



Thread Injector High Performance 3 Form Threadmills Technical Information

- RedLine Thread Injector High Performance 3 Form Threadmills are geared for top performance in a variety of different materials
- 3 Form Threadmills are found on pages 351-352.

3 Form Threadmills Speeds & Feeds

Material	Grades	SFM	Threadmill Diameter (IPT)									
			1/16	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	
			(.0625)	(.1250)	(.1875)	(.2500)	(.3125)	(.3750)	(.5000)	(.0625)	(.7500)	
P - Steels												
High Strength Tool Steel	A2, D2, P20, H11, H13, S2, 01	300	.0001	.0001	.0001	.0002	.0004	.0010	.0012	.0015	.0020	
Low Carbon	A36, 12L14, 12L15, 1005, 1018, 1020, 1108-1119, 1213-1215, 1513-1518, 4012, 5015, 9310	450	.0025	.0030	.0030	.0040	.0050	.0050	.0060	.0060	.0060	
Medium Carbon	1040-1095, 1140-1151, 1330-1345, 1520-1572, 4023-4063, 4120-4161, 4330-4340, 4620-4640, 8620-8660, 8740-8750, 6150, 51000, 52100	395-430	.0010	.0003-.0010	.0003-.0030	.0005-.0020	.0006-.0030	.0007-.0030	.0010-.0040	.0015-.0040	.0015-.0040	
M - Stainless Steels												
Austenitic	301-304L, 310, 316L, 321, 347	395	.0008	.0010	.0010	.0015	.0015	.0020	.0030	.0030	.0040	
Martensitic	403, 410, 416, 420, 430, 431, 440	415	.0008	.0010	.0010	.0015	.0015	.0020	.0030	.0030	.0040	
Precipitation Hardening	12/8, 15/5, 17/4, AM-350/355/363, PH13-8MO, PH14-8/MO	225	.0008	.0010	.0010	.0010	.0015	.0015	.0020	.0020	.0020	
K - Cast Irons												
Ductile	A536, J434, 60-40-18	450	.0010	.0010	.0015	.0015	.0020	.0030	.0040	.0040	.0040	
Gray	A48, A436, A319, Class 20, G4000	450	.0010	.0010	.0015	.0015	.0020	.0030	.0040	.0040	.0040	
Malleable	A220, A602, J158	450	.0010	.0010	.0015	.0015	.0020	.0030	.0040	.0040	.0040	
N - Non-Ferrous												
Aluminum Alloys	2014, 2024, 6061, 7075	1275	.0015	.0020	.0020	.0030	.0030	.0040	.0050	.0050	.0050	
Aluminum High Silicon	A380, A390	335	.0004	.0005	.0010	.0015	.0020	.0020	.0025	.0030	.0050	
Brass/Bronze	Aluminum Bronze, Low Silicon Bronze	1275	.0010	.0020	.0020	.0030	.0030	.0040	.0050	.0050	.0050	
Composites	G-10, Fiberglass, Graphite, Graphite Epoxy, Plastics	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	
Copper		750	.0004	.0004	.0005	.0006	.0006	.0008	.0010	.0012	.0012	
Magnesium		750	.0004	.0010	.0010	.0020	.0020	.0020	.0030	.0050	.0050	
S - High Temp Alloys												
Cobalt Base	Stellite, HS-21, Haynes 25/188, X40, L605	115	.0001	.0002	.0004	.0005	.0005	.0007	.0008	.0010	.0012	
Iron Base	Incoloy 800-802, Multmet N-155, Timkin 16-25-6, Carpenter 22-b3	115	.0001	.0002	.0004	.0005	.0005	.0007	.0008	.0010	.0012	
Nickel Base	Inconel 625/718, Inco 700, 713C, 718, Monel 400-401, 404, K401, Rene, Rene 41 & 95 Hastelloy, Waspoly, Udimet 500 & 700	90	.0005	.0005	.0005	.0010	.0010	.0015	.0020	.0020	.0020	
Titanium	Commercially Pure, 6Al-4V, ASTM 1/2/3, 6Al-25N-4Zr-2Mo-Si, Ti-8Al-1Mo, Ti-8Al-4Mo	75	.0005	.0005	.0005	.0010	.0010	.0015	.0020	.0020	.0020	

NOTE: Speeds and Feeds listed are estimated and will vary by application.