



## Single Form Thread Milling Guide

Single Form Threadmills are the most versatile threading tool due to their ability to mill multiple pitch sizes. Since they are used in a helical interpolation environment, specific machining parameters are needed to avoid deflection and breakage. These tools can be used successfully in materials ranging from Aluminum to Steels.

### Speeds & Feeds calculations:

1. Determine the correct SFM and Chip Load (IPT) for the cutter and material
2. Calculate the Speed (RPM) and Linear Feed (IPM)
3. Adjust Linear Feed to account for helical interpolation of internal or external threads
4. Determine correct number of radial passes at full axial depth

Example: Tool #932920 to machine a 6-40 internal thread in 17-4 stainless steel

1. From Speeds & Feeds chart (next page), SFM is 150 and Chip Load (IPT) is .00028
2. Calculate Speed (RPM) and Linear Feed (IPM)

$$\begin{aligned} \text{RPM} &= (\text{SFM} \times 3.82) / \text{Cutter Diameter} \\ &= (150 \times 3.82) / .098 \\ &= 5847 \end{aligned}$$

$$\begin{aligned} \text{Linear Feed (IPM)} &= \text{RPM} \times \text{IPT} \times \text{Number of Flutes} \\ &= 5847 \times .00028 \times 4 \\ &= 6.54 \end{aligned}$$

3. Adjust Linear Feed (use Table 1 to determine Major Thread Diameter)

$$\begin{aligned} \text{Adj Internal Feed} &= [(\text{Major Thread Dia} - \text{Cutter Dia}) / \text{Major Thread Dia}] \times \text{Linear Feed} \\ &= [(.138 - .098) / .138] \times 6.54 \\ &= 1.9 \end{aligned}$$

$$\begin{aligned} \text{Adj External Feed} &= [(\text{Major Thread Dia} + \text{Cutter Dia}) / \text{Major Thread Dia}] \times \text{Linear Feed} \\ &= [(.138 + .098) / .138] \times 6.54 \\ &= 11.2 \end{aligned}$$

4. Determine Number of Radial Passes using Table 1

(Note: The number of passes should be based on the thread size of the tool, and not the machined part)

- For Easy Machinability = 2 Radial Pass at full Axial Depth
- For Moderate Machinability = 3 Radial Passes at full Axial Depth
- For Difficult Machinability = 4 Radial Passes at full Axial Depth

#### Definitions:

Easy Machinability materials include Non-Ferrous alloys and Lead Steels  
 Moderate Machinability materials include 200/300/400 Stainless Steels and Steels up to 35 Rc  
 Difficult Machinability materials include Inconel, Titanium and Steels 36-45 Rc

5. Conclusion

In this example, the tool would run at 5847 RPM, 1.9 IPM and make 3 Radial Passes

### Setup & Use:

1. Check software and input proper feed values (Linear or Adjusted)
2. Choke up on tool
3. Minimize runout (consider entire system of spindle, collet, holders etc)
4. Minimize all vibration (consider tool holding, work holding, rpm "sweet spot" etc)
5. Break in tool by reducing feed rates by 25% on first 1-2 holes
6. Cutter should engage part using an arcing toolpath to avoid shock loading (see Table 2)
7. Climb mill for best finish and tool life (see Table 2)
8. Flush chips with coolant to avoid recutting

Table 1 Tool Thread Size	Major Thread Diameter	Number of Radial Passes*		
		Easy Machinability	Moderate Machinability	Difficult Machinability
00	0.047	2	3	4
0	0.060	2	3	4
1	0.073	2	3	4
2	0.086	2	3	3
3	0.099	2	3	3
4	0.112	2	3	4
5	0.125	2	3	3
6	0.138	2	3	4
8	0.164	2	2	3
10	0.190	2	3	4
12	0.216	2	2	3
1/4	0.250	2	2	3
5/16	0.312	2	2	3
3/8	0.375	2	2	3
7/16	0.437	2	2	3
1/2	0.500	2	2	3
9/16	0.562	2	2	3
5/8	0.625	2	2	3
3/4	0.750	2	2	3
7/8	0.875	2	2	3
1	1.000	2	3	4

\* Number of Radial Passes are based on the coarsest pitch by thread size. For finer pitches, the number of passes may be reduced by 1 pass.

Table 2
<p><b>INTERNAL, RIGHT HAND THREAD (CLIMB MILLING)</b></p> <p>Step 1-2: Cutter moves into position            Step 2-3: Cutter engages part with arcing tool path while "Z" feeds up from bottom            Step 3-4: Cutter moves helically            Step 4-5: Cutter exits part along arcing tool path while maintaining "Z" feed            Step 5-6: Cutter returns to center</p>
<p><b>INTERNAL, LEFT HAND THREAD (CLIMB MILLING)</b></p> <p>Step 1-2: Cutter moves into position            Step 2-3: Cutter engages part with arcing tool path while "Z" feeds down from top            Step 3-4: Cutter moves helically            Step 4-5: Cutter exits part along arcing tool path while maintaining "Z" feed            Step 5-6: Cutter returns to center</p>
<p><b>EXTERNAL, RIGHT HAND THREAD (CLIMB MILLING)</b></p> <p>Step 1-2: Cutter engages part with arcing tool path while "Z" feeds down from top            Step 2-3: Cutter moves helically            Step 3-4: Cutter exits part along arcing tool path while maintaining "Z" feed</p>
<p><b>EXTERNAL, LEFT HAND THREAD (CLIMB MILLING)</b></p> <p>Step 1-2: Cutter engages part with arcing tool path while "Z" feeds up from bottom            Step 2-3: Cutter moves helically            Step 3-4: Cutter exits part along arcing tool path</p>



Speeds & Feeds

**Product Table:** Thread Milling Cutters - Single Form - UN Threads  
**Characteristics:** Short Reach  
**Series:** 9329xx

**Please note:**

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions. Chip loads reflect uncoated cutters and may be increased 5%-10% if coated. For ferrous materials with hardness  $\leq 28$  Rc, chip loads can be increased 3%-5%.

