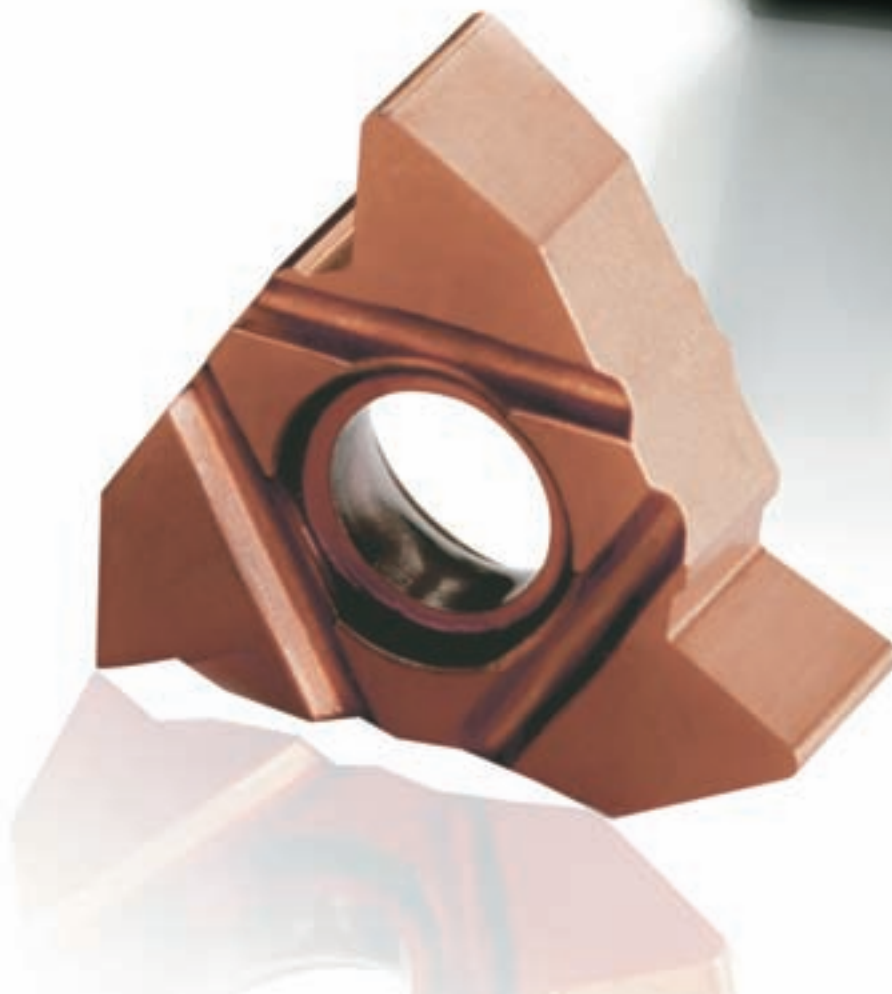


CoroThread™ 266

New ultra-rigid threading tool



Threading stability for oil and gas industries

CoroThread 266 is a group of ultra-rigid threading tools for the oil, gas and mechanical engineering sectors, where high precision threading is essential. Stable threading tools and a cutting edge which remains rigid under the forces of threading, are vital for this precision.

The new threading technology gives the insert ultra-high stability and limits insert movement in the holder pocket. Prevention of insert movement is achieved with an ultra-stable iLock interface between insert-shim and tool holder pocket.

The insert has three slots, one per edge. One slot is located on the new interface, the rail guide on the shim.

The rigidity gives an accurate threading profile, better surface finish, product consistency and assured repeatable and high precision indexing. E-tolerance is ± 0.0004 inch axial and ± 0.002 inch radial. M-tolerance is ± 0.002 inch in radial and axial.



Ultra-stable threading tool

Less product waste

Rigid insert, impossible to misload

Excellent surface finish

Increased tool life

Accurate refit in interrupted thread cycles

Precise, repeatable indexing

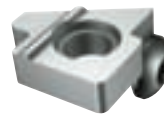
Location of insert slot on shim guide rail



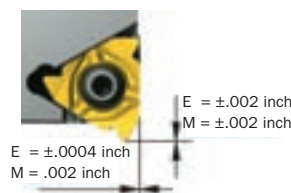
The CoroThread 266 ultra-rigid threading tool with insert and shim with rigid rail interface.



