

Mill-Thread Inserts Speed and Feed Selection

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed ft/min MT7
P	Low and Medium Carbon Steels	380 - 920
	High Carbon Steels	430 - 660
	Alloy Steels, Treated Steels	340 - 590
M	Stainless Steels	430 - 620
	Cast Steels	490 - 620
K	Cast Iron	260 - 560
N	Non-Ferrous & Aluminum	590 - 1120
	Synthetics, Duroplastics, Thermoplastics	380 - 1500
S	Nickel Alloys, Titanium Alloys	80 - 300

Recommended FEED RATE: .002 - .006

Spiral Mill-Thread Inserts Speed and Feed Selection

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed ft/min MT7
P	Low and Medium Carbon Steels	480 - 1200
	High Carbon Steels	540 - 840
	Alloy Steels, Treated Steels	440 - 755
M	Stainless Steels	540 - 800
	Cast Steels	620 - 800
K	Cast Iron	330 - 720
N	Non-Ferrous & Aluminum	755 - 1440
	Synthetics, Duroplastics, Thermoplastics	480 - 1940
S	Nickel Alloys, Titanium Alloys	100 - 380

Recommended FEED RATE: .002 - .006

As you may note, cutting speed is shown in range terms. In most standard cases choosing a speed in the middle of the range would be a good choice for a start.

For hard metals reduce cutting speed.