



General Purpose Carbide Multi Form Thread Mills

Material Guide		HRc	SFM	FEED PER TOOTH								
				1/16	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4
COBALT BASE ALLOYS	Stellite, HS-21, Haynes 25/188, X-40, L-605	under 32 over 32	50 - 90	.00015	.0002	.0003	.0004	.0006	.0008	.0010	.0014	.0018
				.00025	.0005	.0005	.0006	.0009	.0015	.0020	.0028	.0030
NICKEL BASE ALLOYS	Inconel-625/718, Waspalloy, Rene, Hastelloy	under 32 over 32	60 - 100	.0002	.0003	.0005	.0008	.0010	.0015	.0015	.0020	.0025
				.0003	.0006	.0010	.0015	.0020	.0025	.0025	.0030	.0040
IRON BASE ALLOYS	Incoloy 800-802, Multimet N-155, Timkin 16-25-6, Carpeneter 22-b3	under 32 over 32	50 - 90	.00015	.0002	.0003	.0004	.0006	.0008	.0010	.0014	.0018
				.00025	.0005	.0005	.0006	.0009	.0015	.0020	.0028	.0030
TITANIUM ALLOYS	Commercially Pure, 6AL-4V, Astm 1/2/3, 6Al-25N-4Zr-2Mo-Si		80 - 150	.0002	.0003	.0005	.0008	.0010	.0015	.0015	.0025	.0030
				.0005	.0006	.0010	.0015	.0020	.0025	.0025	.0035	.0040
STAINLESS STEEL (PRECIPITATION)	13/8, 15/5, 17-4, AM-350/355	under 32 over 32	100 - 250	.00015	.00025	.0005	.0008	.0010	.0015	.0020	.0030	.0035
				.00025	.00055	.0010	.0015	.0020	.0025	.0030	.0040	.0050
STAINLESS STEEL (AUSTENITIC)	200 Series, 302, 303, 304, 316	under 32 over 32	100 - 250	.00015	.00025	.0005	.0008	.0010	.0015	.0020	.0030	.0035
				.00025	.00055	.0010	.0015	.0020	.0025	.0030	.0040	.0050
STAINLESS STEEL (MARTENSITIC)	403, 410, 416, 440	under 32 over 32	150 - 250	.0002	.0004	.0005	.0010	.0015	.0015	.0020	.0030	.0030
				.0003	.0008	.0010	.0015	.0020	.0030	.0035	.0040	.0040
HIGH STRENGTH TOOL STEELS	4140, 4340, 6150, 5210, A2, D2 P20, H11, H13, S2, 01	under 32 over 32	250 - 400	.00015	.0003	.0005	.0008	.0010	.0015	.0020	.0030	.0035
				.0003	.0006	.0010	.0015	.0020	.0025	.0030	.0040	.0050
MEDIUM ALLOY STEELS	200, 250, 300	under 32 over 32	300 - 450	.0002	.0005	.0010	.0015	.0020	.0030	.0035	.0050	.0060
				.0004	.0010	.0015	.0025	.0030	.0045	.0055	.0070	.0080
CARBON STEELS	A36, 12L14, 12L15, 1005, 1018, 1020, 1108-1119, 1213-1215, 1513-1518, 4012, 5015, 9310	under 32 over 32	350 - 500	.0002	.0005	.0010	.0015	.0020	.0030	.0035	.0050	.0060
				.0004	.0010	.0015	.0025	.0030	.0045	.0055	.0070	.0080
DUCTILE	Ductile Cast Irons		200 - 300	.00025	.0003	.0005	.0008	.0010	.0015	.0020	.0030	.0030
				.00035	.0006	.0010	.0015	.0020	.0025	.0030	.0040	.0050
CAST IRONS	Gray Cast Irons		250 - 350	.00025	.0004	.0005	.0008	.0010	.0015	.0020	.0030	.0030
				.00035	.0008	.0010	.0015	.0020	.0025	.0030	.0040	.0050
MALLEABLE	A220, A436, A439, A602		200 - 300	.00025	.0003	.0005	.0008	.0010	.0015	.0020	.0030	.0030
				.00035	.0006	.0010	.0015	.0020	.0025	.0030	.0040	.0050
ALUMINUM	2014, 2024, 6061-(T1-T6), 7075, Die Cast, Extruded		800 - 1400	.0002	.0005	.0010	.0015	.0020	.0030	.0035	.0050	.0060
				.0004	.0010	.0015	.0025	.0030	.0045	.0055	.0070	.0100
HIGH SILICON			475 - 750	.00015	.00035	.00075	.0010	.0015	.0018	.0023	.0028	.0035
				.00022	.0004	.0008	.0020	.0025	.0028	.0030	.0031	.0050
MAGNESIUM			800 - 1400	.0003	.0005	.0010	.0015	.0020	.0030	.0035	.0050	.0060
				.0005	.0010	.0015	.0025	.0030	.0045	.0055	.0070	.0100
COPPER, COPPER ALLOYS			450 - 1000	.00025	.0003	.0005	.0008	.0010	.0015	.0020	.0030	.0035
				.00035	.0006	.0010	.0015	.0020	.0025	.0030	.0040	.0050
BRASS, BRONZE	Brass, Alum/Bronze, Low Silicon Bronze		550 - 800	.0002	.0005	.0010	.0015	.0020	.0030	.0035	.0050	.0060
				.0005	.0010	.0015	.0025	.0030	.0045	.0055	.0070	.0100
COMPOSITES	G-10 Fiberglass, Graphite, Graphite/Epoxy, Plastics		800 - 1400	.0003	.0005	.0010	.0015	.0020	.0030	.0035	.0050	.0060
				.0005	.0010	.0015	.0025	.0030	.0045	.0055	.0070	.0100