

Mini Mill-Thread (MTSB)



MATERIAL GROUP	MATERIAL TO BE MACHINED	Cutting Speed m/min	Feed mm/tooth					
			Cutting Diameter = D					
			Ø1	Ø1.5	Ø2	Ø3	Ø4	Ø5
P	Low and Medium Carbon Steels <0.55%C	60 - 120	0.04	0.05	0.05	0.07	0.09	0.11
	High Carbon Steels ≥0.55%C	60 - 90	0.03	0.04	0.05	0.06	0.08	0.09
	Alloy Steels, Treated Steels	50 - 80	0.03	0.04	0.04	0.05	0.05	0.06
M	Stainless Steels - Free Cutting	70 - 100	0.02	0.03	0.03	0.04	0.05	0.06
	Stainless Steels - Austenitic	60 - 90	0.02	0.03	0.03	0.04	0.05	0.06
	Cast Steels	70 - 90	0.03	0.04	0.04	0.05	0.05	0.06
K	Cast Iron	40 - 80	0.04	0.05	0.05	0.07	0.09	0.11
N	Aluminium ≤12%Si, Copper	100 - 200	0.04	0.05	0.05	0.07	0.09	0.11
	Alluminium > 12% Si	60 - 140	0.03	0.03	0.03	0.04	0.05	0.06
	Symthetics, Duroplastics, Thermoplastics	50 - 200	0.09	0.1	0.11	0.12	0.14	0.16
S	Nickel Alloys and Tianium Alloys	20 - 40	0.03	0.03	0.03	0.04	0.04	0.05
H	Hardened Steel, 45-50HRc	60 - 70	0.03	0.04	0.04	0.05	0.05	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.