



Carmex
Precision Tools Ltd.
x-treme thread cutting™



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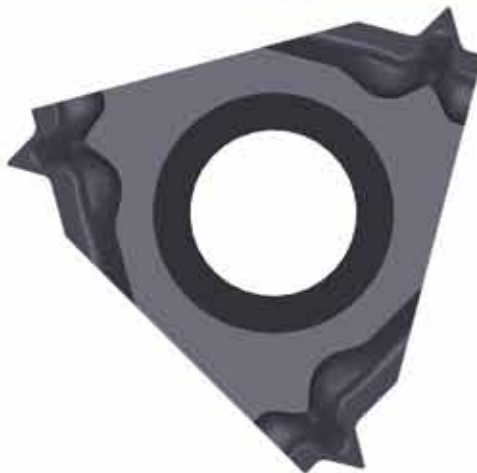
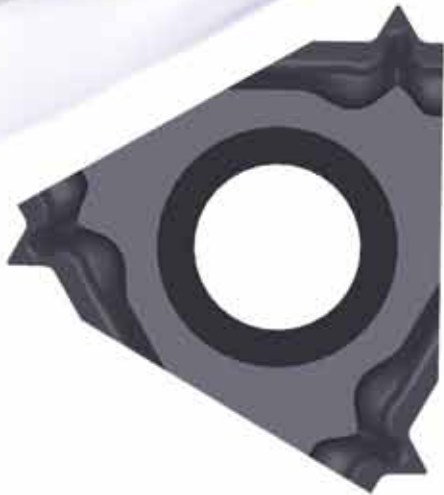
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Thread Turning New Products

Size 11mm (1/4") Type B inserts



Precision ground thread form with sintered Chip-Breaker

Carmex expands the Type B line by offering a new size 11mm (1/4") internal thread turning inserts, including a wide range of thread profiles and pitches

Precision ground thread form with Sintered Chip-Breaker.

Precision Ground Profile

Ensures accurate and high quality threads.

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

Sintered Chip-Breaker

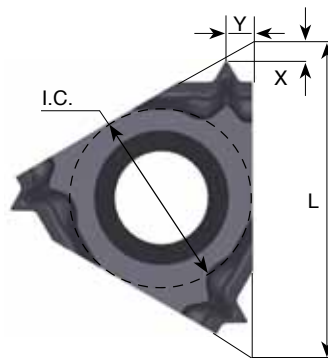
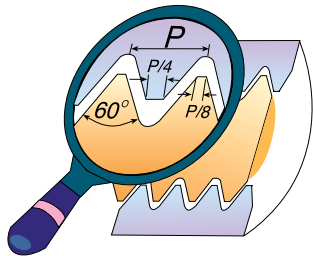
- Improved chip control and chip flow, for high surface finish.
- Excellent for internal threads.

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.

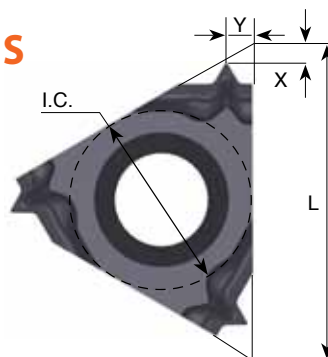
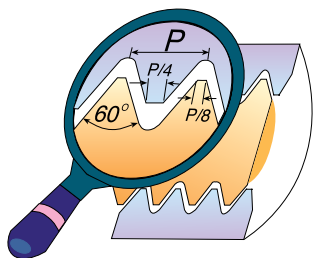
To be used with Carmex standard toolholders

