












Recommendations for Thread Milling Cutters

Material Group	Hardness		SFM	Feed Rate Inch per tooth							Recommended Treatment
	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
	-	<180	400	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	<20	<230	325	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	<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
	<30	<280	230	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	
	<35	<320	200	0.0004	0.001	0.0015	0.002	0.0025	0.0025	0.003	
	<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
	<25	<250	300	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	<25	<250	280	0.0008	0.0015	0.002	0.003	0.0035	0.0035	0.004	
	<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	