Mill-Thread Solid Carbide (MT- ISO, UNC,UNF)

MATERIAL GROUP	MATERIAL TO BE MACHINED	Cutting Speed m/min		Feed mm/r Cutting Diameter =D			Feed mm/tooth Cutting Diameter = D		
				Drilling			Mill Thread		
		K20	MT7	D≤4	4≤D≤6	D≥6	D≤4	4≤D≤6	D≥6
K	Cast Iron	50 - 80	80 - 120	0.10 - 0.15	0.15 - 0.20	0.15 - 0.30	0.005 - 0.03	0.01 - 0.05	0.02 - 0.10
N	Aluminium ≤12%Si, Copper	100 - 250	100 - 350	0.06 - 0.10	0.10 - 0.20	0.20 - 0.30	0.005 - 0.004	0.01 - 0.06	0.02 - 0.13
	Aluminium ≤12%Si,	–	80 - 180	0.05 - 0.07	0.10 - 0.15	0.15 - 0.25	0.005 - 0.04	0.01 - 0.06	0.02 - 0.13
	Synthetics, Duroplastics, Thermoplastics	60 - 100	80 - 180	0.10 - 0.20	0.20 - 0.30	0.20 - 0.30	0.005 - 0.04	0.01 - 0.06	0.02 - 0.13

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.