

NEW



C.P.T.
Precision Tools

Slim MT

High productivity – Slim cost





CPT presents Slim MT

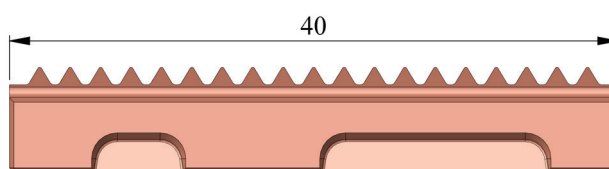
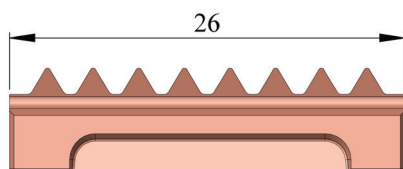
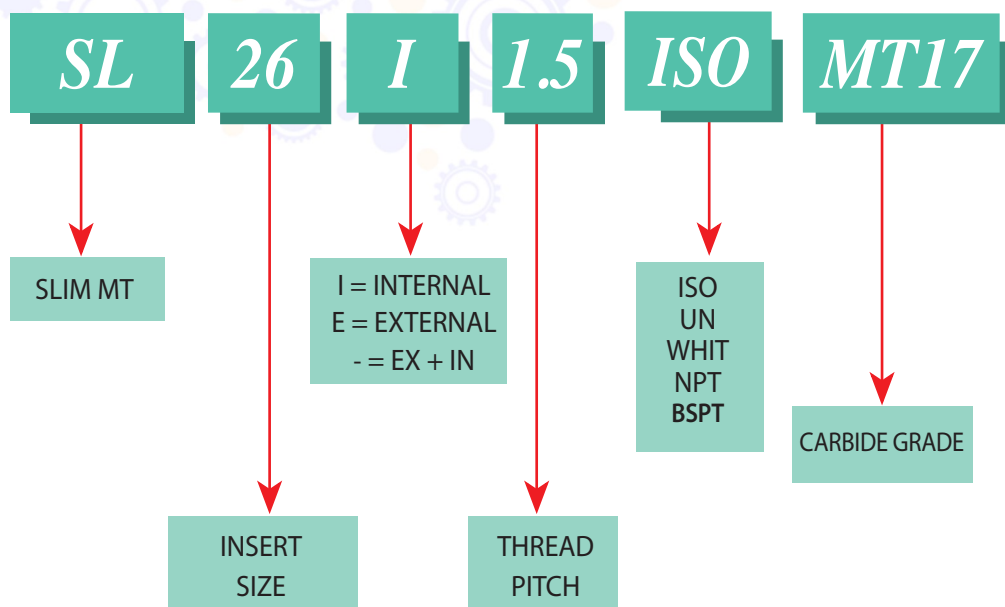
High productivity, Slim cost.

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.

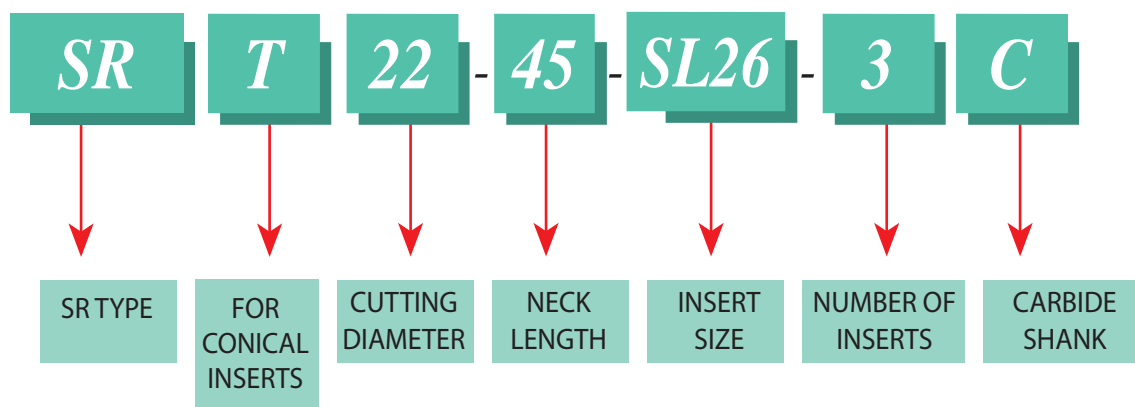
- **Advanced carbide and coating combination for extended tool life and improved productivity.**
- **Most inserts are double sided.**
- **Nickel coated holders for high wear resistance.**
- **Unique clamping mechanism.**
- **Large variety of holders & inserts in accordance to international standards.**

