












Recommendations for Thread Milling Cutters

Material Group		Hardness		SFM	Feed Rate		Inch per tooth					Recommended Finish
		Rc	Brn		#10	1/4	3/8	1/2	5/8	3/4	1	
	Structural Steels	-	<180	400	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	TiCN
	Free cutting steels	-	<180	400	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	Unalloyed case hardened materials	<20	<230	325	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	Unalloyed heat-treatable steels	<25	<250	260	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	Alloyed case hardened steels	<25	<250	260	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	TiCN
	Alloyed heat-treatable steels	<30	<280	230	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	
	Alloyed tool steels	<35	<320	200	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	
	High speed tool steels	<38	<380	180	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	
	Stainless		<180	250	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	TiCN
		<25	<250	200	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
		<30	<280	230	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	Structural Steels	<20	<230	330	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	TiCN
	Case hardened steels	<25	<250	300	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	Heat-treatable steels	<25	<250	280	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	Nitriding steels	<30	<280	260	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	Al wrought alloys	-	30-80	750	0.002	0.004	0.005	0.006	0.007	0.007	0.008	Bright
		-	75-150	500	0.002	0.004	0.005	0.006	0.007	0.007	0.008	
	Al cast alloys	-	n/a	600	0.002	0.004	0.005	0.006	0.007	0.007	0.008	TiCN
		-	n/a	450	0.002	0.004	0.005	0.006	0.007	0.007	0.008	
	Cast iron	-	<180	400	0.002	0.003	0.0035	0.0045	0.005	0.005	0.006	TiCN
		<25	<250	320	0.002	0.003	0.0035	0.0045	0.005	0.005	0.006	
		<35	<320	300	0.002	0.003	0.0035	0.0045	0.005	0.005	0.006	
	Brass,	-	<180	600	0.002	0.004	0.005	0.007	0.008	0.008	0.01	Bright
		-	<180	600	0.002	0.004	0.005	0.006	0.007	0.007	0.008	
	Plastics, Carbon/glass reinforced	-		500	0.002	0.004	0.005	0.007	0.008	0.008	0.01	TiCN
	Magnesium-alloys	-		750	0.002	0.004	0.005	0.007	0.008	0.008	0.01	Bright
	Titanium and Ti-alloys	-	140-300	140	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	TiCN
		-	300-380	110	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	
	Ni-alloys	-	<300	125	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	TiCN
		-	>300	100	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	