

SPEED AND FEEDS FOR THREADING TOOLS				
MATERIAL	TYPE	SPEED SURFACE FEET PER MINUTE	FEED INFEED PER PASS 1ST PASS	FEED INFEED PER PASS LAST PASS
PLASTIC	TEFLON	250-400	.015	.001
	NYLON	250-400	.015	.001
	PHENOLIC	250-400	.015	.001
	GLASS FILLED	250-400	.015	.001
MAGNESIUM	AZ,AM,EZ,ZE,HK	100-200	.020	.001
ALUMINUM	2021 THRU 6061	100-200	.020	.001
COPPER		100-200	.010	.001
BRASS		200-300	.010	.001
BRONZE		200-300	.010	.001
CAST IRON		85-140	.015	.0005
STEEL	1005-1029	50-150	.015	.001
	1030-1055	50-150	.015	.001
	1060-1095	50-150	.015	.001
	10L45-10L50	50-150	.015	.001
	12L13-12L15	50-150	.015	.001
	41L30-41L50	50-150	.015	.001
	4140-4150	50-150	.015	.001
	4140 (35 HRC)	50-150	.015	.001
	8617-8622	50-150	.015	.001
	M1-M6	50-150	.015	.001
	H10-H19	50-150	.015	.001
	D2-D7	50-150	.015	.001
	A2-A9, 01-07	50-150	.015	.001
	W1, W2	50-150	.015	.001
	M-50, 52100	50-150	.015	.001
TITANIUM	TI-9AI-6V	40-65	.020	.0005
STAINLESS	405-446	65-100	.015	.001
	15-5PH, 16-6PH, 14-4 PH	65-100	.015	.001
NICKEL	NICKEL 200-300	40-100	.015	.001

### SINGLE POINT THREADING ROUGHING INFEED DEPTH PER PASS

THREADS PER INCH	8	10	11	12	13	14	16	18	20	24	28	32	36	40
PASS 1	.0171	.0148	.0148	.0134	.0124	.0114	.0110	.0110	.0099	.0094	.0079	.0083	.0072	.0083
PASS 2	.0283	.0243	.0243	.0219	.0202	.0189	.0179	.0178	.0159	.0150	.0126	.0130	.0113	.0128
PASS 3	.0372	.0318	.0318	.0287	.0264	.0244	.0233	.0231	.0206	.0194	.0163	.0167	.0145	
PASS 4	.0449	.0383	.0383	.0345	.0317	.0293	.0279	.0276	.0246	.0231	.0194			
PASS 5	.0517	.0441	.0441	.0396	.0364	.0337	.0321	.0316	.0282					
PASS 6	.0580	.0494	.0494	.0443	.0407	.0376	.0358							
PASS 7	.0637	.0543	.0543	.0486	.0447	.0413								
PASS 8	.0691	.0588	.0588											
PASS 9	.0742													

**IN MOST CASES  
A FINISH OR SPRING PASS IS  
RECOMMENDED.**

**FORMULA FOR CONVERTING SURFACE FEET PER MINUTE (SFM)  
TO REVOLUTIONS PER MINUTE (RPM)**

NOTE : ALL SPEEDS AND FEEDS LISTED HERE ARE PROVIDED FOR REFERENCE ONLY.

$$RPM = \frac{SFM \times 12}{(\pi) \times DIAMETER}$$