HARVEY TOOL

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 #993940 to machine a 10-28 internal thread in 17-4 stainless steel

1. From Speeds & Feeds chart (next page), SFM is 150 and Chip Load (IPT) is .00023
2. Calculate Speed (RPM) and Linear Feed (IPM)

   RPM = (SFM x 3.82) / Cutter Diameter
   = (150 x 3.82) / .135
   = 4244

   Linear Feed (IPM) = RPM x IPT x Number of Flutes
   = 4244 x .00021 x 4
   = 3.56

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

   Adj Internal Feed = [(Major Thread Dia - Cutter Dia) / Major Thread Dia] x Linear Feed
   = [(.190- .135) / .190] x 3.56
   = 1.03

   Adj External Feed = [(Major Thread Dia + Cutter Dia) / Major Thread Dia] x Linear Feed
   = [(.190 + .135) / .190] x 3.56
   = 6.08

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 Leaded 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 4244 RPM, 1.03 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

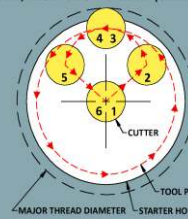
Table 1

Tool Thread Size	Major Thread Diameter	Number of Radial Passes*		
		Easy Machinabilty	Moderate Machinabilty	Difficult Machinabilty
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.

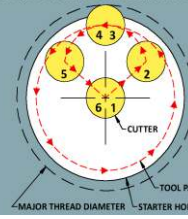
Table 2

INTERNAL, RIGHT HAND THREAD (CLIMB MILLING)



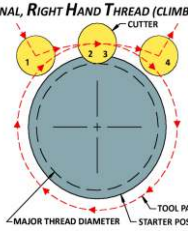
Step 1-2: Cutter moves into position
Step 2-3: Cutter engages part with arcing tool path while "Z" feeds up from bottom
Step 3-4: Cutter moves helically
Step 4-5: Cutter exits part along arcing tool path while maintaining "Z" feed
Step 5-6: Cutter returns to center

INTERNAL, LEFT HAND THREAD (CLIMB MILLING)



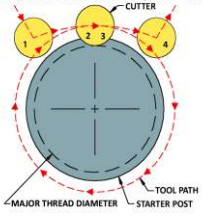
Step 1-2: Cutter moves into position
Step 2-3: Cutter engages part with arcing tool path while "Z" feeds down from top
Step 3-4: Cutter moves helically
Step 4-5: Cutter exits part along arcing tool path while maintaining "Z" feed
Step 5-6: Cutter returns to center

EXTERNAL, RIGHT HAND THREAD (CLIMB MILLING)



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

EXTERNAL, LEFT HAND THREAD (CLIMB MILLING)



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

Speeds & Feeds

Product Table: Thread Milling Cutters - Single Form - UN Threads
Characteristics: XXL Reach
Series: 9939xx

MATERIAL	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
Hardness: ≤ 28 Rc (≤ 271 HBn)													
ALUMINUM ALLOYS Casting (2xx, 5xx, 7xx, 8xx)	750	.00011	.00014	.00017	.00021	.00028	.00059	.00079	.00120	.00144	.00193	.00241	.00289
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	1000												
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	750	.00009	.00012	.00016	.00019	.00025	.00053	.00071	.00108	.00130	.00173	.00217	.00260
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	700												
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	650												
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	475												
Wrought - 5%-8% Si (4xxx)	1000												
Wrought - 8%-12% Si (4xxx)	800												
MAGNESIUM ALLOYS	1500	.00011	.00014	.00017	.00021	.00028	.00059	.00079	.00120	.00144	.00193	.00241	.00289
ZINC ALLOYS	800												
COPPER ALLOYS High Coppers - 90%+ (C1xxxx)	225	.00010	.00013	.00017	.00020	.00027	.00048	.00064	.00101	.00121	.00161	.00202	.00242
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C66400-C69800)	500												
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	225												
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	500												
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	500												
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	225												
Cast Copper Alloys (C83300-C86200, C86400-C87900, C9200-C95800, C97300-C97800, C99400-C99700)	550												
Hardness: 29-37 Rc (279-344 HBn)													
CARBON STEELS Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	600	.00008	.00010	.00013	.00016	.00021	.00047	.00063	.00098	.00118	.00158	.00197	.00236
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 51xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	200	.00008	.00010	.00013	.00016	.00021	.00047	.00063	.00087	.00105	.00140	.00175	.00210
STAINLESS STEELS 203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	450	.00008	.00010	.00013	.00016	.00021	.00047	.00063	.00098	.00118	.00158	.00197	.00236
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	.00008	.00010	.00013	.00016	.00021	.00031	.00042	.00066	.00079	.00105	.00131	.00158
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	150	.00008	.00010	.00013	.00016	.00021	.00031	.00042	.00059	.00071	.00095	.00118	.00142
TOOL STEELS A, L, O, P, W series	200	.00009	.00011	.00014	.00017	.00023	.00035	.00046	.00077	.00092	.00123	.00154	.00185
D, H, M, T, S series	200	.00008	.00010	.00013	.00016	.00021	.00031	.00042	.00070	.00084	.00112	.00140	.00168
TITANIUM ALLOYS	150	.00009	.00011	.00014	.00017	.00023	.00035	.00046	.00067	.00081	.00108	.00135	.00162
HIGH TEMP ALLOYS Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discoloy, Incoloy	70	.00007	.00010	.00012	.00014	.00019	.00029	.00039	.00057	.00068	.00091	.00114	.00137

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
Hardness: 38-45 Rc (353-421 HBn)												
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
100	.00007	.00009	.00011	.00013	.00018	.00027	.00036	.00056	.00067	.00089	.00112	.00134
90	.00007	.00009	.00011	.00013	.00018	.00027	.00036	.00050	.00060	.00080	.00100	.00120
100	.00007	.00010	.00012	.00015	.00020	.00029	.00039	.00065	.00079	.00105	.00131	.00157
90	.00007	.00009	.00011	.00013	.00018	.00027	.00036	.00059	.00071	.00095	.00119	.00143
75	.00007	.00010	.00012	.00015	.00020	.00029	.00039	.00057	.00069	.00092	.00115	.00137
50	.00006	.00008	.00010	.00012	.00016	.00024	.00033	.00048	.00058	.00077	.00097	.00116

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 ≤ 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**.