



Multi-Flute
Indexable
Thread Milling

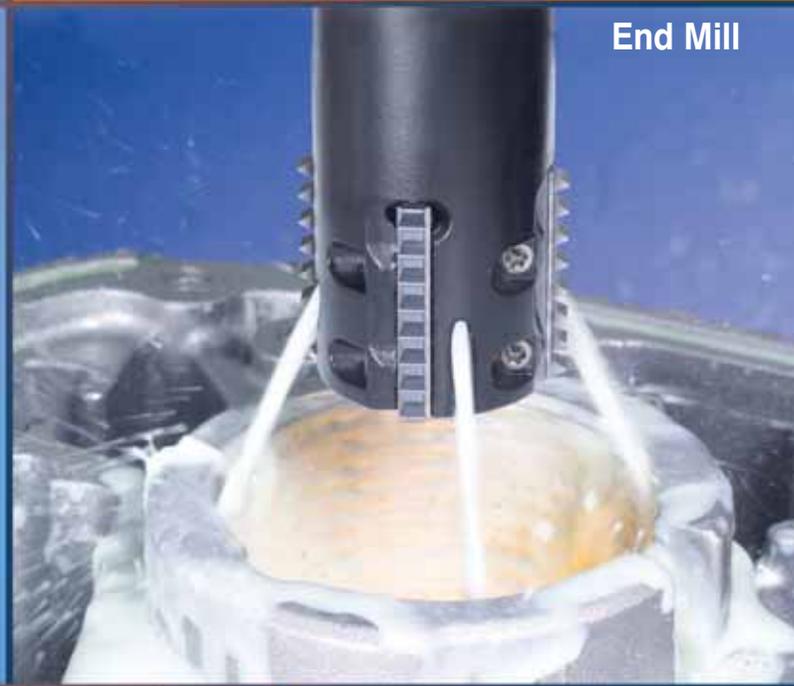
MiTM

Features:

- Up to 8 inserts for high feed rate
- Tool diameter as small as 17mm
- Excellent stability in deep holes
- High rigidity
- Coolant - Thru
- Adjustable overhang in Shell Mill cutters

Shell Mill

End Mill



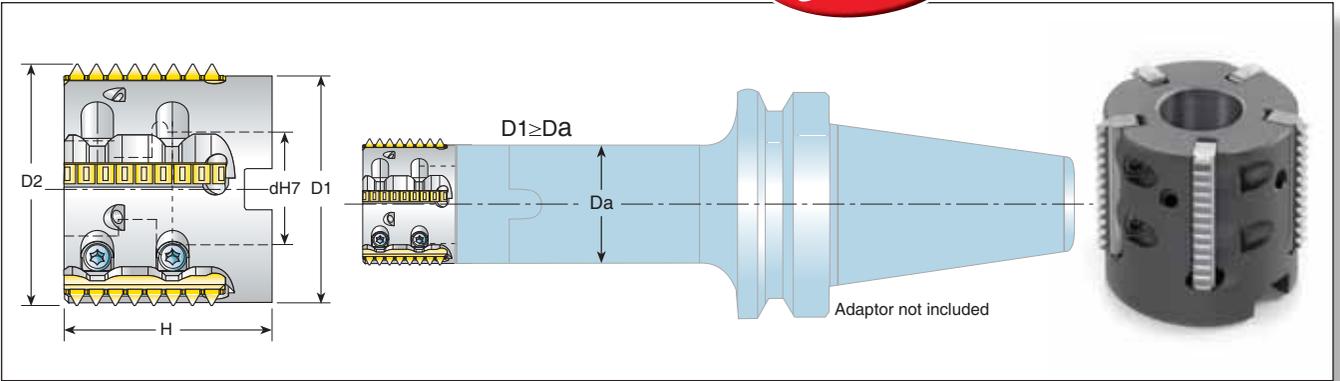
NEW!
Shell Mill





MiTM Shell Mill

NEW!
Shell Mill



Conical and Standard Shell Mills

NEW!
Shell Mill

Insert Length	Ordering Code	Dimensions (mm)				No. of Flutes		 **	
		mm	D1	D2	dH7				
Standard	25	RTMC-D36-16-25S5	32	36	16	33.5	SLD4IP8 (M4x0.7)	KIP8	M8x30
	25	RTMC-D44-22-25S6	40	44	22	38			M10x35
	25	RTMC-D52-27-25S8	48	52	27	40			M12x30
Conical	25	RTMNC-D36-16-25S5	32	36	16	33.5			M8x30

