

Cutting Data

D-Thread type

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)
P	Low and Medium Carbon Steels <0.55%C	100-205
	High Carbon Steels ≥0.55%C	100-180
	Alloy Steels, Treated Steels	100-140
M	Stainless Steels - Free Cutting	85-125
	Stainless Steels - Austenitic	80-115
	Cast Steels	115-155
K	Cast Iron	75-145
N	Aluminum ≤12%Si, Copper	150-300
	Aluminum >12% Si	150-300
	Synthetics, Duroplastics, Thermoplastics	100-350
S	Nickel Alloys, Titanium Alloys	45- 95

Recommended FEED RATE: 0.07 - 0.15 mm