



Thread Injector High Performance End or Side Coolant Threadmills Technical Information

- RedLine Thread Injector High Performance Coolant Fed Threadmills are geared for top performance in a variety of different materials
- Coolant Fed Threadmills found on pages 343, 347 & 349.



Carbide Threadmills - Technical Info

End or Side Coolant Threadmills Speeds & Feeds

Material	Grades	SFM	Threadmill Diameter (IPT)								
			1/16 (.0625)	1/8 (.1250)	3/16 (.1875)	1/4 (.2500)	5/16 (.3125)	3/8 (.3750)	1/2 (.5000)	5/8 (.6250)	3/4 (.7500)
P - Steels											
High Strength Tool Steel	A2, D2, P20, H11, H13, S2, 01	400	.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	600	.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	525-575	.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	525	.0008	.0010	.0010	.0015	.0015	.0020	.0030	.0030	.0040
Martensitic	403, 410, 416, 420, 430, 431, 440	550	.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	300	.0008	.0010	.0010	.0010	.0015	.0015	.0020	.0020	.0020
K - Cast Irons											
Ductile	A536, J434, 60-40-18	600	.0010	.0010	.0015	.0015	.0020	.0030	.0040	.0040	.0040
Gray	A48, A436, A319, Class 20, G4000	600	.0010	.0010	.0015	.0015	.0020	.0030	.0040	.0040	.0040
Malleable	A220, A602, J158	600	.0010	.0010	.0015	.0015	.0020	.0030	.0040	.0040	.0040
N - Non-Ferrous											
Aluminum Alloys	2014, 2024, 6061, 7075	1700	.0015	.0020	.0020	.0030	.0030	.0040	.0050	.0050	.0050
Aluminum High Silicon	A380, A390	450	.0004	.0005	.0010	.0015	.0020	.0020	.0025	.0030	.0050
Brass/Bronze	Aluminum Bronze, Low Silicon Bronze	1700	.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		1000	.0004	.0004	.0005	.0006	.0006	.0008	.0010	.0012	.0012
Magnesium		1000	.0004	.0010	.0010	.0020	.0020	.0020	.0030	.0050	.0050
S - High Temp Alloys											
Cobalt Base	Stellite, HS-21, Haynes 25/188, X40, L605	150	.0001	.0002	.0004	.0005	.0005	.0007	.0008	.0010	.0012
Iron Base	Incoloy 800-802, Multmet N-155, Timkin 16-25-6, Carpenter 22-b3	150	.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, Waspoloy, Udimet 500 & 700	120	.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	100	.0005	.0005	.0005	.0010	.0010	.0015	.0020	.0020	.0020

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