

**NEW**



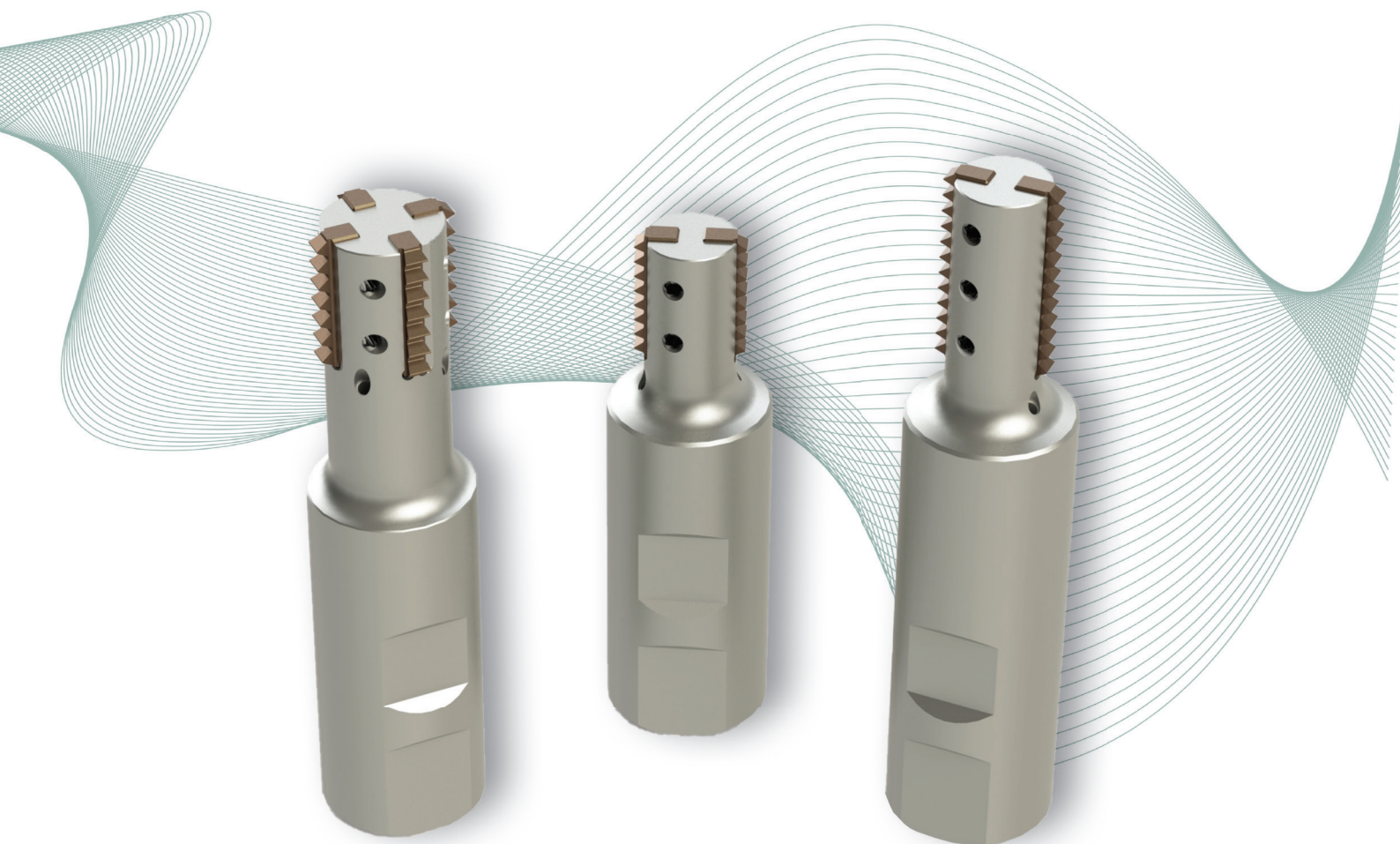
***C.P.T.***  
**Precision Tools**

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# Slim MT

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High productivity – Slim cost