Insert design showing slots.



Shim with guide rail.



E- and M- tolerance.

Higher productivity, ultra-rigid threading

CoroThread 266 is the new way for the oil, gas and mechanical engineering sectors to improve productivity and product accuracy.

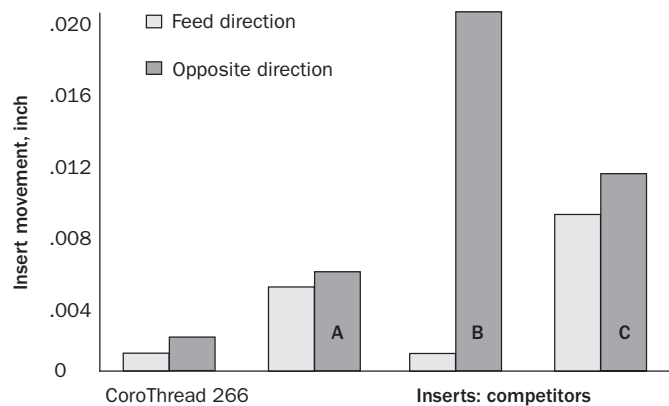
Tests confirm that insert movement with the rigid rail interface is close to zero. Tool life with the new grade is so good, it can double product output. Surface finish with the high-precision cutting edges is excellent.



Stable, permanently rigid threading

Laboratory test

CoroThread 266 insert movement compared with competitors.



Excellent surface finish

Field test - component to be threaded

Material: CMC 02.1/0.2.2
 Cutting speed: 370 ft/min
 No. of passes: 14
 Length of cut: 4.41 inch
 Thread: 4 t.p.i. with taper 4.76°
 Median diameter: 4.7 inch
 Length: 4.41 inch
 In-feed: radial



Results - surface finish and tool life

	Existing tool	Ultra-rigid CoroThread 266
Profile:	V0.038 - 0402	V0.038 - 0402
Grade:	P25	GC1020
Tool life:	6 pcs	27 pcs
Criteria for tool change:	Poor surface finish.	End of production batch, still excellent surface finish.

New grades double tool life

Laboratory test - insert tool life

Material: SS2541
 Cutting speed: 410 ft/min
 No. of passes: 12
 Length of cut: 3.1 inch
 Thread: 4 t.p.i. with taper 4.76°
 Diameter of workpiece: 5.5 inch

Insert **R166.0G-22V381-0402**

Grade: GC4125
 Tool life: 33 pcs
 Comment: After 33 pcs
 - component thread had vibration marks.

Insert **266RG-22V381A0402E**

Grade: New GC1125
 Tool life: 66 pcs
 Comment: After 66 pcs
 - component thread still maintains excellent surface finish.



Strength and stillness at the cutting edge

This new threading tool is designed to improve accuracy and reduce the waste of threaded products for oil, gas and mechanical engineering. First to be launched is the CoroThread 266 for 1/2 inch (22 mm) and 5/8 inch (27 mm) inserts. This remarkable tool makes these productivity gains with an ultra-stable iLock interface between insert and tool holder pocket.

On the shim, a convex stability guide rail provides a firm seat for a slot on the underside of the triple edge insert. When brought together and screwed in, this combination, along with the strength of the new Sandvik Coromant GC1125 grade, the first choice in steel applications, provides rigidity and stillness at the working heart of the insert, the cutting edge. GC1020 is the all-purpose grade. The result is a steady, accurate edge as it engages with the work piece, pass after pass, piece after piece. This gives a smooth surface finish.

This is the strength and stillness of certainty, the knowledge that cutting is where cutting is intended.

Productivity gains

Insert - rigid and stable under cutting forces

Assured, precise indexing every time

Insert - impossible to misload, saves time

High product consistency

Excellent surface finish

Longer tool life



For more information, call 1-800-SANDVIK (1-800-726-3845) or visit www.coromant.sandvik.com/us
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Your success in focus