

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

**Carmex**  
Precision Tools Ltd.

**Free Programming Help!**  
**Please Call For More Information.**



### 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	\$31.35	-	-
	0.75	T-CT12 I 0.75M	\$31.35	-	-
	1.00	T-CT12 I 1.0M	\$31.35	-	-
	1.25	T-CT12 I 1.25M	\$31.35	-	-
	1.50	T-CT12 I 1.5M	\$31.35	-	-
14	0.50	T-CT14 I 0.5M	\$31.35	-	-
	0.75	T-CT14 I 0.75M	\$31.35	T-CT14 E 0.75M	\$31.35
	1.00	T-CT14 I 1.0M	\$31.35	T-CT14 E 1.0M	\$31.35
	1.25	T-CT14 I 1.25M	\$31.35	T-CT14 E 1.25M	\$31.35
	1.50	T-CT14 I 1.5M	\$31.35	T-CT14 E 1.5M	\$31.35
	1.75	T-CT14 I 1.75M	\$31.35	T-CT14 E 1.75M	\$31.35
	2.00	T-CT14 I 2.0M	\$31.35	T-CT14 E 2.0M	\$31.35
21	2.50	T-CT14 I 2.5M	\$31.35	T-CT14 E 2.5M	\$31.35
	1.00	T-CT21 I 1.0M	\$47.03	T-CT21 E 1.0M	\$47.03
	1.50	T-CT21 I 1.5M	\$47.03	T-CT21 E 1.5M	\$47.03
	1.75	T-CT21 I 1.75M	\$47.03	-	-
	2.00	T-CT21 I 2.0M	\$47.03	T-CT21 E 2.0M	\$47.03
	2.50	T-CT21 I 2.5M	\$47.03	T-CT21 E 2.5M	\$47.03
	3.00	T-CT21 I 3.0M	\$47.03	T-CT21 E 3.0M	\$47.03
30	3.50	T-CT21 I 3.5M	\$47.03	-	-
	1.50	T-CT30 I 1.5M	\$67.93	T-CT30 E 1.5M	\$67.93
	2.00	T-CT30 I 2.0M	\$67.93	T-CT30 E 2.0M	\$67.93
	3.00	T-CT30 I 3.0M	\$67.93	T-CT30 E 3.0M	\$67.93
	3.50	T-CT30 I 3.5M	\$67.93	T-CT30 E 3.5M	\$67.93
	4.00	T-CT30 I 4.0M	\$67.93	T-CT30 E 4.0M	\$67.93
40	4.50	T-CT30 I 4.5M	\$67.93	T-CT30 E 4.5M	\$67.93
	1.50	T-CT40 I 1.5M	\$104.50	T-CT40 E 1.5M	\$104.50
	2.00	T-CT40 I 2.0M	\$104.50	T-CT40 E 2.0M	\$104.50
	3.00	T-CT40 I 3.0M	\$104.50	T-CT40 E 3.0M	\$104.50
	3.50	T-CT40 I 3.5M	\$104.50	-	-
	4.00	T-CT40 I 4.0M	\$104.50	T-CT40 E 4.0M	\$104.50
	4.50	T-CT40 I 4.5M	\$104.50	-	-
	5.00	T-CT40 I 5.0M	\$104.50	T-CT40 E 5.0M	\$104.50
5.50	T-CT40 I 5.5M	\$104.50	-	-	
6.00	T-CT40 I 6.0M	\$104.50	T-CT40 E 6.0M	\$104.50	