## ***CPT presents Slim MT***

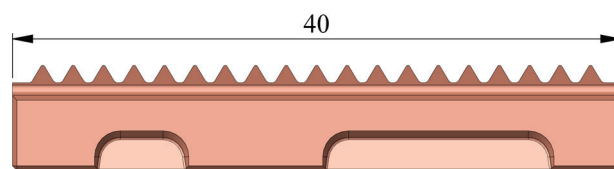
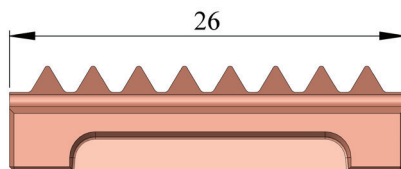
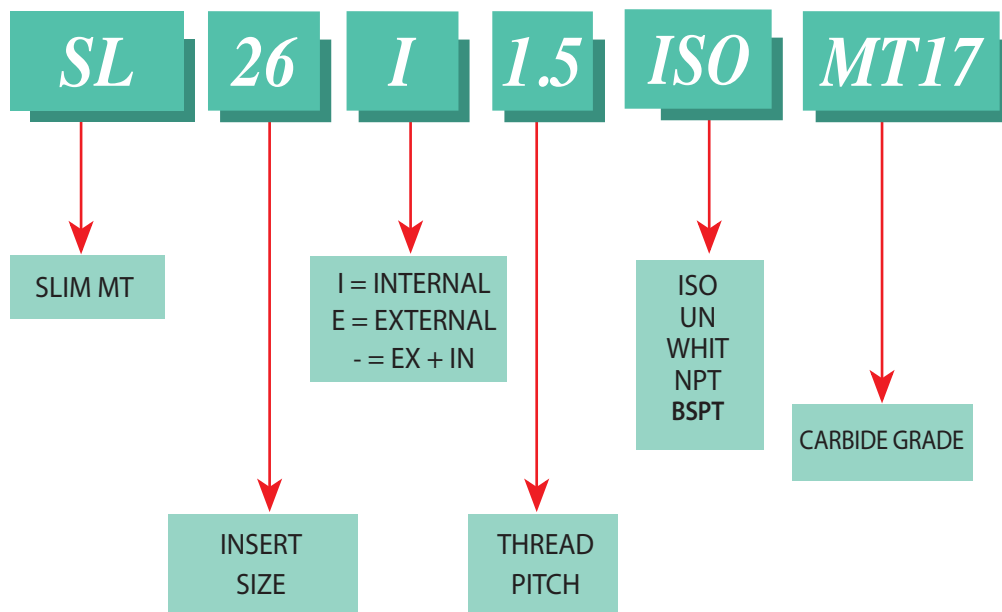
### ***High productivity, Slim cost.***

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.

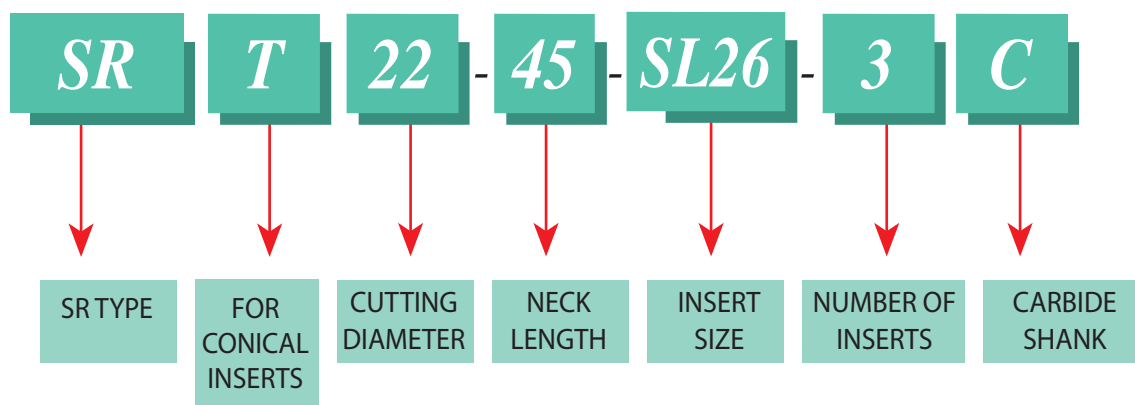
- **Advanced carbide and coating combination for extended tool life and improved productivity.**
- **Most inserts are double sided.**
- **Nickel coated holders for high wear resistance.**
- **Unique clamping mechanism.**
- **Large variety of holders & inserts in accordance to international standards.**

## Product Identification

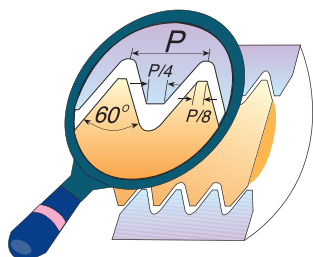
### Inserts



### Toolholders



## ISO



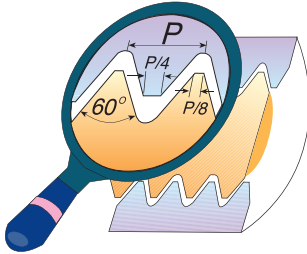
| Insert size | Pitch mm | Ex/In | Ordering code           | Toolholder            |
|-------------|----------|-------|-------------------------|-----------------------|
| SL 26       | 0.5      | In    | <b>SL26 I 0.5 ISO</b>   | SR ..... - SL26 - ... |
|             | 0.75     | In    | <b>SL26 I 0.75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

