

MINI MILL THREAD MILL(MTH)



MATERIAL GROUP	MATERIAL TO BE MACHINED	Hardness HRC	Cutting Speed m/min	FEED mm/tooth								
				Cutting Diameter = D								
				Ø2.5	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10
S	Nickel Alloys and Titanium Alloys		20 - 40	0.02	0.02	0.02	0.02	0.03	0.03	0.03	0.03	0.04
H	Hardened Steel, Cast Iron	45 - 50	60 - 70	0.02	0.03	0.03	0.04	0.04	0.05	0.05	0.06	0.07
		51 - 55	50 - 60	0.01	0.02	0.02	0.03	0.03	0.04	0.04	0.05	0.06
		56 - 62	40 - 50	0.005	0.01	0.01	0.02	0.02	0.03	0.03	0.04	0.05

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.