ISO - metric 60°



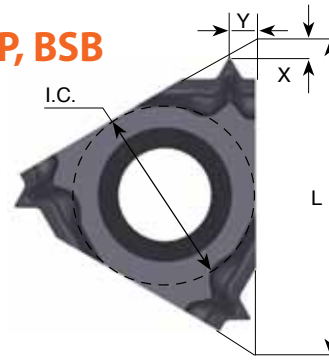
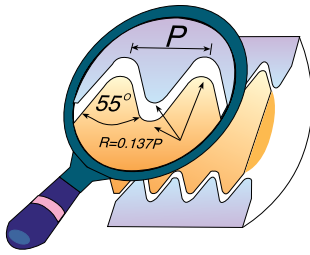
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0.5	11	1/4	11 IR B 0.5 ISO	.02	.02
0.75			11 IR B 0.75 ISO	.02	.02
0.8			11 IR B 0.8 ISO	.02	.02
1.0			11 IR B 1.0 ISO	.02	.02
1.25			11 IR B 1.25 ISO	.03	.04
1.5			11 IR B 1.5 ISO	.03	.04
1.75			11 IR B 1.75 ISO	.03	.04
2.0			11 IR B 2.0 ISO	.03	.04

UN - Unified 60° UNC, UNF, UNEF, UNS



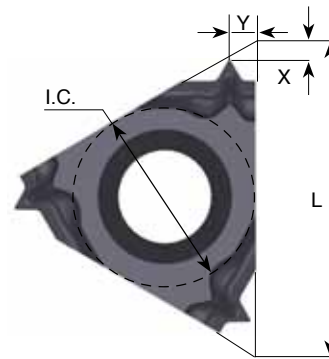
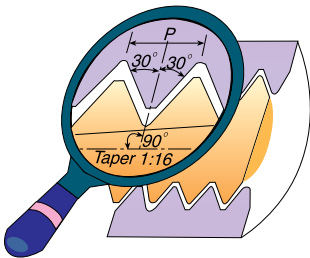
Pitch TPI	L mm	I.C.	INTERNAL Ordering Code Right Hand	X	Y
32	11	1/4	11 IR B 32 UN	.02	.02
28			11 IR B 28 UN	.02	.02
24			11 IR B 24 UN	.02	.02
20			11 IR B 20 UN	.02	.02
18			11 IR B 18 UN	.03	.04
16			11 IR B 16 UN	.03	.04
14			11 IR B 14 UN	.03	.04
12			11 IR B 12 UN	.03	.04

Whitworth 55° BSW, BSF, BSP, BSB



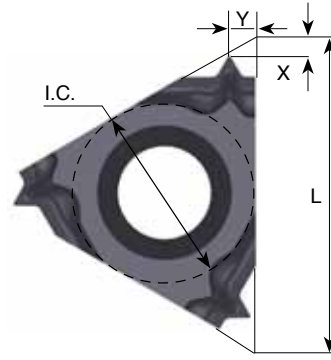
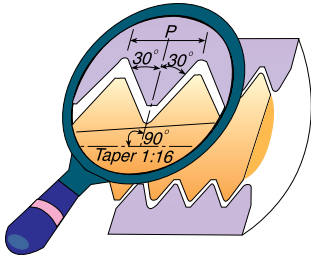
Pitch TPI	L mm	I.C.	INTERNAL Ordering Code Right Hand	X	Y
28	11	1/4	11 IR B 28 W	.02	.02
24			11 IR B 24 W	.02	.02
20			11 IR B 20 W	.03	.04
19			11 IR B 19 W	.03	.04
18			11 IR B 18 W	.03	.04
16			11 IR B 16 W	.03	.04
14			11 IR B 14 W	.03	.04

NPT



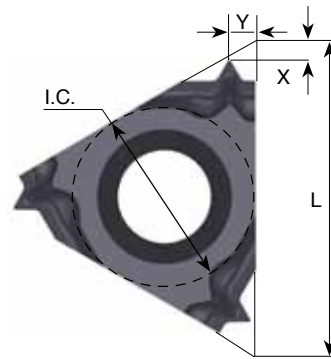
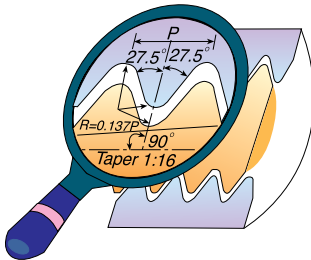
Pitch TPI	L mm	I.C.	INTERNAL Ordering Code Right Hand	X	Y
18	11	1/4	11 IR B 18 NPT	.03	.04

