

Solid Carbide Thread Mills For Aluminium (AMT)



MATERIAL GROUP	MATERIAL TO BE MACHINED	Cutting Speed m/min	Feed mm/tooth Cutting Diameter = D		
			D ≤ 4	4 ≤ D ≤ 9	D ≥ 9
P	Low and Medium Carbon Steels <0.55%C	50 - 140	0.005 - 0.03	0.01 - 0.05	0.02 - 0.10
	High Carbon Steels ≥0.55%C	60 - 130	0.005 - 0.02	0.01 - 0.04	0.02 - 0.09
	Alloy Steels, Treated Steels				
M	Stainless Steels - Free Cutting	40 - 120	0.005 - 0.02	0.01 - 0.04	0.02 - 0.09
	Stainless Steels - Austenitic				
	Cast Steels	70 - 120	0.005 - 0.03	0.01 - 0.05	0.02 - 0.10
K	Cast Iron	50 - 120	0.005 - 0.03	0.01 - 0.05	0.02 - 0.10
N	Aluminium ≤12%Si, Copper	130 - 250	0.005 - 0.04	0.01 - 0.06	0.02 - 0.13
	Alluminium > 12% Si	80 - 180	0.005 - 0.04	0.01 - 0.06	0.02 - 0.13
	Symthetics, Duroplastics, Thermoplastics	80 - 180	0.005 - 0.04	0.01 - 0.06	0.02 - 0.13
S	Nickel Alloys and Tianium Alloys	20 - 80	0.005 - 0.02	0.01 - 0.04	0.02 - 0.09

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.