

Spiral Mill-Thread Inserts (H..)



MATERIAL GROUP	MATERIAL TO BE MACHINED	CUTTING SPEED m/min MT7
P	Low and Medium Carbon Steels	145 - 360
	High Carbon Steels	165 - 255
	Alloy Steels, Treated Steels	135 - 230
M	Stainless Steels	165 - 245
	Cast Steels	190 - 245
K	Cast Iron	100 - 220
N	Aluminium & Non Ferrous	230 - 440
	Symthetics, Duroplastics, Thermoplastics	145 - 590
S	Nickel Alloys and Tianium Alloys	30 - 115

Key	
Vc	Cutting speed (m/min)
n	RPM (rev/min)
Fz	Feed rate (mm/tooth)
f	Feed rate (mm/rev)
HRc	Hardness of metal

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

Recommended FEED RATE: 0.05 - 0.15 mm

As you may note, cutting speed is shown in range terms. In most standard cases, choosing a speed in the middle of the range would be a good choice for a start.

For hard metals reduce cutting speed.