*All holders with Coolant-Thru
** Use Torx+ Screwdriver only

Standard Thread Applications per Toolholder

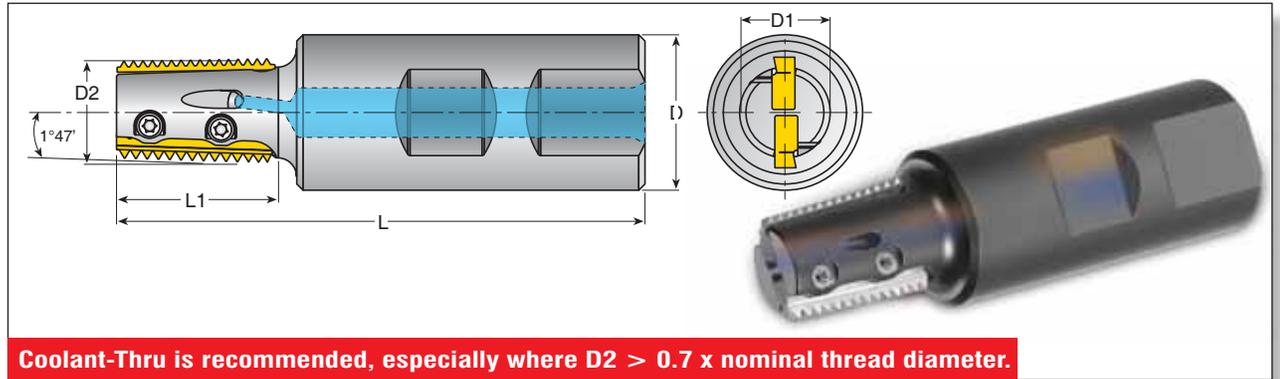
Toolholder		Min. Thread Ø				
		D2 (mm)	ISO (fine)	UN/UNF/UNEF/UNS	BSP(G)	BSW
Standard	RTMC-D36-16-25S5	36	38x1 ; 39x1.5 ; 39x2 ; 40x3	19/16 - 12UN ; 1 5/8 - 14UNS ; 19/16 - 16UN ; 1 1/2 - 18UNEF ; 1 1/2 - 20UN	1 1/4 - 11	1 3/4 - 16 1 3/4 - 12
	RTMC-D44-22-25S6	44	48x1 ; 48x1.5 ; 48x2 ; 48x3	17/8 - 12UN ; 1 13/16 - 16UN ; 1 13/16 - 20UN ; 1 15/16 - 8UN ; 17/8 - 10UNS ; 17/8 - 14UNS	1 1/2 - 11	2 - 16 2 - 12
	RTMC-D52-27-25S8	52	55x1 ; 55x1.5 ; 55x2 ; 56x3	2 1/4 - 18UN ; 2 1/4 - 20UN ; 2 1/4 - 8UN ; 2 1/4 - 12UN ; 2 1/4 - 10UN ; 2 1/4 - 14UN ; 2 1/4 - 16UN	2 - 11	2 1/4 - 16 2 1/4 - 12

Conical Thread Applications per Toolholder

Toolholder		Thread Ø			
		D2 (mm)	NPT	NPTF	BSPT
Conical	RTMNC-D36-16-25S5	36	1 1/4 - 11.5 ; 1 1/2 - 11.5 ; 2 - 11.5	1 1/4 - 11.5 ; 1 1/2 - 11.5 ; 2 - 11.5	1 1/2 - 6x11



Conical Toolholders



Coolant-Thru is recommended, especially where $D2 > 0.7 \times$ nominal thread diameter.

