



VARDEX MULTI-FLUTE THREAD MILL CUTS

TOOL COSTS ON LONG THREADS

The use of long inserts and multiple flute holders on the VARDEX Multi-flute Indexable Thread Mills (MiTM) from VARGUS promises unparalleled reductions in cycle times for the generation of medium and large threads.

With VARDEX MiTM – the ‘super fast thread milling system’ - multiple flute holders allow significant increases in feed rates. And the use of longer-than-usual inserts (25mm and 40mm) enables a reduction in the number of machining passes, especially when producing long threads.

The range now also includes the additional tools MiTM 24, for small bores from M14.5x0.5, and MiTM 41 for large pitches up to ISO 6.0mm.

With MiTM, the effective increase in the number of available cutter edges not only reduces cycle times but also leads to overall reductions in tool costs and improvements in finish machined product quality.

With holders having cutting diameters from 13.6mm to 58mm and with one to eight flutes, MiTM coated inserts are ideal for cost-effective thread generation on stainless steel as well as for general machining applications.

The inserts are supplied with varying numbers of teeth in a variety of pitches and are offered in a range of threading standards. Conical and Shell Mill holder styles are available to suit the thread and pitch size required.

In one application, the switch from conventional tapping to MiTM by a supplier to the global marine industry has made the creation of a series of threads in propeller housings into a consistently accurate and more profitable process.

The housings, which are machined from 42CrMo4 900 N/mm² steel, require a number of M20 threads, at a 2.5mm pitch and 35mm deep on both main housing faces. Formerly produced by tapping, the sequence used to be plagued by accuracy problems on workpiece material that is notoriously inconsistent. Indeed, every operation had to be checked and each thread frequently corrected.

Today, however, using the MiTM tooling with VBX carbide inserts, each thread is produced in a total of 3 mins 24 secs, representing the two axial passes and the single super finish pass now applied – at climb and conventional approach routes, respectively - at a cutting speed of 135 m/min on the AXA VHC50 machining centre.

In fact, the happy customer reports that more than 150 threads are being produced without the need for tool compensation – a situation far removed from tradition, it says.

MiTM is one of a number of world-leading VARDEX threading solutions from VARGUS, the renowned manufacturer and supplier of quality tooling for threading, turning, milling and grooving applications, as well as hand deburring tools.

Issued on behalf of Vargus Ltd.

Visit us at www.vargus.com or contact us with any of your questions and comments.

David Wolfe, Vice President Sales & Marketing, davidw@vargus.com

Annie Reuveni, Marketing Communications Manager, annier@vargus.com

General Inquiries: mrktg@vargus.com