\* 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



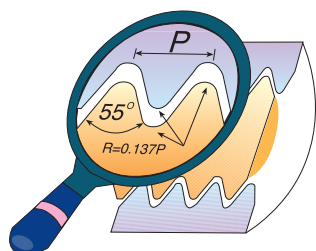
| Insert size | Pitch<br>TPI | Ex/In | Ordering code        | Toolholder            |
|-------------|--------------|-------|----------------------|-----------------------|
| SL 26       | 20           | In    | <b>SL26 I 20 UN</b>  | SR ..... - SL26 - ... |
|             | 20           | Ex    | <b>SL26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

\* 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



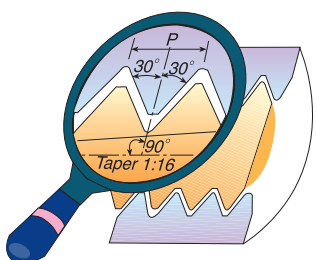
**Same insert for External and Internal thread**

| Insert size | Pitch<br>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



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

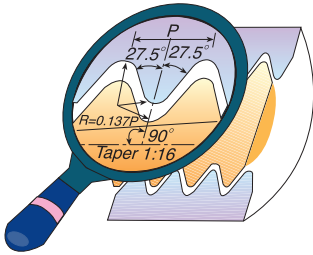
| Insert size | Pitch<br>TPI | Ordering code      | Toolholder            |
|-------------|--------------|--------------------|-----------------------|
| SL 26       | 14           | SL 26 - 14 NPT     | SR ..... - SL26 - ... |
|             | 11.5         | * SL 26 - 11.5 NPT |                     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

\* 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



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

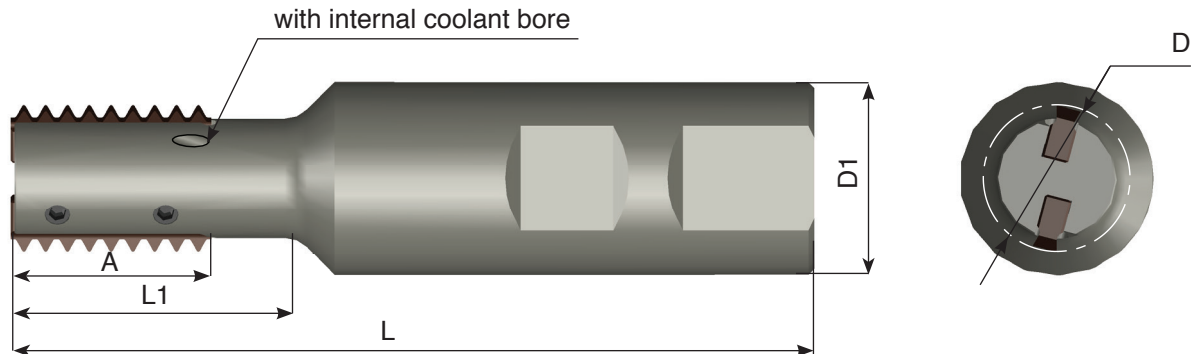
| Insert size | Pitch<br>TPI | Ordering code     | Toolholder            |
|-------------|--------------|-------------------|-----------------------|
| SL 26       | 14           | SL 26 - 14 BSPT   | SR ..... - SL26 - ... |
|             | 11           | * SL 26 - 11 BSPT |                       |

\* 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.