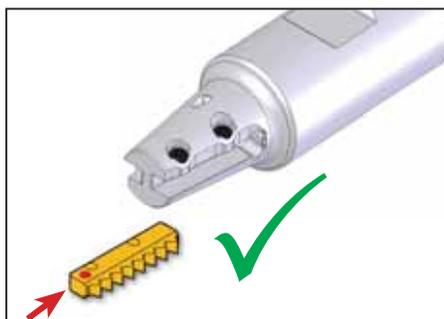
RTMNC - for Conical Threads

Insert Length	Ordering Code	Dimensions (mm)					No. of Flutes		
mm		L	L1	D	D1	D2	Z	Screw	Torx+ Screwdriver
25	RTMNC 2517-26S2	85	26	25	14	17	2	SLD4IP8 (M4 x 0.7)	KIP8
	RTMNC 2522-43S3	102	43	25	18	22	3		
	RTMNC 2528-43S4	103	43	25	26	28	4		

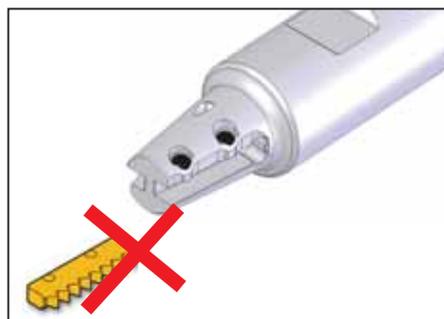
* Use Torx+ screwdriver only

Thread Application per Toolholder

Toolholder	D2(mm)	Thread Ø		
		NPT	NPTF	BSPT
RTMNC 2517-26S2	17	1/2 - 14; 3/4 - 14; 1 - 11.5; 1 1/4 - 11.5; 1 1/2 - 11.5; 2 - 11.5	1/2 - 14; 3/4 - 14; 1 - 11.5; 1 1/4 - 11.5; 1 1/2 - 11.5; 2 - 11.5	1/2 - 14; 3/4 - 14; 1 - 11; 1 1/4 - 11; 1 1/2 - 11; 2 - 11
RTMNC 2522-43S3	22	3/4 - 14; 1 - 11.5; 1 1/4 - 11.5; 1 1/2 - 11.5; 2 - 11.5	3/4 - 14; 1 - 11.5; 1 1/4 - 11.5; 1 1/2 - 11.5; 2 - 11.5	3/4 - 14; 1 - 11; 1 1/4 - 11; 1 1/2 - 11; 2 - 11; 2 1/2 - 11; 3 - 11; 4 - 11; 5 - 11; 6 - 11
RTMNC 2528-43S4	28	1 - 11.5; 1 1/4 - 11.5; 1 1/2 - 11.5; 2 - 11.5	1 - 11.5; 1 1/4 - 11.5; 1 1/2 - 11.5; 2 - 11.5	1 - 11; 1 1/4 - 11; 1 1/2 - 11; 2 - 11; 2 1/2 - 11; 3 - 11; 4 - 11; 5 - 11; 6 - 11

