Technical data

RECOMMENDED CUTTING DATA

Infeeds should be based on the pitch and material. Since the cutting forces on the insert increases as the profile is made deeper, a reducing series of infeeds is recommended. However, minimum infeed should not be less than 0.05mm (0.002"). The cutting speeds shown are based on cutting edge life of 20-30 minutes in most cases. The higher values for cutting speeds apply for feeds of maximum 0.2mm (0.008"). The lower values apply for greater feeds with fewer passes and for harder materials.

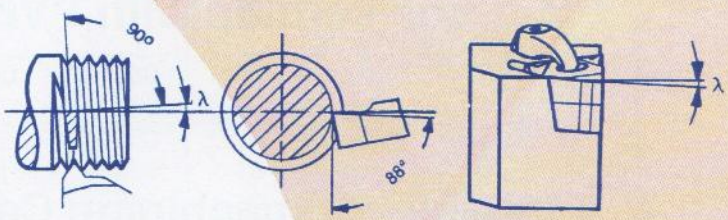
Material	Cutting speed m/min / Tool grade			
	AC350M	AC200M	GC10F	K15
Low and medium carbon steel	250-210	250-210	250-210	
High Carbon steel	210-150	210-150	210-150	
Alloyed tool steel & heat treatment steels	180-140	180-140	180-140	
Stainless steel	170-140	170-140	140-110	90-70
Cast iron HB 180-250				90-70
Non-ferrous metals				180-120

GUIDELINES FOR NUMBER OF PASSES RELATIVE TO PITCH OR TPI

The chart below is only for a guide. The thread sometimes can be produced in fewer passes depending on material

Pitch	0.5	0.75	1.0	1.25	1.5	1.75	2.0	2.5	3.0	3.5	4.0	4.5	5.0	5.5	6.0	8.0
TPI	48	32	24	20	16	14	12	10	8	7	6	5.5	5	4.5	4	3
No. of passes	4-6	4-7	4-8	5-9	6-10	7-12	7-12	8-14	10-16	11-18	11-18	11-19	12-20	12-20	12-20	15-24

Anvil selection



TECHNICAL DATA

In the chart below, the helix angle is given as a function of the diameter and pitch. If another helix angle is required, just change the anvil.

$\tan \lambda = \frac{P}{3.14 \cdot D}$ where P is the thread pitch and D is the pitch diameter.