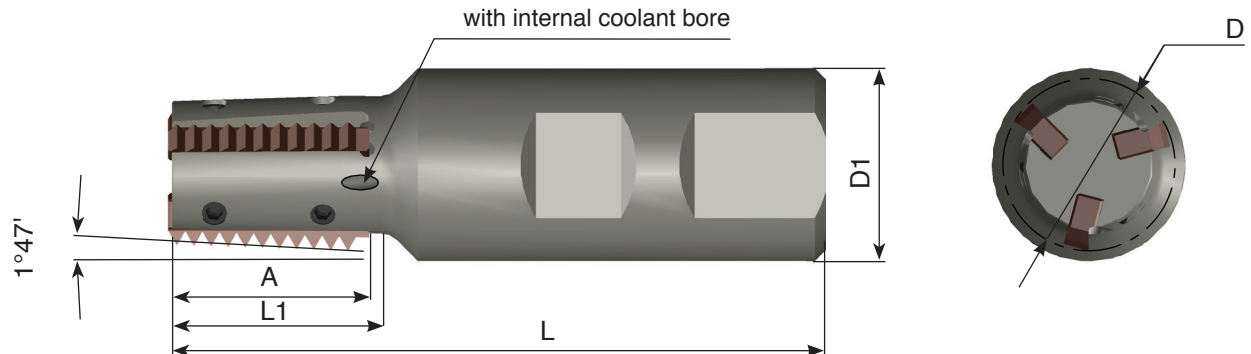
## Toolholders



| Ordering Code         | Insert size=A | D    | D1   | L   | L1 | No. of Inserts | Screw | Key  |
|-----------------------|---------------|------|------|-----|----|----------------|-------|------|
| <b>SR17-27-SL26-2</b> | SL 26         | 17.0 | 25.0 | 85  | 27 | 2              | S4P   | K08P |
| <b>SR17-36-SL26-2</b> |               | 17.0 | 25.0 | 90  | 36 | 2              | S4P   | K08P |
| <b>SR19-27-SL26-2</b> |               | 19.0 | 25.0 | 85  | 27 | 2              | S4P   | K08P |
| <b>SR19-40-SL26-2</b> |               | 19.0 | 25.0 | 95  | 40 | 2              | S4P   | K08P |
| <b>SR20-27-SL26-3</b> |               | 20.5 | 25.0 | 85  | 27 | 3              | S4P   | K08P |
| <b>SR20-40-SL26-3</b> |               | 20.5 | 25.0 | 95  | 40 | 3              | S4P   | K08P |
| <b>SR22-28-SL26-3</b> |               | 22.0 | 25.0 | 85  | 28 | 3              | S4P   | K08P |
| <b>SR22-42-SL26-3</b> |               | 22.0 | 25.0 | 100 | 42 | 3              | S4P   | K08P |
| <b>SR22-42-SL40-3</b> | SL 40         | 22.0 | 25.0 | 100 | 42 | 3              | S4P   | K08P |
| <b>SR30-42-SL40-4</b> |               | 30.0 | 32.0 | 115 | 42 | 4              | S4P   | K08P |

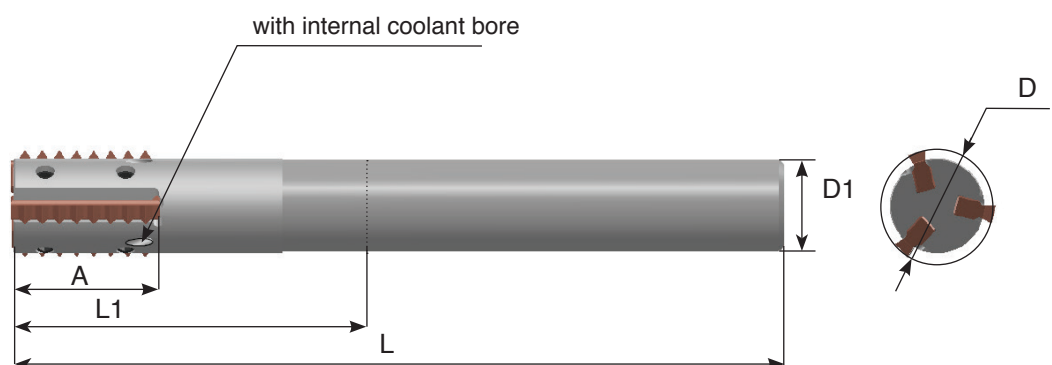


## Toolholders for Conical Threads



| Ordering Code            | Insert size=A | D    | D1   | L  | L1 | No. of Inserts | Screw | Key  |
|--------------------------|---------------|------|------|----|----|----------------|-------|------|
| <b>SR T 17-27-SL26-2</b> | SL 26         | 17.0 | 25.0 | 85 | 27 | 2              | S4P   | K08P |
| <b>SR T 22-27-SL26-3</b> |               | 22.0 | 25.0 | 85 | 27 | 3              | S4P   | K08P |
| <b>SR T 27-27-SL26-4</b> |               | 27.0 | 25.0 | 85 | 27 | 4              | S4P   | K08P |