Product Identification

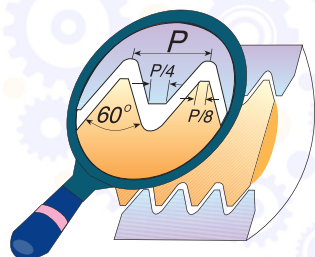
Inserts



Toolholders



ISO



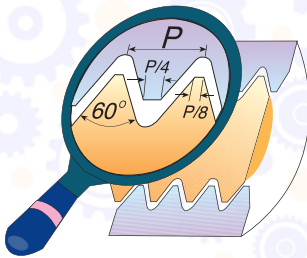
Insert size	Pitch mm	Ex/In	Ordering code	Toolholder
SL 26	0.5	In	SL26 I 0.5 ISO	SR - SL26 - ...
	0.75	In	SL26 I 0.75 ISO	
	1.0	In	SL26 I 1.0 ISO	
	1.0	Ex	SL26 E 1.0 ISO	
	1.5	In	SL26 I 1.5 ISO	
	1.5	Ex	SL26 E 1.5 ISO	
	2.0	In	SL26 I 2.0 ISO	
	2.0	Ex	SL26 E 2.0 ISO	
	2.5	In	SL26 I 2.5 ISO	
	2.5	Ex	SL26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

* 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



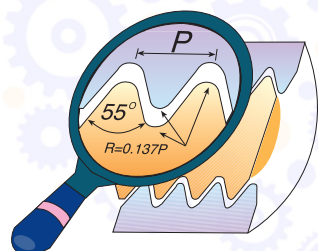
Insert size	Pitch TPI	Ex/In	Ordering code	Toolholder
SL 26	20	In	SL26 I 20 UN	SR - SL26 - ...
	20	Ex	SL26 E 20 UN	
	18	In	SL26 I 18 UN	
	18	Ex	SL26 E 18 UN	
	16	In	SL26 I 16 UN	
	14	In	SL26 I 14 UN	
	12	In	SL26 I 12 UN	
	12	Ex	SL26 E 12 UN	
	10	In	SL26 I 10 UN	
	10	Ex	SL26 E 10 UN	
	9	In	* SL26 I 9 UN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

* 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



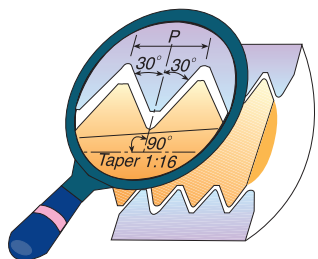
Same insert for External and Internal thread

Insert size	Pitch 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



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

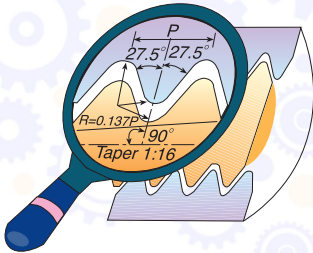
Insert size	Pitch TPI	Ordering code	Toolholder
SL 26	14	SL 26 - 14 NPT	SR - SL26 - ...
	11.5	* SL 26 - 11.5 NPT	

* 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



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

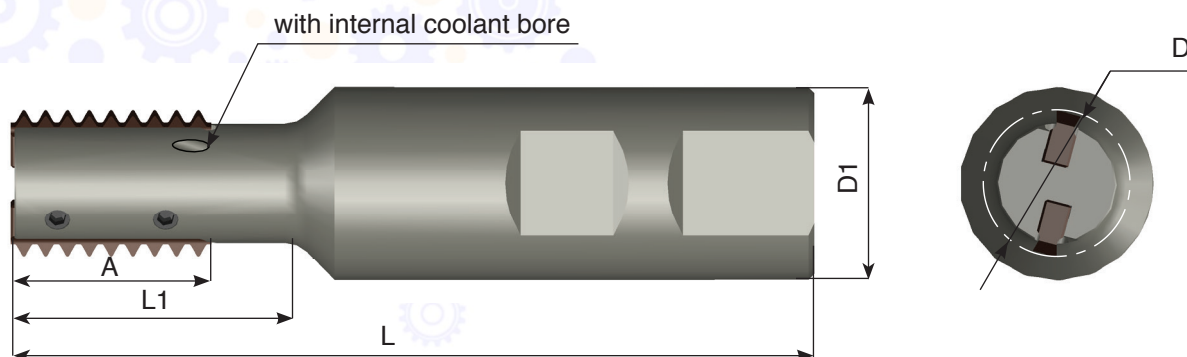
Insert size	Pitch TPI	Ordering code	Toolholder
SL 26	14	SL 26 - 14 BSPT	SR - SL26 - ...
	11	* SL 26 - 11 BSPT	

* Cannot be used with toolholder SRT17-27-SL26-2

For tool holders see pages 8-9.