NPTF - Dryseal



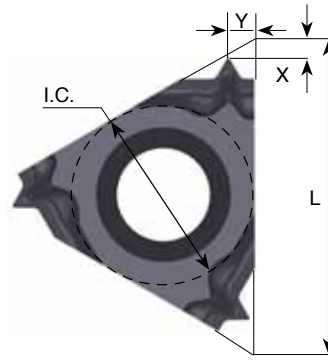
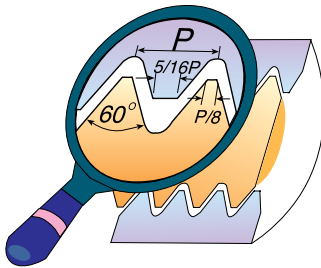
Pitch TPI	L mm	I.C.	INTERNAL Ordering Code Right Hand	X	Y
18	11	1/4	11 IR B 18 NPTF	.03	.04

BSPT



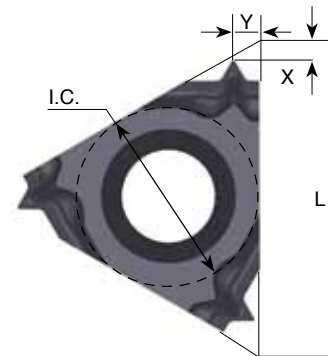
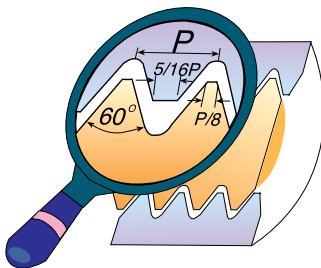
Pitch TPI	L mm	I.C.	INTERNAL Ordering Code Right Hand	X	Y
19	11	1/4	11 IR B 19 BSPT	.03	.04

MJ - ISO 5855



Pitch mm	L mm	I.C.	INTERNAL Ordering Code Right Hand	X	Y
1.0	11	1/4	11 IR B 1.0 MJ	.02	.02
1.5			11 IR B 1.5 MJ	.03	.04

UNJ UNJC, UNJF, UNJEF, UNJS



Pitch TPI	L mm	I.C.	INTERNAL Ordering Code Right Hand	X	Y
32	11	1/4	11 IR B 32 UNJ	.02	.02
28			11 IR B 28 UNJ	.02	.02
24			11 IR B 24 UNJ	.02	.02
20			11 IR B 20 UNJ	.03	.04
18			11 IR B 18 UNJ	.03	.04
16			11 IR B 16 UNJ	.03	.04
14			11 IR B 14 UNJ	.03	.04

Recommended cutting speed (ft/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	390-590
		≥0.25%C	Annealed	
		< 0.55%C	Quenched and Tempered	
		≥0.55%C	Annealed	
	Low Alloy Steel and Cast Steel (less than 5% Alloying Elements)	Annealed	260-420	
		Quenched and Tempered		
High Alloy Steel, Cast Steel, and Tool Steel	Annealed	200-260		
	Quenched and Tempered			
M	Stainless Steel and Cast Steel	Ferritic/martensitic	290-430	
		Martensitic		
		Austenitic		
K	Cast Iron Nodular (Ggg)	Ferritic/pearlitic	330-430	
		Pearlitic		
	Grey Cast Iron (GG)	Ferritic	390-430	
		Pearlitic		
	Malleable Cast Iron	Ferritic	330-430	
		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	80-200
			Cured	
		Ni or Co Based	Annealed	
			Cured	
		Cast		
Titanium Alloys	Alpha+beta alloys cured	115-150		
H	Hardened Steel	Hardened 45-50 HRC	115-150	
		Hardened 51-55 HRC		
		Hardened 56-62 HRC		
	Chilled Cast Iron	Cast	80-115	
Cast Iron	Hardened	50-80		