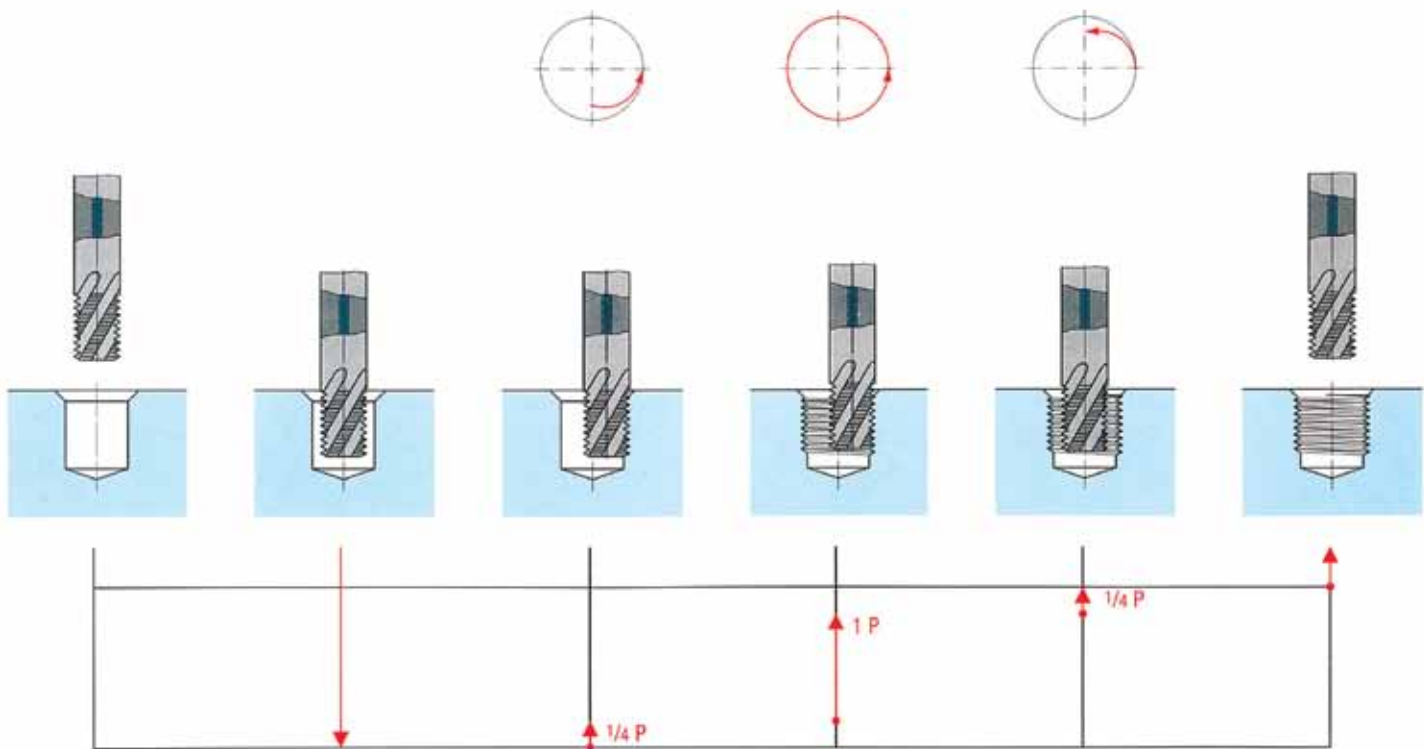


Thread Milling Feed & Speeds

Material	Speed SFM	Feed Rate (inches/tooth)						
		Tool Diameter						
		1/8	3/16	1/4	5/16	3/8	1/2	5/8
Aluminum	800-1400	.0005-.001	.001-.0015	.0015-.0025	.002-.003	.003-.0045	.0035-.0055	.005-.007
Magnesium	800-1400	.0005-.001	.001-.0015	.0015-.0025	.002-.003	.003-.0045	.0035-.0055	.005-.007
Brass	600-800	.0005-.001	.001-.0015	.0015-.0025	.002-.003	.003-.0045	.0035-.0045	.005-.006
Bronze	500-600	.0005-.001	.001-.0015	.0015-.0025	.002-.003	.003-.0045	.0035-.0045	.005-.006
Hard Bronze	200-300	.0004-.0008	.0007-.0012	.001-.002	.001-.002	.0015-.0025	.002-.003	.003-.004
Low Alloy Steels < 25 Rc	350-500	.0005-.001	.001-.0015	.0015-.0025	.002-.003	.0025-.0035	.003-.004	.004-.005
High Alloy Steels > 25 Rc	250-400	.0003-.0006	.0005-.001	.0008-.0015	.001-.002	.0015-.0025	.002-.003	.003-.004
Stainless Steel	150-250	.0004-.0008	.0006-.001	.001-.0015	.0015-.002	.0015-.003	.002-.0035	.003-.004
Cast Iron - Soft	250-350	.0004-.0008	.0007-.0013	.0007-.0013	.0015-.002	.002-.003	.002-.004	.003-.005
Cast Iron - Hard	200-300	.0003-.0006	.0005-.001	.0008-.0015	.001-.002	.0015-.0025	.002-.003	.003-.004
Titanium	80-150	.0003-.0006	.0005-.001	.0008-.0015	.001-.002	.0015-.0025	.0015-.0025	.0025-.0035
Inconel	60-100	.0003-.0006	.0005-.001	.0008-.0015	.001-.002	.0015-.0025	.0015-.0025	.002-.003

Positioning Moving sideways to the starting point Thread milling Thread milling Backing out Retracting tool to positioning level



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