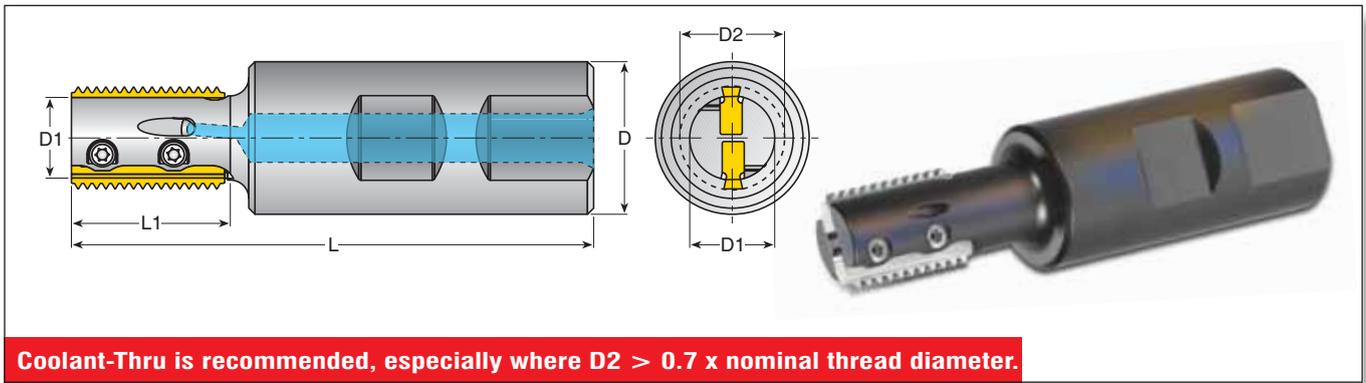


On conical inserts, the identification mark must be face up



Side without identification marks

Standard Toolholders



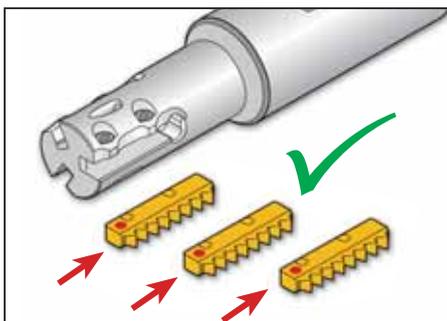
RTMC - for Standard Threads

Insert Length	Ordering Code	Dimensions (mm)			No. of Flutes				
mm		L	L1	D	D1	D2	Z	Screw	Torx+ Screwdriver
25	RTMC 2517-26S2	85	26	25	14	17	2	SLD4IP8 (M4 x 0.7)	KIP8
	RTMC 2517-36S2	95	36		14	17	2		
	RTMC 2520-37S3	96	37		16.7	20.5	3		
	RTMC 2520-44S3	103	44		16.7	20.5	3		
	RTMC 2522-43S3	102	43		18	22	3		
	RTMC 2522-55S3	114	55		18	22	3		
	RTMC 2530-55S5	115	55		26	30	5		
	BRTMC 2530-80S4	140	80		26	30	4		

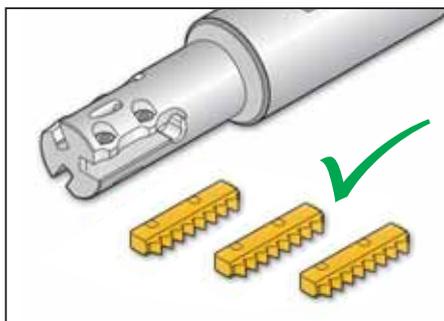
* Use Torx+ screwdriver only

Thread Application per Toolholder

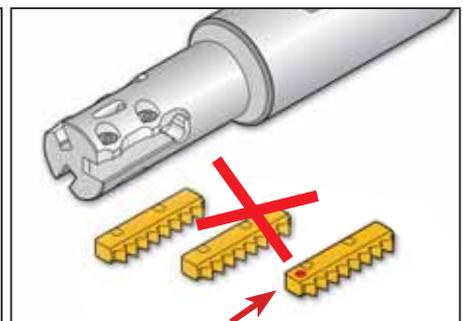
Toolholder	Min. Thread Ø						
	D2 (mm)	ISO (coarse)	ISO (fine)	UNC	UN/UNF/UNEF/UNS	BSF	BSP(G)
RTMC 2517-26S2 RTMC 2517-36S2	17	M20x2.5	M19x1; M19x1.5; M20x2	-	7/8 - 10UNS ; 13/16-12UN ; 7/8 - 14UNF; 3/4 - 16UNF ; 3/4 - 18UNS ; 3/4 - 20UNEF	7/8 - 11; 7/8 - 12; 7/8 - 14; 7/8 - 16	1/2 - 14
RTMC 2520-37S3 RTMC 2520-44S3	20.5	M24x3	M22x1; M23x1.5; M23x2; M23.5x2.5	1-8	15/16 - 9UN ; 1 - 10UNS ; 15/16 - 12UN ; 1 - 14UNS ; 15/16 - 16UN ; 7/8 - 18UNS ; 7/8 - 20UNEF	1 - 11; 1 - 12; 1 - 14; 1 - 16	5/8 - 14
RTMC 2522-43S3 RTMC 2522-55S3	22	M27x3	M24x1; M24x1.5; M25x2; M25x2.5	-	11/16 - 8UN ; 1 - 9UN ; 1 - 10UNS ; 1 - 12UNF ; 1 - 14UNS ; 1 - 16UN ; 1 - 18UN ; 15/16 - 20UNEF	1 - 11; 1 - 12; 1 - 14; 1 - 16	3/4 - 14
RTMC 2530-55S5 BRTMC 2530-80S4	30	-	M32x1; M32x1.5; M33x2; M33x2.5; M34x3	-	13/8 - 8UN ; 13/8 - 9UN ; 13/8 - 10UN ; 15/16 - 12UN ; 13/8 - 14UNS ; 15/16 - 16UN ; 15/16 - 18UNEF ; 15/16 - 20UN	13/8 - 11; 13/8 - 12; 13/8 - 14; 13/8 - 16	1 - 11



