Multi Function Thread Mills (DMTH)

MATERIAL GROUP	MATERIAL TO BE MACHINED	Cutting Speed m/min	Feed mm/tooth								
			Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø9	Ø10	Ø12
P	Low and Medium Carbon Steels <0.55%C	60 - 120	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.05	0.05
	High Carbon Steels ≥0.55%C	60 - 90	0.02	0.02	0.02	0.03	0.03	0.04	0.04	0.04	0.05
	Alloy Steels, Treated Steels	50 - 80	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.04
M	Stainless Steels - Free Cutting	70 - 100	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.03
	Stainless Steels - Austenitic	60 - 90	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.04
	Cast Steels	70 - 90	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.04
K	Cast Iron	40 - 80	0.03	0.03	0.03	0.03	0.04	0.05	0.05	0.05	0.05
N	Aluminium ≤12%Si, Copper	100 - 200	0.03	0.03	0.03	0.03	0.04	0.05	0.05	0.05	0.05
	Alluminium > 12% Si	60 - 140	0.02	0.02	0.02	0.02	0.02	0.02	0.03	0.03	0.03
	Symthetics, Duroplastics, Thermoplastics	50 - 200	0.04	0.05	0.05	0.05	0.05	0.06	0.06	0.06	0.06
S	Nickel Alloys and Tianium Alloys	20 - 40	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.06	0.06

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.