



Carmex
Precision Tools Ltd.

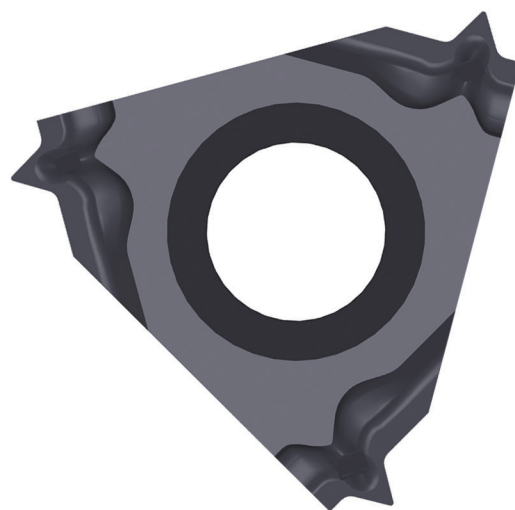
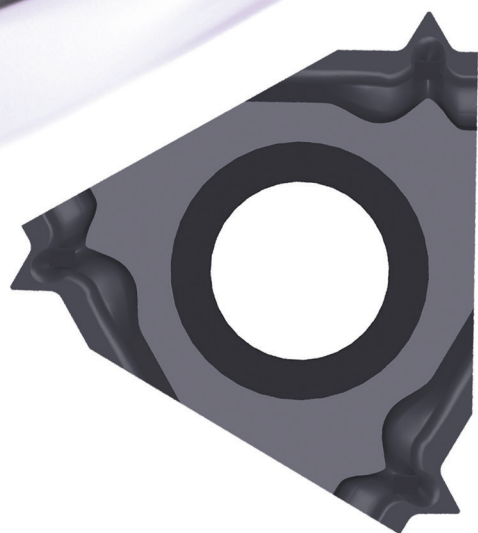
x-treme thread cutting™



Thread Turning

New Products

Size 11_{mm} Type B inserts



Metric 2013 - 14

Precision ground thread form with sintered Chip-Breaker

Carmex expands the Type B line by offering a new size 11mm internal thread turning inserts, including a wide range of thread profiles and pitches

Precision Ground Profile

Ensures accurate and high quality threads

- Suitable for most common materials.
- Reduces cutting forces.

Sintered Chip-Breaker

- Improved chip control and chip flow, for high surface finish.
- Excellent for internal threads.

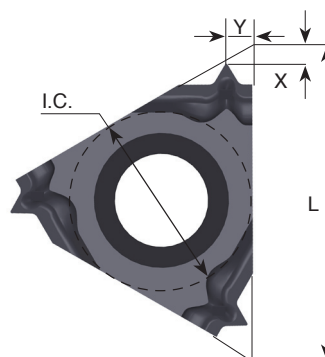
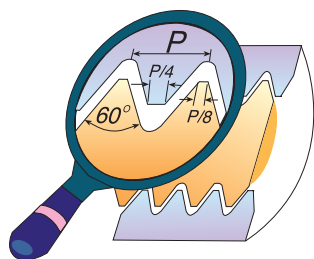
Grade and Coating

- BMA Sub-Micrograin grade (K20-K30, P20-P40).
- Advance PVD coating, provides high wear and heat resistance.
- To use with a wide range of materials.

To be used with Carmex standard toolholders

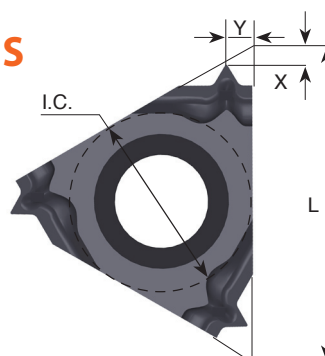
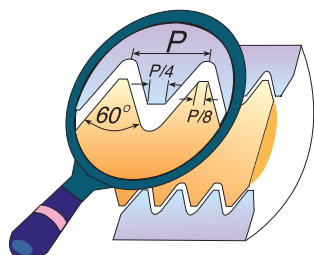
Type B Inserts