If you require additional information, Harvey Tool has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **800-645-5609** or [Harveytech@harveyperformance.com](mailto:Harveytech@harveyperformance.com).

WARNING: Cutting tools may shatter under improper use. Government regulations require use of safety glasses and other appropriate safety equipment in the vicinity of use.

MATERIAL	Hardness: $\leq 28$ Rc ( $\leq 271$ HBn)												
	SFM	Chip Load (IPT) By Cutter Diameter											
		0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.312	0.375	0.500	0.625	0.750
<b>ALUMINUM ALLOYS</b>													
Casting (2xx, 5xx, 7xx, 8xx)	750	.00018	.00024	.00030	.00036	.00048	.00101	.00135	.00206	.00248	.00330	.00413	.00495
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000												
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750												
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700												
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650	.00016	.00021	.00027	.00032	.00043	.00091	.00122	.00185	.00223	.00297	.00371	.00446
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475												
Wrought - 5%-8% Si (4xxx)	1000												
Wrought - 8%-12% Si (4xxx)	800												
<b>MAGNESIUM ALLOYS</b>	1500	.00018	.00024	.00030	.00036	.00048	.00101	.00135	.00206	.00248	.00330	.00413	.00495
<b>ZINC ALLOYS</b>	800												
<b>COPPER ALLOYS</b>	225												
High Coppers - 90%+ (C1xxx)													
Brass (Copper Zinc alloys, C2xxx, C3xxx, C4xxx, C6400-C6900)	500												
Phosphor Bronzes (Copper Tin alloys, C5xxx)	225												
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500	.00017	.00023	.00029	.00034	.00046	.00082	.00110	.00173	.00207	.00277	.00346	.00415
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500												
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxx)	225												
Cast Copper Alloys (C83300-C86200, C86400-C87900, C9200-C95800, C97300-C97800, C99400-C99700)	550												

MATERIAL	Hardness: 29-37 Rc (279-344 HBn)												
	SFM	Chip Load (IPT) By Cutter Diameter											
		0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.312	0.375	0.500	0.625	0.750
<b>CARBON STEELS</b>													
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	.00014	.00018	.00022	.00027	.00036	.00081	.00108	.00168	.00203	.00270	.00338	.00405
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xx, 3xx, 4xx & 4xLxx, 5xxx & 5xLxx, 51xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	200	.00014	.00018	.00022	.00027	.00036	.00081	.00108	.00150	.00180	.00240	.00300	.00360
<b>STAINLESS STEELS</b>													
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	.00014	.00018	.00022	.00027	.00036	.00081	.00108	.00168	.00203	.00270	.00338	.00405
201, 202, 203, 205, 301, 302, 304, 304L, 308, 309, 310, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	200	.00014	.00018	.00022	.00027	.00036	.00054	.00072	.00112	.00135	.00180	.00225	.00270
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	.00014	.00018	.00022	.00027	.00036	.00054	.00072	.00101	.00122	.00162	.00203	.00243
<b>TOOL STEELS</b>													
A, L, O, P, W series	200	.00015	.00020	.00025	.00029	.00040	.00059	.00079	.00132	.00158	.00211	.00264	.00317
D, H, M, T, S series	200	.00014	.00018	.00022	.00027	.00036	.00054	.00072	.00120	.00144	.00192	.00240	.00288
<b>TITANIUM ALLOYS</b>	150	.00015	.00020	.00025	.00029	.00040	.00059	.00079	.00115	.00139	.00185	.00231	.00277
<b>HIGH TEMP ALLOYS</b>													
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	.00012	.00016	.00021	.00025	.00033	.00049	.00066	.00097	.00117	.00156	.00195	.00234

MATERIAL	Hardness: 38-45 Rc (353-421 HBn)												
	SFM	Chip Load (IPT) By Cutter Diameter											
		0.047	0.062	0.078	0.093	0.125	0.187	0.250	0.312	0.375	0.500	0.625	0.750
<b>CARBON STEELS</b>													
Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	-	-	-	-	-	-	-	-	-	-	-	-
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xx, 3xx, 4xx & 4xLxx, 5xxx & 5xLxx, 51xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	200	-	-	-	-	-	-	-	-	-	-	-	-
<b>STAINLESS STEELS</b>													
203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	-	-	-	-	-	-	-	-	-	-	-	-
201, 202, 203, 205, 301, 302, 304, 304L, 308, 309, 310, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	200	.00012	.00015	.00019	.00023	.00031	.00046	.00061	.00095	.00115	.00153	.00191	.00230
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	90	.00012	.00015	.00019	.00023	.00031	.00046	.00061	.00086	.00103	.00138	.00172	.00207
<b>TOOL STEELS</b>													
A, L, O, P, W series	100	.00013	.00017	.00021	.00025	.00034	.00050	.00067	.00112	.00135	.00180	.00224	.00269
D, H, M, T, S series	90	.00012	.00015	.00019	.00023	.00031	.00046	.00061	.00102	.00122	.00163	.00204	.00245
<b>TITANIUM ALLOYS</b>	75	.00013	.00017	.00021	.00025	.00034	.00050	.00067	.00098	.00118	.00157	.00196	.00236
<b>HIGH TEMP ALLOYS</b>													
Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	50	.00011	.00014	.00018	.00021	.00028	.00042	.00056	.00083	.00099	.00133	.00166	.00199