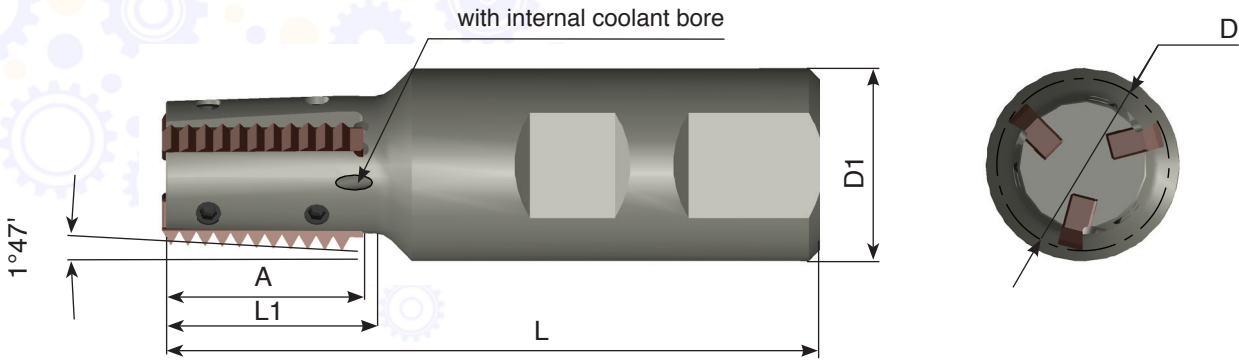
For carbide grade and cutting speed see page 10.

Toolholders



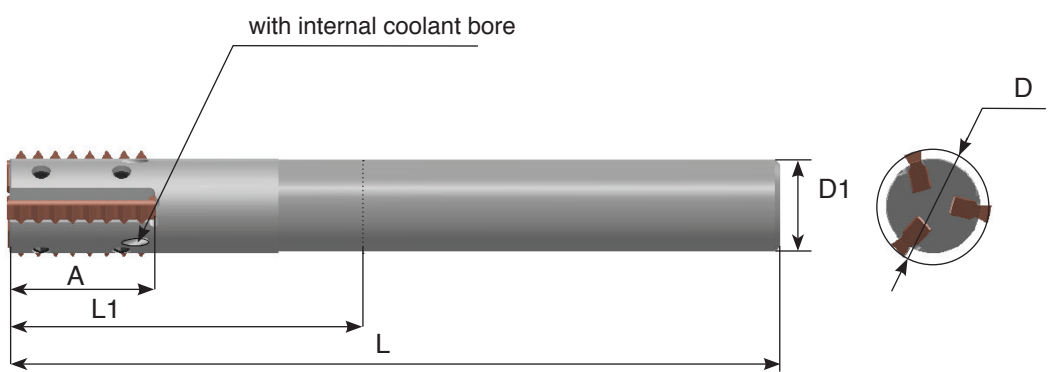
Ordering Code	Insert size=A	D	D1	L	L1	No. of Inserts	Screw	Key
SR17-27-SL26-2	SL 26	17.0	25.0	85	27	2	S4P	K08P
SR17-36-SL26-2		17.0	25.0	90	36	2	S4P	K08P
SR19-27-SL26-2		19.0	25.0	85	27	2	S4P	K08P
SR19-40-SL26-2		19.0	25.0	95	40	2	S4P	K08P
SR20-27-SL26-3		20.5	25.0	85	27	3	S4P	K08P
SR20-40-SL26-3		20.5	25.0	95	40	3	S4P	K08P
SR22-28-SL26-3		22.0	25.0	85	28	3	S4P	K08P
SR22-42-SL26-3		22.0	25.0	100	42	3	S4P	K08P
SR22-42-SL40-3	SL 40	22.0	25.0	100	42	3	S4P	K08P
SR30-42-SL40-4		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
SR T 17-27-SL26-2	SL 26	17.0	25.0	85	27	2	S4P	K08P
SR T 22-27-SL26-3		22.0	25.0	85	27	3	S4P	K08P
SR T 27-27-SL26-4		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
SR 19-70-SL26-2 C	SL 26	19.0	16.0	135	70	2	S4P	K08P
SR 20-70-SL26-3 C		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)
P	Non-Alloy Steel and Cast Steel, 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	
M	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	
K	Cast Iron Nodular (GGG)	Quenched & Tempered	45-80	(0.055 * D) / 22
		Ferritic	90-200	
		Martensitic	80-160	
		Austenitic	60-110	
N	Grey Cast Iron (GG)	High alloy Austenitic & Duplex	40-70	(0.045 * D) / 22
		Ferritic	90-125	
		Pearlitic	90-110	
		Ferritic	110-145	
S	Malleable Cast Iron	Pearlitic	80-125	(0.055 * D) / 22
		Ferritic	110-125	
		Pearlitic	80-120	
		Ferritic	110-125	
N	Aluminum-Wrought Alloy	Not Cureable	135-350	(0.05 * D) / 22
		Cured	100-270	
		Not Cureable ≤ 12% Si	90-270	
		Cured	90-225	
S	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	
S	Copper Alloys	Duroplastics, Fiber Plastics	70-270	(0.038 * D) / 22
		Hard Rubber	70-270	
		Annealed	30-50	
		Cured	30-50	
S	High Temperature/Super Alloys (Fe based)	Annealed	25-45	(0.038 * D) / 22
		Cured	25-45	
		Cast	25-45	
		Cast	25-45	
S	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	
S	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.





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