

Mill-Thread Inserts (ISO,UNNPT..)



MATERIAL GROUP	MATERIAL TO BE MACHINED	Cutting Speed m/min MT7
P	Low and Medium Carbon Steels <0.55%C	115 - 280
	High Carbon Steels ≥0.55%C	130 - 200
	Alloy Steels, Treated Steels	105 - 180
M	Stainless Steels	130 - 190
	Cast Steels	150 - 190
K	Cast Iron	80 - 70
N	Aluminium & Non Ferrous	180 - 340
	Symthetics, Duroplastics, Thermoplastics	115 - 460
S	Nickel Alloys and Tianium Alloys	25 - 90

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.