## Carbide Shank Toolholders



| Ordering Code            | Insert size=A | D    | D1   | L   | L1 | No. of Inserts | Screw | Key  |
|--------------------------|---------------|------|------|-----|----|----------------|-------|------|
| <b>SR 19-70-SL26-2 C</b> | SL 26         | 19.0 | 16.0 | 135 | 70 | 2              | S4P   | K08P |
| <b>SR 20-70-SL26-3 C</b> |               | 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) |
| <b>P</b> | Non-Alloy Steel and Cast Steel,<br>Free Cutting Steel | Annealed < 0.25% C             | 110-220               | ( 0.055 * D ) / 22   |
|          |                                                       | Annealed ≥ 0.25% C             | 100-210               |                      |
|          |                                                       | Annealed ≥ 0.55% C             | 90-150                |                      |
|          |                                                       | Quenched & Tempered < 0.55% C  | 70-140                |                      |
| <b>M</b> | Stainless Steel and Cast Steel                        | Quenched & Tempered ≥ 0.55% C  | 55-70                 | ( 0.055 * D ) / 22   |
|          |                                                       | Annealed                       | 60-110                |                      |
|          |                                                       | Quenched & Tempered            | 60-90                 |                      |
|          |                                                       | Annealed                       | 55-90                 |                      |
| <b>K</b> | Cast Iron Nodular (GGG)                               | Quenched & Tempered            | 45-80                 | ( 0.055 * D ) / 22   |
|          |                                                       | Ferritic                       | 90-200                |                      |
|          |                                                       | Martensitic                    | 80-160                |                      |
|          |                                                       | Austenitic                     | 60-110                |                      |
| <b>N</b> | Grey Cast Iron (GG)                                   | High alloy Austenitic & Duplex | 40-70                 | ( 0.045 * D ) / 22   |
|          |                                                       | Ferritic                       | 90-125                |                      |
|          |                                                       | Pearlitic                      | 90-110                |                      |
|          |                                                       | Ferritic                       | 110-145               |                      |
| <b>S</b> | Malleable Cast Iron                                   | Pearlitic                      | 80-125                | ( 0.055 * D ) / 22   |
|          |                                                       | Ferritic                       | 110-125               |                      |
|          |                                                       | Pearlitic                      | 80-120                |                      |
|          |                                                       | Ferritic                       | 110-125               |                      |
| <b>N</b> | Aluminum-Wrought Alloy                                | Not Cureable                   | 135-350               | ( 0.05 * D ) / 22    |
|          |                                                       | Cured                          | 100-270               |                      |
|          |                                                       | Not Cureable ≤ 12% Si          | 90-270                |                      |
|          |                                                       | Cured                          | 90-225                |                      |
| <b>S</b> | Aluminum-Cast, Alloyed                                | High Temperature > 12% Si      | 90-180                | ( 0.038 * D ) / 22   |
|          |                                                       | Free Cutting > 1% Pb           | 70-225                |                      |
|          |                                                       | Brass                          | 70-180                |                      |
|          |                                                       | Electrolytic Copper            | 70-270                |                      |
| <b>S</b> | Copper Alloys                                         | Duroplastics, Fiber Plastics   | 70-270                | ( 0.038 * D ) / 22   |
|          |                                                       | Hard Rubber                    | 70-270                |                      |
|          |                                                       | Annealed                       | 30-50                 |                      |
|          |                                                       | Cured                          | 30-50                 |                      |
| <b>S</b> | High Temperature/Super Alloys (Fe based)              | Annealed                       | 25-45                 | ( 0.038 * D ) / 22   |
|          |                                                       | Cured                          | 25-45                 |                      |
|          |                                                       | Cast                           | 25-45                 |                      |
|          |                                                       | Cast                           | 25-45                 |                      |
| <b>S</b> | High Temperature/Super Alloys (Ni or Co based)        | Alpha + Beta Alloys Cured      | 30-40                 | ( 0.038 * D ) / 22   |
|          |                                                       | Alpha + Beta Alloys Cured      | 30-40                 |                      |
|          |                                                       | Alpha + Beta Alloys Cured      | 30-40                 |                      |
|          |                                                       | Alpha + Beta Alloys Cured      | 30-40                 |                      |
| <b>S</b> | Titanium Alloys                                       | Alpha + Beta Alloys Cured      | 30-40                 | ( 0.038 * D ) / 22   |
|          |                                                       | Alpha + Beta Alloys Cured      | 30-40                 |                      |
|          |                                                       | Alpha + Beta Alloys Cured      | 30-40                 |                      |
|          |                                                       | Alpha + Beta Alloys Cured      | 30-40                 |                      |

D= Tool holder cutting diameter.