ISO - metric 60°



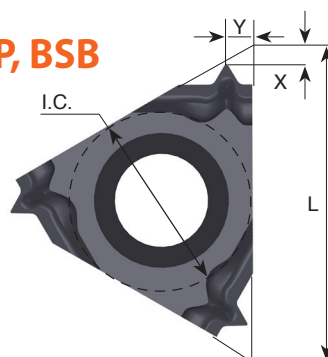
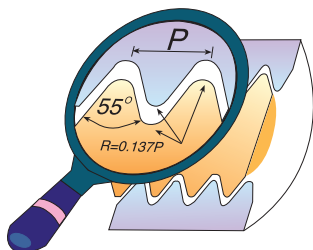
Pitch mm	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
0.5	11	1/4	11 IR B 0.5 ISO	0.6	0.6
0.75			11 IR B 0.75 ISO	0.6	0.6
0.8			11 IR B 0.8 ISO	0.6	0.6
1.0			11 IR B 1.0 ISO	0.6	0.6
1.25			11 IR B 1.25 ISO	0.8	0.9
1.5			11 IR B 1.5 ISO	0.8	0.9
1.75			11 IR B 1.75 ISO	0.8	0.9
2.0			11 IR B 2.0 ISO	0.8	0.9

UN - Unified 60° UNC, UNF, UNEF, UNS



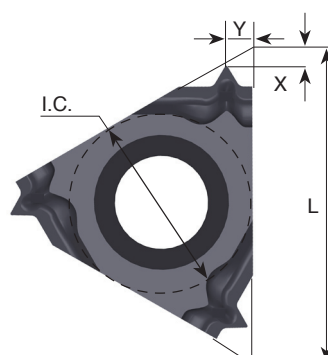
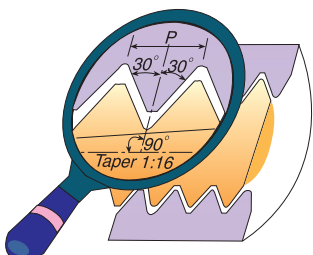
Pitch TPI	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
32	11	1/4	11 IR B 32 UN	0.6	0.6
28			11 IR B 28 UN	0.6	0.6
24			11 IR B 24 UN	0.6	0.6
20			11 IR B 20 UN	0.8	0.9
18			11 IR B 18 UN	0.8	0.9
16			11 IR B 16 UN	0.8	0.9
14			11 IR B 14 UN	0.8	0.9
12			11 IR B 12 UN	0.8	0.9

Whitworth 55° BSW, BSF, BSP, BSB



Pitch TPI	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
28	11	1/4	11 IR B 28 W	0.6	0.6
24			11 IR B 24 W	0.6	0.6
20			11 IR B 20 W	0.8	0.9
19			11 IR B 19 W	0.8	0.9
18			11 IR B 18 W	0.8	0.9
16			11 IR B 16 W	0.8	0.9
14			11 IR B 14 W	0.8	0.9

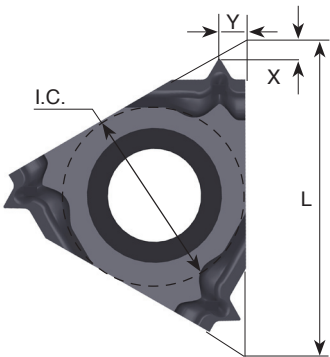
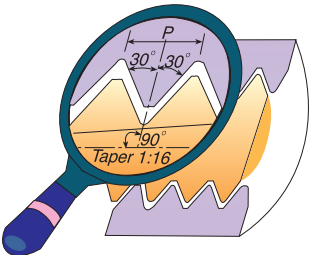
NPT



Pitch TPI	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
18	11	1/4	11 IR B 18 NPT	0.8	0.9

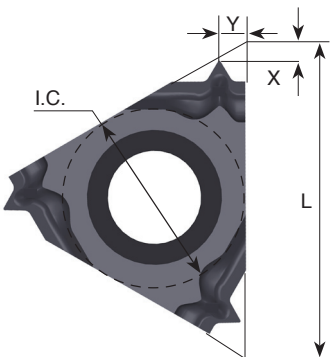
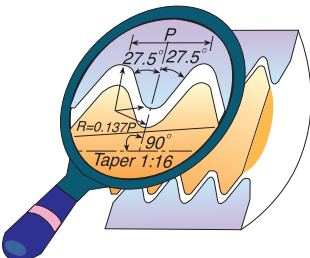
Type B Inserts

