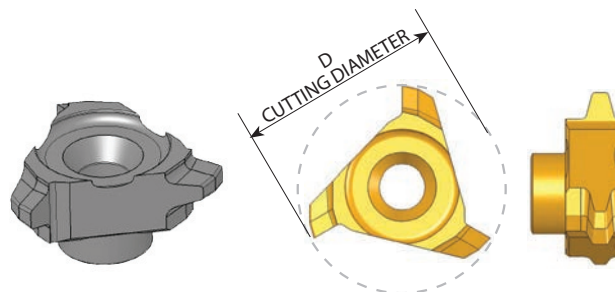
Inserts for internal thread



Insert Type	Pitch mm	Standard	Ordering Code	D	Holder Code
C10	2.0	$\varnothing \geq 16$	C10 I 2 TR	10.0	H1, 2, 12,
C18	3.0	$\varnothing \geq 24$	C18 I 3 TR	17.8	H6, 7, 8, 9, 16
	4.0	$\varnothing \geq 26$	C18 I 4 TR		H16
	5.0	$\varnothing \geq 28$	C18 I 5 TR		
C25	6.0	$\varnothing \geq 36$	C25 I 6 TR	25.0	H10, 11, 17, 18

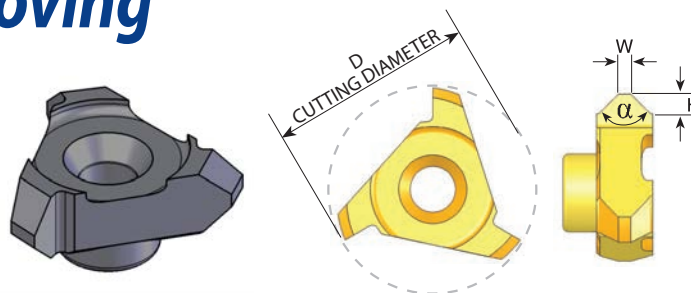
Acme

Inserts for internal thread



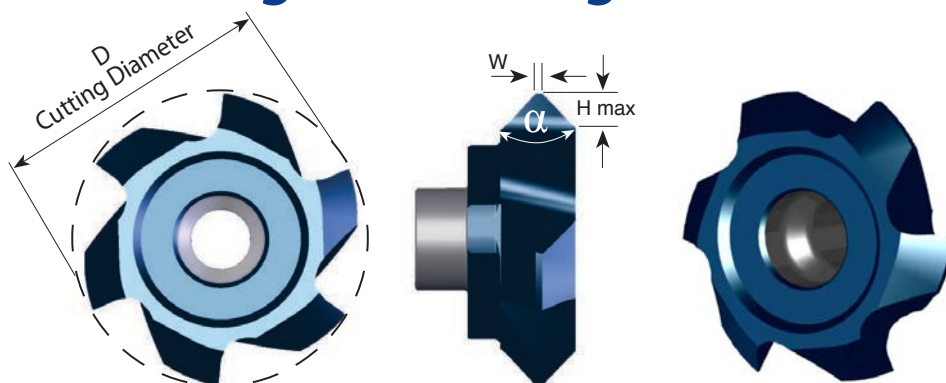
Insert Type	Pitch TPI	Standard	Ordering Code	D	Holder Code
C18	5	1 1/8, 1 1/4	C18 I 5 ACME	18.0	H16
C25	4	1 1/2, 1 3/4, 2	C25 I 4 ACME	25.0	H10, 11, 17, 18

Chamfering and Grooving



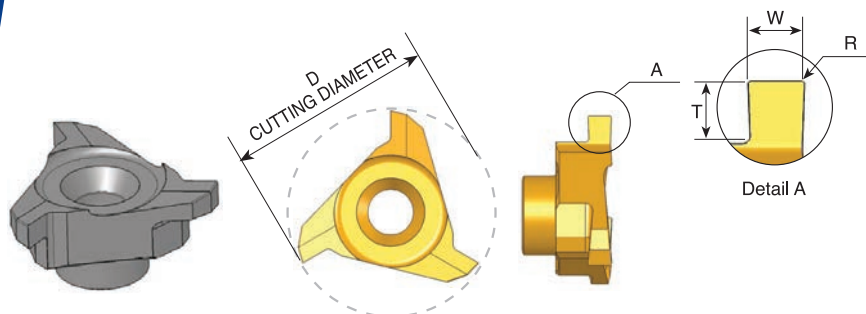
Insert Type	Ordering Code	D	H	W	α	Holder Code*
C10	C10 C90	10.0	1.30	0.4	90°	H1, 2, 12
C12	C12 C90	12.0	1.35	0.3		H3, 4, 5, 14
C18	C18 C90	17.8	1.95	1.1		H6, 7, 8, 9, 16
C25	C25 C90	25.0	2.50	1.0		H10, 11, 17, 18

