Mill-Thread Inserts Speed and Feed Selection

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed m/min MT7
P	Low and Medium Carbon Steels	115 - 280
	High Carbon Steels	130 - 200
	Alloy Steels, Treated Steels	105 - 180
M	Stainless Steels	130 - 190
	Cast Steels	150 - 190
K	Cast Iron	80 - 70
N	Non-Ferrous & Aluminum	180 - 340
	Synthetics, Duroplastics, Thermoplastics	115 - 460
S	Nickel Alloys, Titanium Alloys	25 - 90

Recommended FEED RATE: 0.05 - 0.15 mm

Spiral Mill-Thread Inserts Speed and Feed Selection

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed m/min MT7
P	Low and Medium Carbon Steels	145 - 360
	High Carbon Steels	165 - 255
	Alloy Steels, Treated Steels	135 - 230
M	Stainless Steels	165 - 245
	Cast Steels	190 - 245
K	Cast Iron	100 - 220
N	Non-Ferrous & Aluminum	230 - 440
	Synthetics, Duroplastics, Thermoplastics	145 - 590
S	Nickel Alloys, Titanium Alloys	30 - 115

Recommended FEED RATE: 0.05 - 0.15 mm

As you may note, cutting speed is shown in range terms. In most standard cases choosing a speed in the middle of the range would be a good choice for a start.

For hard metals reduce cutting speed.