### 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	\$31.35	-	-
	20	T-CT12 I 20UN	\$31.35	-	-
	18	T-CT12 I 18UN	\$31.35	-	-
	16	T-CT12 I 16UN	\$31.35	-	-
14	32	T-CT14 I 32UN	\$31.35	T-CT14 E 32UN	\$31.35
	28	T-CT14 I 28UN	\$31.35	T-CT14 E 28UN	\$31.35
	27	T-CT14 I 27UN	\$31.35	-	-
	24	T-CT14 I 24UN	\$31.35	T-CT14 E 24UN	\$31.35
	20	T-CT14 I 20UN	\$31.35	T-CT14 E 20UN	\$31.35
	18	T-CT14 I 18UN	\$31.35	T-CT14 E 18UN	\$31.35
	16	T-CT14 I 16UN	\$31.35	T-CT14 E 16UN	\$31.35
	14	T-CT14 I 14UN	\$31.35	T-CT14 E 14UN	\$31.35
	12	T-CT14 I 12UN	\$31.35	T-CT14 E 12UN	\$31.35
	21	24	T-CT21 I 24UN	\$47.03	T-CT21 E 24UN
20		T-CT21 I 20UN	\$47.03	T-CT21 E 20UN	\$47.03
18		T-CT21 I 18UN	\$47.03	T-CT21 E 18UN	\$47.03
16		T-CT21 I 16UN	\$47.03	T-CT21 E 16UN	\$47.03
14		T-CT21 I 14UN	\$47.03	T-CT21 E 14UN	\$47.03
12		T-CT21 I 12UN	\$47.03	T-CT21 E 12UN	\$47.03
10		T-CT21 I 10UN	\$47.03	T-CT21 E 10UN	\$47.03
8		T-CT21 I 8UN	\$47.03	-	-
20		T-CT30 I 20UN	\$67.93	T-CT30 E 20UN	\$67.93
30		18	T-CT30 I 18UN	\$67.93	T-CT30 E 18UN
	16	T-CT30 I 16UN	\$67.93	T-CT30 E 16UN	\$67.93
	14	T-CT30 I 14UN	\$67.93	T-CT30 E 14UN	\$67.93
	12	T-CT30 I 12UN	\$67.93	T-CT30 E 12UN	\$67.93
	10	T-CT30 I 10UN	\$67.93	T-CT30 E 10UN	\$67.93
	8	T-CT30 I 8UN	\$67.93	T-CT30 E 8UN	\$67.93
	6	T-CT30 I 6UN	\$67.93	T-CT30 E 6UN	\$67.93
	16	T-CT40 I 16UN	\$104.50	T-CT40 E 16UN	\$104.50
	14	T-CT40 I 14UN	\$104.50	T-CT40 E 14UN	\$104.50
	40	12	T-CT40 I 12UN	\$104.50	T-CT40 E 12UN
10		T-CT40 I 10UN	\$104.50	T-CT40 E 10UN	\$104.50
8		T-CT40 I 8UN	\$104.50	T-CT40 E 8UN	\$104.50
6		T-CT40 I 6UN	\$104.50	T-CT40 E 6UN	\$104.50
4.5		T-CT40 I 4.5UN	\$104.50	T-CT40 E 4.5UN	\$104.50
4		T-CT40 I 4UN	\$104.50	T-CT40 E 4UN	\$104.50

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# THREADMILLS INSERTS/HOLDERS

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

Free Programming Help!  
Please Call For More Information.

**Carmex**  
Precision Tools Ltd.

For NPT Threads

INSERT SIZE "A"	TPI	INTERNAL/EXTERNAL	
		Part Number	Price Each
12	18	T-CT12 IE 18NPT	\$31.35
14	18	T-CT14 IE 18NPT	\$31.35
14	14	T-CT14 IE 14NPT	\$31.35
21	14	T-CT21 IE 14NPT	\$47.03
21	11.5	T-CT21 IE 11.5NP	\$47.03
30	11.5	T-CT30 IE 11.5NP	\$67.93
30	8	T-CT30 IE 8NPT	\$67.93
40	11.5	T-CT40 IE 11.5NP	\$104.50
40	8	T-CT40 IE 8NPT	\$104.50

For NPTF DRYSEAL Threads

INSERT SIZE "A"	TPI	INTERNAL/EXTERNAL	
		Part Number	Price Each
12	18	T-CT12 IE 18NPF	\$31.35
14	18	T-CT14 IE 18NPF	\$31.35
14	14	T-CT14 IE 14NPF	\$31.35
21	14	T-CT21 IE 14NPF	\$47.03
21	11.5	T-CT21 IE 11.5NP	\$47.03
30	8	T-CT30 IE 8NPF	\$67.93
40	8	T-CT40 IE 8NPF	\$104.50

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

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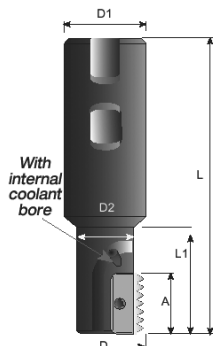