Chamfering, Grooving and Boring Multi Flute



Insert Type	Ordering Code	D	H max	W	α	No. of Flutes	Holder Code
S17	SC160 E H14	16.0	1.35	0.2	90°	5	H3, 4, 5, 14, 15
S20	SC170 E H14	17.0	1.35	0.2	90°	5	H6, 7, 8, 9, 16
	SC200 F H14	20.0	1.35	0.2	90°	6	H6, 7, 8, 9, 16
	SC200 F H24	20.0	2.35	0.2			
S35	SC350 F H42	35.0	4.20	0.2	90°	6	H19, 20, 21
S20	SC200 F H20	20.0	1.95	1.0	90°	6	H6, 7, 8, 9, 16
	SC200 F H17	20.0	1.70	1.5			
	SC200 F H15	20.0	1.50	2.0			
	SC200 F H12	20.0	1.20	2.5			

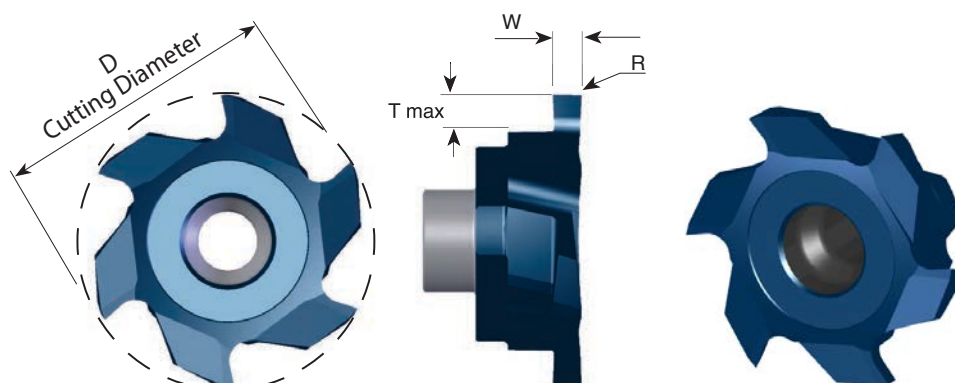
Groove Milling



Insert Type	Ordering Code	D	W ±0.02	T max.	R	Groove Dia. (min.)	Holder Code
C10	C10 W08	10.0	0.80	0.80	0.1	$\varnothing \geq 10.0$	H1, 2, 12, 13
	C10 W09		0.90	0.90			
	C10 W10		1.00	0.90			
C12	C12 W08	12.0	0.80	0.80	0.1	$\varnothing \geq 12.0$	H3, 4, 5, 14, 15
	C12 W10		1.00	0.90			
C18	C18 W10	17.8	1.00	1.50	0.1	$\varnothing \geq 17.8$	H6, 7, 8, 9, 16
	C18 W12		1.20	1.50			
	C18 W15		1.50	1.95			
	C18 W20		2.00	2.80			H16
C25	C25 W20	25.0	2.00	3.00	0.2	$\varnothing \geq 25$	H10, 11, 17, 18
	C25 W25		2.50	3.00			
	C25 W30		3.00	3.00			
	C25 W35		3.50	3.50			
	C25 W40		4.00	3.50			
	C25 W50		5.00	3.50			

