












Drilling Parameters for DTMC Thread Mills

Material Group	Hardness		SFM	Feed Rate Inch per tooth				
	Rc	Brn		#10	1/4	3/8	1/2	5/8
 Structural Steels	-	<180	400					
	-	<180	400					
	<20	<230	325					
	<25	<250	260					
 Alloyed case hardened steels	<25	<250	260					
	<30	<280	230					
	<35	<320	200					
	<38	<380	180					
 Stainless		<180	250					
	<25	<250	200					
	<30	<280	230					
 Structural Steels	<20	<230	330					
	<25	<250	300					
	<25	<250	280					
	<30	<280	260					
 Al wrought alloys	-	30-80	750	0.002	0.004	0.006	0.008	0.01
	-	75-150	500	0.002	0.004	0.006	0.008	0.01
	-	n/a	600	0.002	0.006	0.009	0.012	0.016
	-	n/a	450	0.002	0.004	0.007	0.01	0.012
 Cast iron	-	<180	400	0.002	0.004	0.006	0.008	0.01
	<25	<250	320	0.002	0.003	0.004	0.006	0.008
	<35	<320	300	0.002	0.003	0.004	0.006	0.008
 Brass,	-	<180	600	0.002	0.006	0.01	0.012	0.016
	-	<180	600	0.002	0.004	0.006	0.008	0.01
 Plastics, Carbon/glass reinforced	-		500	0.002	0.006	0.009	0.012	0.016
 Magnesium-alloys	-		750	0.002	0.006	0.009	0.012	0.016
 Titanium and Ti-alloys	-	140-300	140					
	-	300-380	110					
 Ni-alloys	-	<300	125					
	-	>300	100					