

Threadmills

Material Group	Cutting Speed (v_c , m/min)	Feed Rate (mm/Tooth)
Carbon Steels	80	0.06
Alloy Steels up to 850 N/mm ²	60	0.04
High Tensile Alloy Steels above 850 N/mm ²	40	0.02
Free machining Stainless Steel	50	0.04
Austenitic Stainless Steel	30	0.02
Ferritic and Martensitic Stainless Steels	50	0.03
Cast Iron	80	0.08
SC Iron	80	0.06
Aluminium unalloyed	150	0.1
Aluminium Cast low silicon	100	0.1
Aluminium Cast high silicon	100	0.075
Copper	120	0.08
Brass	120	0.08
Soft Plastics	150	0.1
Glass reinforced Plastics	60	0.06
Nickel Alloys up to 850 N/mm ²	30	0.03
Nickel Alloys above 850 N/mm ²	20	0.005
Titanium Alloy	30	0.02

Typical Threadmilling Applications

