

NEW!

MiTM

VARGUS 



Multi-Flute Indexable Thread Milling Line

MiTM Advantages:

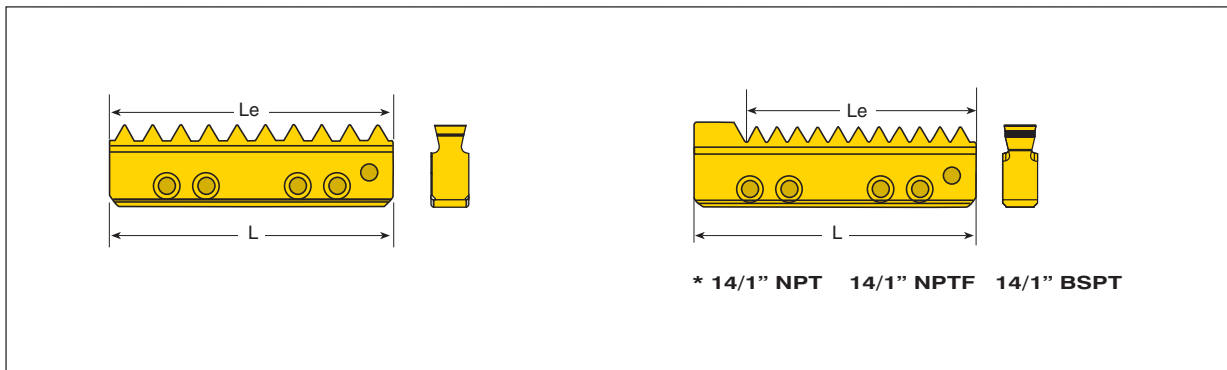
- Multiple flutes for high feed rate
- Two cutting edges on each insert
- Tool diameter as small as 17 mm
- Long inserts
- Excellent stability
- Holder can be used with single insert or multiple inserts



Metric

VARDEX Threading Solutions

MiTM Inserts



R25 Inserts

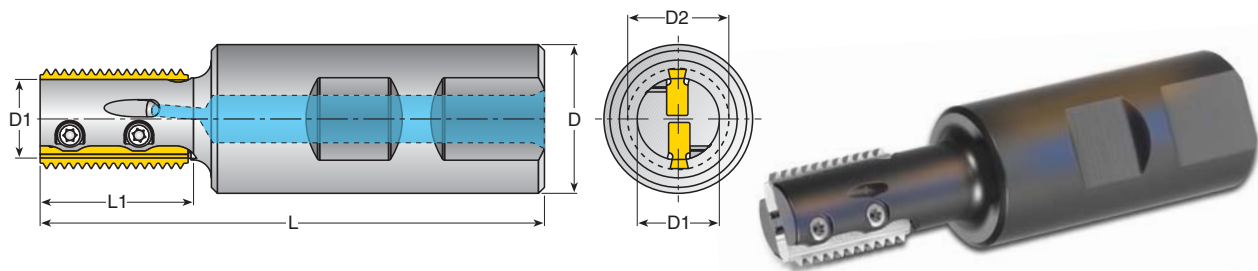
	L		Pitch	Ordering Code	Teeth	Toolholder		
	mm	mm	tpi		Le	Zt		
INTERNAL 	ISO	25	1.00	-	R25I1.00ISOTM...	24.0	24	(B)RTMC.... All Types **See note below
			1.50	-	R25I1.50ISOTM...	24.0	16	
			2.00	-	R25I2.00ISOTM...	24.0	12	
			2.50	-	R25I2.50ISOTM...	25.0	10	
			3.00	-	**R25I3.00ISOTM...	24.0	8	
	UN	25	-	20	R25I20UNTM...	24.13	19	(B)RTMC.... All Types **See note below
			-	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	
			-	9	**R25I9UNTM...	22.58	8	
			-	8	**R25I8UNTM...	22.22	7	
	W	25	-	16	R25EI16WTM...	23.81	15	(B)RTMC.... All Types
			-	14	R25EI14WTM...	23.58	13	
			-	12	R25EI12WTM...	23.28	11	
			-	11	R25EI11WTM...	23.09	10	
EXTERNAL + INTERNAL 	NPT	25	-	14	*R25EI14NPTTM...	19.96	11	RTMNC.... All Types
			-	11.5	R25EI11.5NPTTM...	24.3	11	
	NPTF	25	-	14	*R25EI14NPTFTM...	19.96	11	
			-	11.5	R25EI11.5NPTFTM...	24.3	11	
	BSPT	25	-	14	*R25EI14BSPTTM...	19.96	11	
-			11	R25EI11BSPTTM...	23.09	10		

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

R25NC Plug Insert

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

Standard Toolholders



Coolant-Thru is recommended, especially where $D2 > 0.7 \times \text{nominal thread } \varnothing$.