Groove Milling

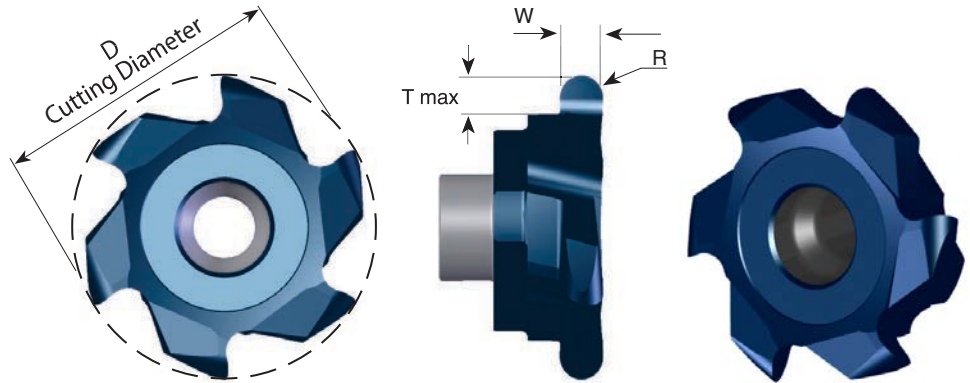
Multi Flute



Insert Type	Ordering Code	D	W ±0.02	T Max.	R	Groove Dia. (min)	No. of Flutes	Holder Code
S17	SG170 F W15	17.0	1.5	2.8	0.2	Ø > 17	6	H3, 4, 5, 14, 15
	SG170 F W20	17.0	2.0					
	SG170 F W25	17.0	2.5					
S20	SG200 F W15	20.0	1.5	2.9	0.2	Ø > 20	6	H6, 7, 8, 9, 16
	SG200 F W20	20.0	2.0					
	SG200 F W25	20.0	2.5					
	SG200 F W30	20.0	3.0					
	SG200 F W40	20.0	4.0					
	SG200 F W49	20.0	4.9					
S20	SG200 E W20T	20.0	2.0	3.7	0.2	Ø > 20	5	H16
	SG200 E W25T	20.0	2.5					
	SG200 E W30T	20.0	3.0					
S35	SG350 F W30T	35.0	3.0	6.3	0.2	Ø > 35	6	H19, 20, 21
	SG350 F W40T	35.0	4.0					
	SG350 F W50T	35.0	5.0					
	SG350 F W60T	35.0	6.0					
	SG350 F W80T	35.0	8.0					

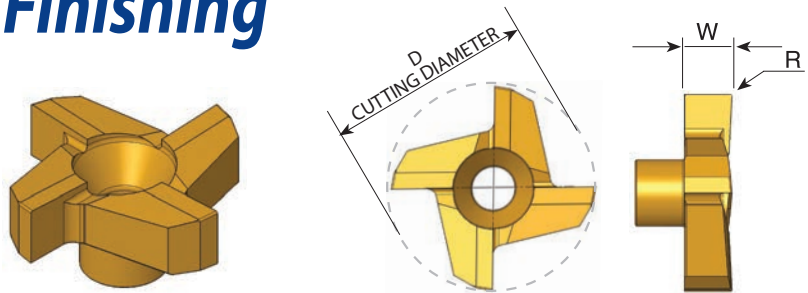
Full Radius Groove Milling

Multi Flute



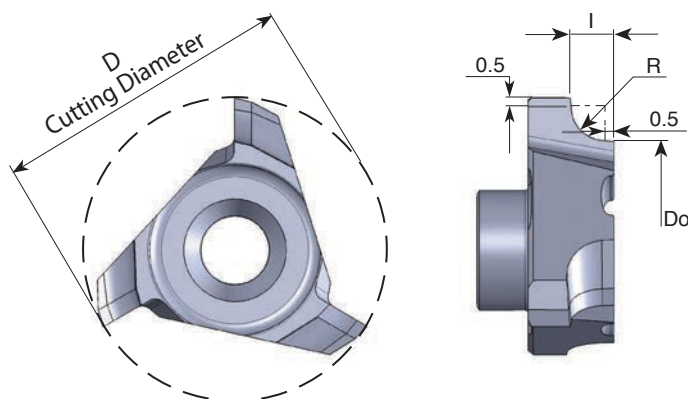
Insert Type	Ordering Code	D	R	W ±0.02	T Max.	Groove Dia. (min)	No. of Flutes	Holder Code
S20	SG200 F R10	20.0	1.0	2.0	2.9	Ø > 20	6	H6, 7, 8, 9, 16
	SG200 F R12	20.0	1.2	2.4				
	SG200 F R15	20.0	1.5	3.0				
	SG200 F R20	20.0	2.0	4.0				

