

FMT Fast MT

- Carmex has designed a unique line of solid carbide thread milling tools FMT for increased productivity and high performance.
- Large number of flutes enables to achieve significant shorter machining time.

FMT vs. Taps

Features	FMT	Taps
Thread up to bottom at blind hole	Possible	Not possible
Machining load	Very low	High
Thread surface quality	High	Medium
Process reliability	Very reliable, especially for expensive work pieces	Medium
Thread geometry	Very accurate	Medium
Cycle time	Same or faster than tap	Fast

MT8 Sub Micron grade with advanced PVD triple coating (ISO K10-K20). Extremely high heat resistant and smooth cutting operation, for high performance and normal machining conditions. General purpose for all materials.

Test Report

Application

Internal right hand thread: M6x1.0
 Thread length: 10 mm, Blind hole
 Bore size: Ø 5 mm
 Chamfer: 0.9 mm

Work piece material

Steel SAE 4340

Cutter description

FMT08048F10 1.0 ISO- with internal coolant
 Shank diameter: Ø8 mm
 Cutting diameter: Ø4.8 mm
 Number of flutes: 6
 Cutting length: 10.5 mm
 Total length: 64 mm

Cutting conditions

Cutting speed: 130 m/min Feed: 0.016 mm/tooth

Machine

Mori Seiki NV5000 Coolant: emulsion 5%

Results

Tool life : 2,170 threads
 Cycle time: 1.5 sec