



Application recommendations thread milling cutters and micro thread milling cutters

ISO		Hardness HRC	Hardness Brinell	Cutting speed SFM	Milling part diameter [d1] / feed per tooth [IPT]								
					Ø1 mm	Ø2 mm	Ø3 mm	Ø4 mm	Ø5 mm	Ø6 mm	Ø7 mm	Ø8 mm	Ø9 mm
P	Structural/free-cutting steels, Unalloyed heat-treatable-/ case hardened steels	< 22	< 220	300	0.0004	0.0008	0.0008	0.0010	0.0012	0.0014	0.0018	0.0020	0.0022
	Free-cutting steels, unalloyed case hardened steels, nitriding steels	< 30	< 290	260	0.0004	0.0008	0.0008	0.0010	0.0012	0.0014	0.0018	0.0020	0.0022
	Alloyed heat-treatable steels, heat-treatable steels, high speed steels	< 38	<350	230	0.0004	0.0008	0.0008	0.0010	0.0012	0.0014	0.0018	0.0020	0.0022
M	Stainless steel sulfured, austenitic	< 30	< 290	180	0.0004	0.0008	0.0010	0.0012	0.0012	0.0012	0.0014	0.0016	0.0020
	Stainless and acid-resit. steel steels, martensitic	< 30	< 290	165	0.0004	0.0008	0.0010	0.0012	0.0012	0.0012	0.0014	0.0016	0.0020
	duplex and super duplex	< 40	< 375	150	0.0004	0.0008	0.0010	0.0012	0.0012	0.0012	0.0014	0.0016	0.0020
K	cast iron		< 300	400	0.0004	0.0008	0.0010	0.0012	0.0014	0.0016	0.0018	0.002	0.0024
	Spher. graph. iron and mall. cast iron		< 350	330	0.0004	0.0008	0.0010	0.0012	0.0014	0.0016	0.0018	0.002	0.0024
	ADI, GGV		< 350	260	0.0004	0.0008	0.0010	0.0012	0.0014	0.0016	0.0018	0.002	0.0024
N	Aluminium and wrought alloys		30 - 150	820	0.0008	0.0012	0.0014	0.0016	0.0018	0.0020	0.0022	0.0024	0.0026
	Aluminium- cast alloys	6-12 % silicon content	--	750	0.0008	0.0012	0.0014	0.0016	0.0018	0.0020	0.0022	0.0024	0.0026
	Magnesium alloys		< 150	600	0.0008	0.0012	0.0014	0.0016	0.0018	0.0020	0.0022	0.0024	0.0026
	Copper and copper alloys		≤ 120	425	0.0004	0.0008	0.0010	0.0012	0.0014	0.0016	0.0018	0.0020	0.0022
	Copper special alloys		< 410	525	0.0004	0.0008	0.0010	0.0012	0.0014	0.0016	0.0018	0.0020	0.0022
	Plastics [thermoplastics, duroplastics]		--	1000	0.0008	0.0012	0.0016	0.0018	0.0020	0.0022	0.0024	0.0028	0.0031
S	Titanium and titanium alloys		< 350	130	0.0004	0.0004	0.0006	0.0008	0.0010	0.0012	0.0014	0.0016	0.0016
	Nickel, cobalt, iron alloys		< 410	100	0.0004	0.0004	0.0006	0.0008	0.0010	0.0012	0.0014	0.0016	0.0016
H	High tensile steels, hardened steels		< 55	150	x	0.0004	0.0006	0.0008	0.001	0.0012	0.0012	0.0014	0.0016
			< 62	165	x	0.0004	0.0006	0.0008	0.001	0.0012	0.0012	0.0014	0.0016



							TM	TMC	TMU	MTM3	MTM1	MTMH3
	Ø10 mm	Ø12 mm	Ø14 mm	Ø16 mm	Ø18 mm	Ø20 mm						
	0.0024	0.0024	0.0026	0.0026	0.0028	0.0031	●	●	●	●	●	
	0.0024	0.0024	0.0026	0.0026	0.0028	0.0031	●	●	●	●	●	
	0.0024	0.0024	0.0026	0.0026	0.0028	0.0031	○	●	●	●	●	○
	0.0022	0.0024	0.0026	0.0026	0.0028	0.0030	○	●	●	●	●	
	0.0022	0.0024	0.0026	0.0026	0.0028	0.0030	○	●	●	●	●	
	0.0022	0.0024	0.0026	0.0026	0.0028	0.0030	○	●	●	●	●	
	0.0026	0.0028	0.0031	0.0035	0.0039	0.0047	●	●	●	●	●	
	0.0026	0.0028	0.0031	0.0035	0.0039	0.0047	●	●	●	●	●	
	0.0026	0.0028	0.0031	0.0035	0.0039	0.0047	●	●	●	●	●	○
	0.0028	0.0031	0.0033	0.0035	0.0039	0.0047	●	●	●	●	●	
	0.0028	0.0031	0.0033	0.0035	0.0039	0.0047	●	●	●	●	●	
	0.0028	0.0031	0.0033	0.0035	0.0039	0.0047	●	●	●	●	●	
	0.0024	0.0026	0.0028	0.0030	0.0031	0.0035	●	●	●	●	●	
	0.0024	0.0024	0.0026	0.0028	0.0030	0.0031	●	●	●	●	●	
	0.0035	0.0035	0.0039	0.0047	0.0051	0.0059	●	●	●	●	●	
	0.0018	0.0020	0.0022	0.0024	0.0026	0.0028	●	●	●	●	●	
	0.0018	0.0020	0.0022	0.0024	0.0026	0.0028	●	●	●	●	●	●
	0.0018	0.002	0.0022	0.0024	0.0026	0.0028	○	●	○	●	○	●
	0.0018	0.002	0.0022	0.0024	0.0026	0.0028						●

- Optimal
- Secondary