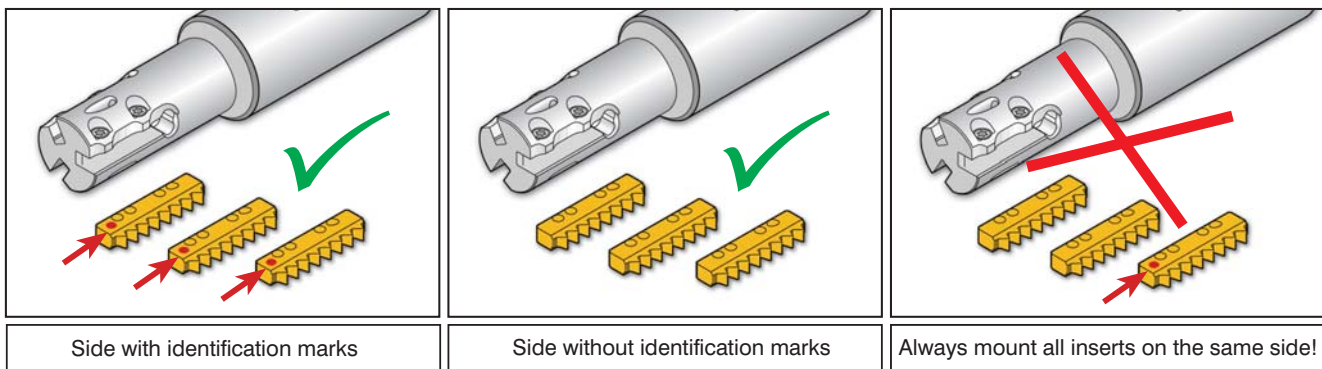
RTMC - for Standard Threads

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

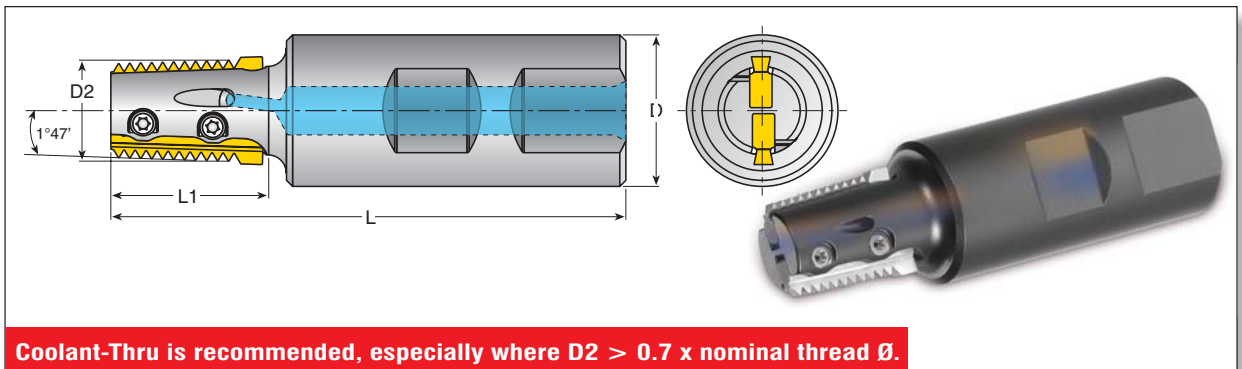
Thread Application per Toolholder

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





Conical Toolholders



Coolant-Thru is recommended, especially where $D2 > 0.7 \times \text{nominal thread } \varnothing$.

