

# Feed & Speeds

Scandinavian Tool Systems						
Thread Milling Speed & Feed Application Cutting Data						
		Speed		Feed Rate		
		SFM		Feed per flute		
MM			Solid		Solid	Grade
Inset Size	Material	Inserts	Carbide	Inserts	Carbide	Choice
14 & 21	Low Carbon Steel <25Rc	530-680	590-720	.002-.006	.0003-.0015	K20C
14 & 21	Carbon Steel > 25 Rc	400-580	500-620	.003-.006	.0003-.0015	K20C
14 & 21	Alloyed Steel >32 Rc	400-480	450-530	.003-.005	.0003-.0015	K20C
14 & 21	Stainless Steel 316	330-500	400-560	.004-.006	.0003-.0015	K20C
14 & 21	Stainless Steel 400 series	400-580	500-620	.003-.006	.0003-.0015	K20C
14 & 21	Cast Iron HB180 - 250	400-510	450-560	.004-.006	.0003-.0015	K20C
14 & 21	Non-ferrous Mts	1800	1800	.004-.006	.0003-.0015	K20C
30 & 40	Low Carbon Steel <25Rc	530-720		.004-.006		K20C
30 & 40	Carbon Steel > 25 Rc	430-620		.003-.006		K20C
30 & 40	Alloyed Steel >32 Rc	400-530		.003-.005		K20C
30 & 40	Stainless Steel 316	350-560		.003-.006		K20C
30 & 40	Stainless Steel 400 series	430-620		.004-.006		K20C
30 & 40	Cast Iron HB180 - 250	420-560		.004-.006		K20C
30 & 40	Non-ferrous Mts	1900		.003-.006		K20C

Solid Carbide TMs	
Shank Dia	Starting FPT
1/8	0.0003
3/16	0.0003
1/4	0.0005
5/16	0.0006
3/8	0.0007
1/2	0.0010
3.4	0.0015
1"	0.0015