Face Milling and Finishing



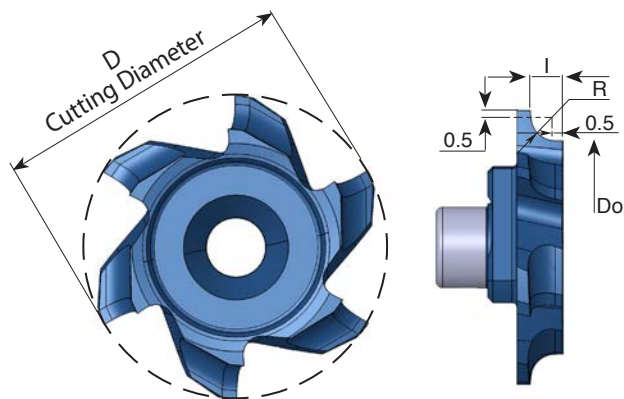
Insert Type	Ordering Code	D	W	R	Holder Code
C18	C18 F R0.1	17.8	5.0	0.1	H6, 7, 8, 9, 16
C25	C25 F R0.2	25.0	6.0	0.2	H10, 11, 17, 18

Corner Rounding



Insert Type	Ordering Code	D	Do	R	I	Holder Code
C10	C10 CR05	10.0	7.9	0.5	1.05	H1, 2, 12, 13
	C10 CR10	10.0	6.9	1.0	1.55	
C18	C18 CR13	17.8	14.2	1.25	1.80	
	C18 CR15	17.8	13.7	1.5	2.05	H6, 7, 8, 9, 16
	C18 CR20	17.8	12.7	2.0	2.55	

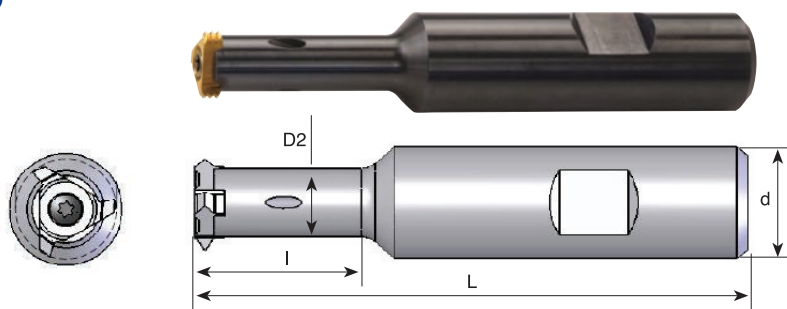
Corner Rounding Multi Flute



Insert Type	Ordering Code	D	Do	R	I	No. of Flutes	Holder Code
S17	S170 E CR10	17.0	13.9	1.0	1.55	5	H3, 4, 5, 14, 15
	S170 E CR13	17.0	13.4	1.25	1.80	5	
	S170 E CR15	17.0	12.9	1.5	2.05	5	

Steel Toolholders

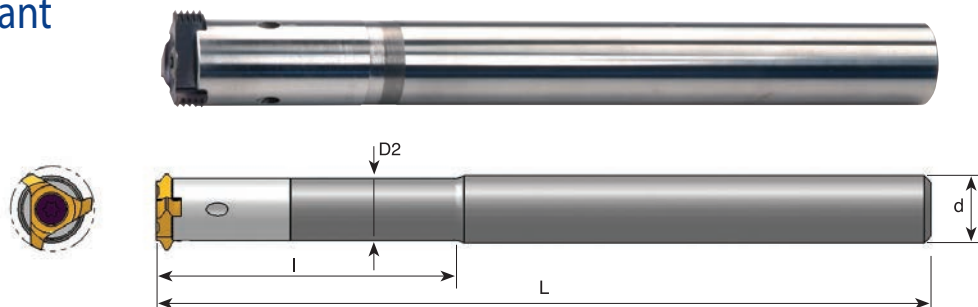
With internal coolant



Tool No.	Ordering Code	Insert Type	d	D2	I	L	Insert Screw	Torx Key
H1	SRC 1210 E	C10	12	7.3	19	70	S5	K5
H2	SRC 1610 G		16		19	90		
H3	SRC 1212 E	C12, S17	12	9.0	25	70	S10	K10
H4	SRC 1612 G		16		25	90		
H5	SRC 1612 H		16		35	100		
H6	SRC 1618 H	C18, S20	16	13.8	48	100	S16	K16
H7	SRC 2018 H		20		32	100		
H8	SRC 2018 J		20		48	110		
H9	SRC 2018 L		20		74	140		
H10	SRC 2525 J	C25	25	17.5	45	115	S27	K27
H11	SRC 2525 M		25		80	150		
H19	SRC 2535 H	S35	25	22	40	100	S33	K33
H20	SRC 2535 K		25		60	130		