NPTF - Dryseal



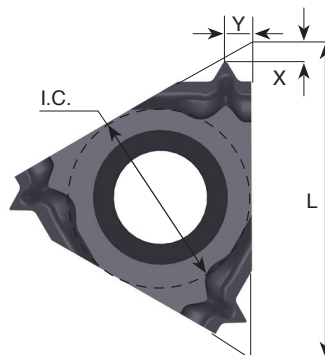
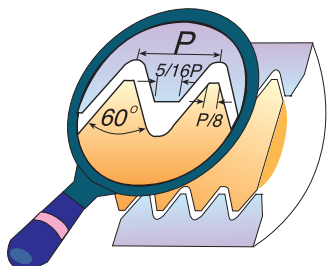
Pitch TPI	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
18	11	1/4	11 IR B 18 NPTF	0.8	0.9

BSPT



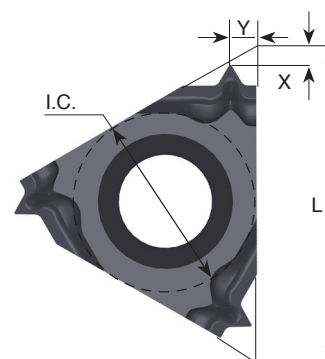
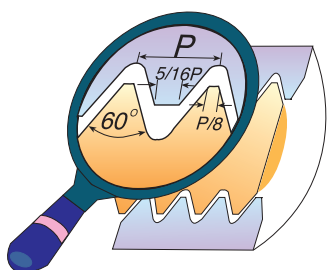
Pitch TPI	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
19	11	1/4	11 IR B 19 BSPT	0.8	0.9

MJ - ISO 5855



Pitch mm	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
1.0	11	1/4	11 IR B 1.0 MJ	0.6	0.6
1.5			11 IR B 1.5 MJ	0.8	0.9

UNJ UNJC, UNJF, UNJEF, UNJS



Pitch TPI	L	I.C. in	INTERNAL Ordering Code Right Hand	X	Y
32	11	1/4	11 IR B 32 UNJ	0.6	0.6
28			11 IR B 28 UNJ	0.6	0.6
24			11 IR B 24 UNJ	0.6	0.6
20			11 IR B 20 UNJ	0.8	0.9
18			11 IR B 18 UNJ	0.8	0.9
16			11 IR B 16 UNJ	0.8	0.9
14			11 IR B 14 UNJ	0.8	0.9

Recommended cutting speed (m/min) for thread turning inserts

BMA (P20-P40), (K20-K30) PVD TiAlN coated sub-micrograin grade for stainless steels and exotic materials at medium to high cutting speed.

ISO Standard	Material		Condition	BMA
P	Non-Alloy Steel and Cast Steels, Free Cutting Steel	<0.25%C	Annealed	120–180
		≥0.25%C	Annealed	
		< 0.55%C	Quenched and Tempered	
		≥0.55%C	Annealed	
			Quenched and Tempered	
	Low Alloy Steel and Cast Steel (less than 5% Alloying Elements)		Annealed	80–130
			Quenched and Tempered	
High Alloy Steel, Cast Steel, and Tool Steel		Annealed	60–80	
		Quenched and Tempered		
M	Stainless Steel and Cast Steel		Ferritic/martensitic	90–130
			Martensitic	
			Austenitic	
K	Cast Iron Nodular (Ggg)		Ferritic/pearlitic	100–130
			Pearlitic	
	Grey Cast Iron (GG)		Ferritic	120–130
			Pearlitic	
	Malleable Cast Iron		Ferritic	100–130
			Pearlitic	
N	Aluminum-Wrought Alloy		Not cureable	---
			Cured	
	Aluminum-Cast, Alloyed	≤12% Si	Not cureable	---
			Cured	
		> 12% Si	High Temperature	
	Copper Alloys	> 1% Pb	Free Cutting	---
			Brass	
			Electrolytic Copper	
	Non Metallic		Duroplastics, Fiber Plastics	---
Hard Rubber				
S	High Temp. Alloys, Super Alloys	Fe based	Annealed	25–69
			Cured	
		Ni or Co based	Annealed	
			Cured	
			Cast	
	Titanium Alloys		Alpha+beta alloys cured	35–45
H	Hardened steel		Hardened 45–50 HRC	35–45
			Hardened 51–55 HRC	
			Hardened 56–62 HRC	
	Chilled cast iron		Cast	25–35
	Cast iron		Hardened	15–25



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x-treme thread cutting™



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