

Mill-Thread Solid Carbide Grades, Speed and Feed Selection

MT 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	Feed mm/tooth Cutting Diameter=D										
			Ø2	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16	Ø20	Ø25
P	Low and Medium Carbon Steels <0.55%C	90 - 200	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18
	High Carbon Steels ≥0.55%C Alloy Steels, Treated Steels	100 - 145	0.02	0.03	0.03	0.05	0.06	0.07	0.08	0.09	0.10	0.12	0.15
M	Stainless Steels - Free Cutting	55 - 130	0.02	0.03	0.03	0.04	0.05	0.06	0.06	0.07	0.08	0.09	0.11
	Stainless Steels - Austenitic	55 - 100	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
	Cast Steels	120 - 135	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
K	Cast Iron	65 - 120	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18
N	Aluminum ≤12%Si, Copper	135 - 280	0.03	0.04	0.04	0.06	0.07	0.08	0.09	0.11	0.12	0.15	0.18
	Aluminum >12% Si	90 - 200	0.02	0.02	0.03	0.03	0.04	0.05	0.05	0.06	0.07	0.08	0.10
	Synthetics, Duroplastics, Thermoplastics	90 - 320	0.05	0.06	0.07	0.08	0.10	0.11	0.12	0.14	0.15	0.18	0.22
S	Nickel Alloys, Titanium Alloys	20 - 70	0.02	0.02	0.02	0.03	0.03	0.03	0.03	0.04	0.04	0.04	0.05

For cutters with long cutting length reduce feed rate by 40%