Carbide Shank Toolholders

With internal coolant

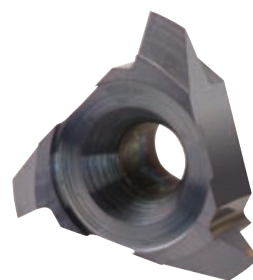


Tool No.	Ordering Code	Insert Type	d	D2	I	L	Insert Screw	Torx Key
H12	CRC 0810 L35 K	C10	8	7.3	35	125	S5	K5
H13	CRC 0810 K		8	8.0	—	125	S5	K5
H14	CRC 1012 L40 M	C12, S17	10	9.0	40	150	S10	K10
H15	CRC 1012 M		10	10.0	—	150	S10	K10
H16	CRC 1218 P	C18, S20	12	12.0	—	170	S16	K16
H17	CRC 1625 R	C25	16	16.0	—	205	S27	K27
H18	CRC 2025 L85 S		20	17.5	85	250	S27	K27
H21	CRC 2035 S	S35	20	22.0	—	260	S33	K33

Toolholders without Weldon

Cutting Data

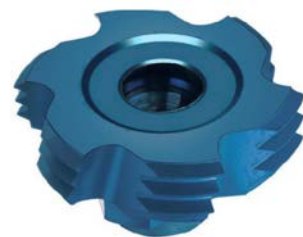
CMT Straight Flute Inserts



ISO Standard	Material	Cutting Speed m/min	Feed mm/tooth Cutting Diameter=D			
			Ø10	Ø12	Ø18	Ø25
P	Low & Medium Carbon Steels <0.55%C	60-120	0.16	0.17	0.20	0.22
	High Carbon Steels ≥0.55%C	60-90	0.14	0.16	0.20	0.22
	Alloy Steels, Treated Steels	50-80	0.10	0.12	0.16	0.18
M	Stainless Steel – Free Cutting	70-100	0.10	0.11	0.15	0.17
	Stainless Steel – Austenitic	60-90	0.10	0.11	0.15	0.17
	Cast Steels	70-90	0.10	0.12	0.16	0.18
K	Cast Iron	40-80	0.16	0.17	0.20	0.22
N	Aluminium ≤12%Si, Copper	100-200	0.16	0.17	0.20	0.22
	Aluminium >12%Si	60-140	0.10	0.11	0.16	0.18
	Synthetics, Duroplastics, Thermoplastics	50-200	0.19	0.19	0.22	0.24
S	Nickel Alloys, Titanium Alloys.	20-40	0.07	0.07	0.10	0.12
H	Hardened Steel 45 – 50HRC	60-70	0.09	0.09	0.13	0.15
	Hardened Steel 50 – 55HRC	50-60	0.08	0.08	0.12	0.14

Cutting Data

CMT Spiral Multi Flute Inserts



ISO Standard	Material	Cutting Speed m/min	Feed mm/tooth Cutting Diameter = D
			Ø16 - Ø35
P	Low & Medium Carbon Steels <0.55%C	60-120	0.14-0.24
	High Carbon Steels ≥0.55%C	60-90	0.12-0.24
	Alloy Steels, Treated Steels	50-80	0.08-0.20
M	Stainless Steel – Free Cutting	70-100	0.08-0.19
	Stainless Steel – Austenitic	60-90	0.08-0.19
	Cast Steels	70-90	0.08-0.20
K	Cast Iron	40-80	0.14-0.24
N	Aluminum ≤12%Si, Copper	100-200	0.14-0.26
	Aluminum >12%Si	60-140	0.08-0.22
	Synthetics, Duroplastics, Thermoplastics	50-200	0.17-0.28
S	Nickel Alloys, Titanium Alloys.	20-40	0.05-0.14
H	Hardened Steel 45-50HRc	60-70	0.07-0.17
	Hardened Steel 51-62HRc	50-60	0.06-0.16

Carmex Mill-Thread catalog and CNC programming software

This software is provided by Carmex to assist the thread milling user, to select and apply the correct tool to machine threads on CNC machining centers. The program will find tools and inserts which are suitable for your application, calculate cutting data and generate a CNC program for a variety of controls.

The software is available at our web site online or offline (download) versions.





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