Side with identification marks

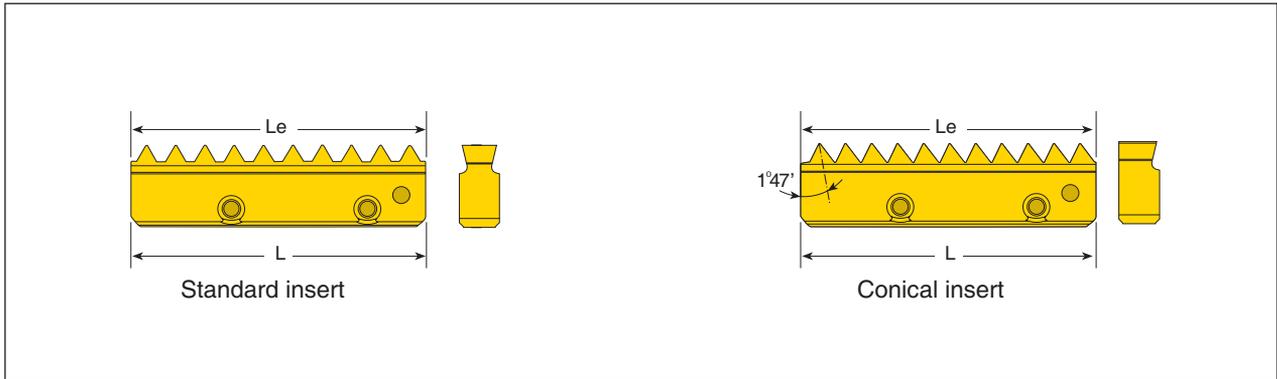


Side without identification marks



Always mount all inserts on the same side!

MiTM Inserts



R25 Inserts

		L	Pitch	Ordering Code	Teeth	Toolholder		
		mm	mm	tpi	Le	Zt		
 <p>Standard insert</p>	ISO	25	1.00	-	R25I1.00ISOTM...	24.0	24	
			1.50	-	R25I1.50ISOTM...	24.0	16	
			2.00	-	R25I2.00ISOTM...	24.0	12	
			2.50	-	R25I2.50ISOTM...	25.0	10	
			3.00	-	*R25I3.00ISOTM...	24.0	8	*See note below
	UN	25	-	20	R25I20UNTM...	24.13	19	
			-	18	R25I18UNTM...	23.99	17	
			-	16	R25I16UNTM...	23.81	15	
			-	14	R25I14UNTM...	23.58	13	
			-	12	R25I12UNTM...	23.28	11	
			-	10	R25I10UNTM...	22.86	9	
	W	25	-	9	*R25I9UNTM...	22.58	8	*See note below
			-	8	*R25I8UNTM...	22.22	7	
			-	16	R25EI16WTM...	23.81	15	
			-	14	R25EI14WTM...	23.58	13	
			-	12	R25EI12WTM...	23.28	11	
	EXTERNAL + INTERNAL	NPT	25	-	14	R25EI14NPTTM...	19.96	11
				-	11.5	R25EI11.5NPTTM...	24.3	11
-				14	R25EI14NPTFTM...	19.96	11	
-				11.5	R25EI11.5NPTFTM...	24.3	11	
 <p>Conical insert Conical inserts have one cutting edge</p>	BSPT	25	-	14	R25EI14BSPTTM...	19.96	11	
			-	11	R25EI11BSPTTM...	23.09	10	