Fig #1

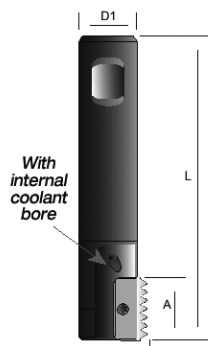


Fig #2

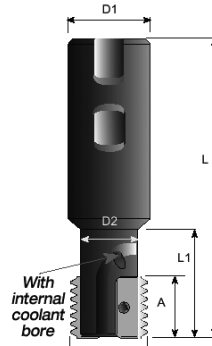


Fig #3

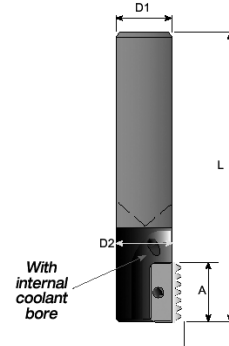


Fig #4

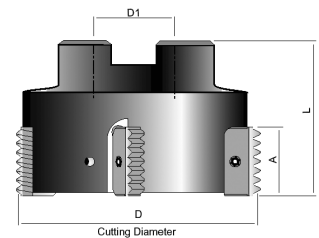


Fig #5

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	\$161.50	S12	K12
		12	0.39	0.75	0.3	3.35	0.51	1	Yes	Steel	T-CTSR0390H12	\$161.50	S12	K12
		14	0.5	0.75	0.37	2.95	0.70	1	Yes	Steel	T-CTSR0500F14	\$161.50	S14	K14
		14	0.54	0.75	0.38	2.98	0.77	1	Yes	Steel	T-CTSR0540F14	\$161.50	S14	K14
		14	0.57	0.75	0.41	3.20	1.00	1	Yes	Steel	T-CTSR0570H14	\$161.50	S14	K14
		14	0.67	0.75	0.53	3.35	1.18	1	Yes	Steel	T-CTSR0670H14	\$161.50	S14	K14
Long Shnk	2	21	0.79	0.75	0.61	3.70	1.57	1	Yes	Steel	T-CTSR0790H21	\$180.50	S21	K21
		30	1.14	1.00	0.91	4.27	1.85	1	Yes	Steel	T-CTSR1140J30	\$229.90	S30	K30
		40	1.73	1.50	1.38	6.02	3.19	1	Yes	Steel	T-CTSR1730M40	\$285.00	S40	K40
Std Length	3	14	0.79	0.75	0.63	3.66	1.57	2	Yes	Steel	T-CTSR0790H14-2	\$294.50	S14	K14
		21	1.18	1.00	0.95	4.25	1.97	2	Yes	Steel	T-CTSR1180J21-2	\$323.00	S21	K21
		30	1.57	1.25	1.18	5.12	2.80	2	Yes	Steel	T-CTSR1580L30-2	\$375.25	S30	K30
		40	1.97	1.50	1.49	6.02	3.35	2	Yes	Steel	T-CTSR1970M40-2	\$418.00	S40	K40
Long Shnk	4	12	0.39	0.312	0.312	5.00	-	1	Yes	Carbide	T-CTSR0390K12C	\$337.25	S12	K12
		14	0.50	0.375	0.375	6.00	-	1	Yes	Carbide	T-CTSR0500J14C	\$337.25	S14	K14
		14	0.62	0.500	0.500	7.00	-	1	Yes	Carbide	T-CTSR0620K14C	\$365.75	S14	K14
		21	0.82	0.625	0.625	8.00	-	1	Yes	Carbide	T-CTSR0820M21C	\$551.00	S21	K21
Shell Mill	5	21	2.48	0.750	1.970	n/a	n/a	5	No	n/a	T-CTSR2480C21-5	\$665.00	S21	K21
		30	2.48	0.750	1.970	n/a	n/a	4	No	n/a	T-CTSR2480C30-4	\$665.00	S30	K30
		30	3.15	1.000	2.160	n/a	n/a	4	No	n/a	T-CTSR3150D30-4	\$688.75	S30	K30
		30	3.94	1.250	2.360	n/a	n/a	4	No	n/a	T-CTSR3940D30-4	\$712.50	S30	K30
		40	3.15	1.000	2.560	n/a	n/a	4	No	n/a	T-CTSR3150D40-4	\$688.75	S40	K40
40	3.94	1.250	2.760	n/a	n/a	4	No	n/a	T-CTSR3940E40-4	\$712.50	S40	K40		

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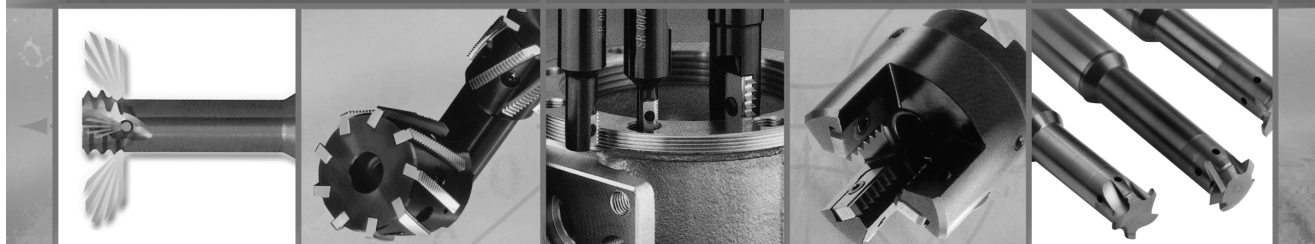


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