RTMNC - for Conical Threads

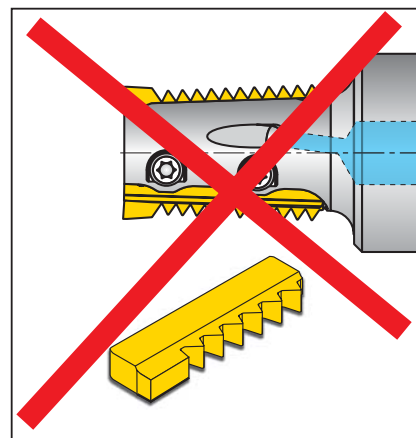
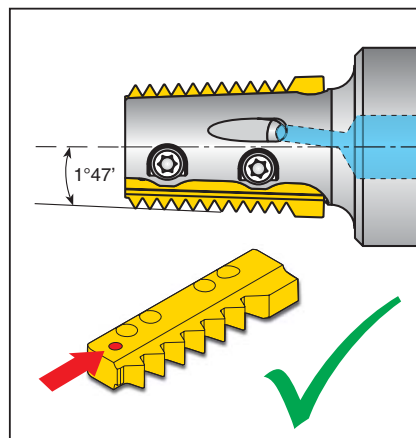
Insert Length	Ordering Code	Dimensions [mm]							
mm		L	L1	D	D1	D2	Z	Screw	Torx+ Screwdriver
25	RTMNC 2517-26S2	85	26	25	14	17	2	SLD4IP8 (M4 x 0.7)	KIP8
	RTMNC 2522-43S3	102	43	25	18	22	3		
	RTMNC 2528-43S4	103	43	25	26	28	4		

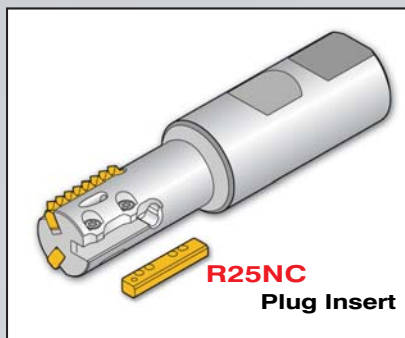
Use **Torx+** screwdriver only

Thread Application per Toolholder

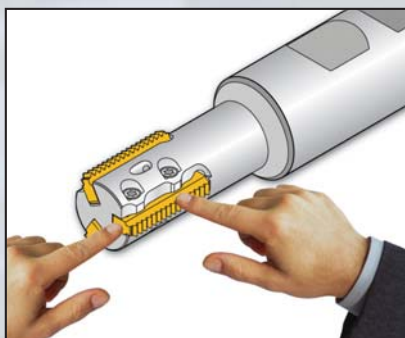
Toolholder		Thread $\varnothing$		
	D2[mm]	NPT	NPTF	BSPT
RTMNC 2517-26S2	17.1	1/2-14; 3/4-14; 1-11.5; 2-11.5	1/2-14; 3/4-14; 1-11.5; 2-11.5	1/2-14; 3/4-14; 1-11; 1 1/4-11; 1 1/2-11; 2-11
RTMNC 2522-43S3	22	3/4-14; 1-11.5; 2-11.5	3/4-14; 1-11.5; 2-11.5	3/4-14; 1-11; 1 1/4-11; 1 1/2-11; 2-11; 2 1/2-11; 3-11; 4-11; 5-11; 6-11
RTMNC 2528-43S4	28	1-11.5; 2-11.5	1-11.5; 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 face up.

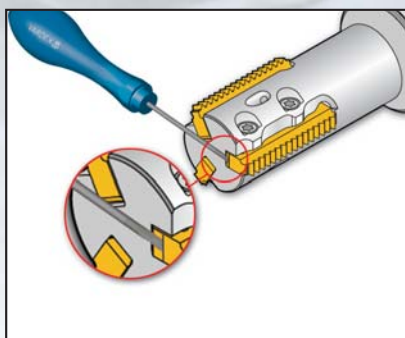




If you do not fill all toolholder pockets with MITM inserts, make sure to use Plug Inserts (R25NC) instead. This keeps the toolholder stable and prevents chips from packing in empty pockets.



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] (Peripheral Feed)
				VBX	VTX	
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

Grades

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

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

Ask for the **VARDEX** General Catalog



VARGUS TM Gen CD
for Tool Selection
and CNC programming



VARDEX

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