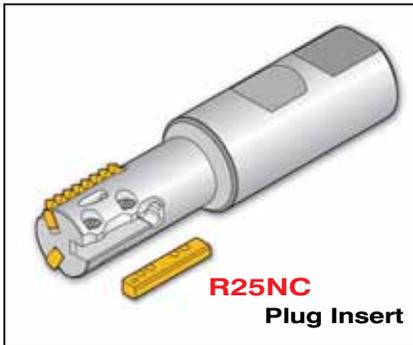
* Note: 3.00 ISO, 8 UN & 9 UN inserts do not fit into toolholder RTMC2517....

R25NC Plug Insert

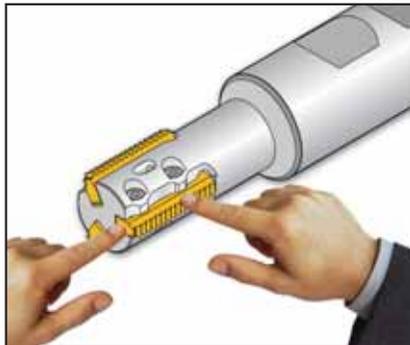
	L	Ordering Code	Teeth	Toolholder
	mm		Zt	
	25	R25NC	No Teeth	(B)RTMC... RTMNC... All Types

* For unused toolholder pockets

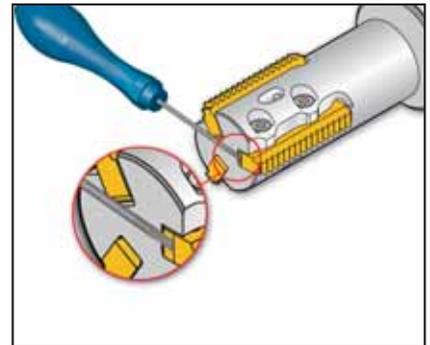
User Guide



If you do not fill all toolholder pockets with MITM inserts, make sure to use Plug Inserts (R25NC) instead. This keeps the toolholder stable and prevents chips from packing in empty pockets.



To mount insert correctly, push the insert toward the pocket walls.



For convenience, use the screwdriver to remove inserts.

Recommended Cutting Speeds and Feed

Selected Material			Hardness Brinell HB	Vc [m/min]		Feed f [mm/ tooth]
				VBX	VTX	(Peripheral Feed)
P	Unalloyed steel	(C=0.25-0.55 %)	150	100-180	90-170	0.05-0.25
	Low alloy steel	Non hardened	180	90-160	90-155	0.05-0.25
M	Stainless steel Austenitic	Austenitic	180	70-140	100-140	0.05-0.15
K	Aluminium alloys Wrought	Non aging	60	100-250	-	0.1-0.4

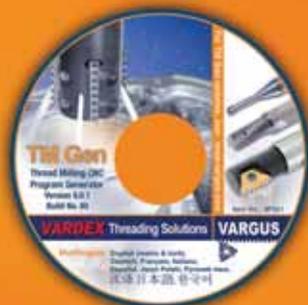
* Cutting data for additional materials is available on VARDEX TM Gen software.

Grades

Grade	Application
VBX	TiCN coated carbide grade. Excellent grade for steels and general use.
VTX	TiAlN coated carbide grade. Ideal for Stainless Steels.



Ask for the **VARDEX**
General Catalog



VARGUS TM Gen
for Tool Selection
and CNC programming

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VARDEX

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