

# SLIM MT PROMO

BUY **4** MILL-THREAD INSERTS

AND GET A **Z2 TOOLHOLDER**  
**FOR FREE**

BUY **6** MILL-THREAD INSERTS

AND GET A **Z3 TOOLHOLDER**  
**FOR FREE**

BUY **8** MILL-THREAD INSERTS

AND GET A **Z4 TOOLHOLDER**  
**FOR FREE**



The following product lines are excluded  
from promotion: Carbide Shank Toolholders  
and Multi-Insert Toolholders.

Supervised by:

Please specify in your order  
the promotion code: „SLIM-22“,  
the Mill-Thread Insert and  
the matching toolholder.

## SLIM MT

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.

## Advantages/Technical data

- 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.

## Schnittdaten

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 Annealed ≥ 0.25% C Annealed ≥ 0.55% C Quenched & Tempered < 0.55% C Quenched & Tempered ≥ 0.55% C	110-220 100-210 90-150 70-140 55-70	( 0.055 * D ) / 22
	Low Alloy Steel and Cast Steel (less than 5% alloying elements)	Annealed Quenched & Tempered	60-110 60-90	( 0.055 * D ) / 22
	High Alloy Steel, Cast Steel, and Tool Steel	Annealed Quenched & Tempered	55-90 45-80	
M	Stainless Steel and Cast Steel	Ferritic Martensitic Austenitic	90-200 80-160 60-110	( 0.055 * D ) / 22
		High alloy Austenitic & Duplex	40-70	( 0.045 * D ) / 22
K	Cast Iron Nodular (GGG)	Ferritic	90-125	( 0.055 * D ) / 22
		Pearlitic	90-110	
	Grey Cast Iron (GG)	Ferritic	110-145	
		Pearlitic	80-125	
	Malleable Cast Iron	Ferritic	110-125	
		Pearlitic	80-120	
N	Aluminum-Wrought Alloy	Not Cureable	135-350	( 0.05 * D ) / 22
		Cured	100-270	
	Aluminum-Cast, Alloyed	Not Cureable ≤ 12% Si	90-270	
		Cured High Temperature > 12% Si	90-225 90-180	
	Copper Alloys	Free Cutting > 1% Pb Brass Electrolytic Copper	70-225 70-180 70-270	
Non Metallic	Duroplastics, Fiber Plastics Hard Rubber	70-270 70-270		
S	High Temperature/Super Alloys (Fe based)	Annealed Cured	30-50	( 0.038 * D ) / 22
	High Temperature/Super Alloys (Ni or Co based)	Annealed	25-45	
		Cured Cast		
	Titanium Alloys	Alpha + Beta Alloys Cured	30-40	