

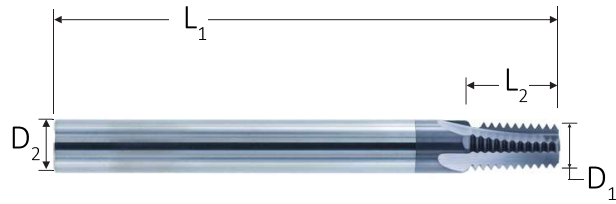
# SPEED & FEED INFORMATION

## SERIES: TM

MATERIAL	STARTING SFM	CUTTING DIAMETER									
		1/8"	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	
CHIP PER TOOTH											
<b>STAINLESS STEELS</b>		<b>ISO-M</b>									
<b>Precipitation</b> 13-8, 15-5, 17-4PH	175	0.0050	0.0010	0.0015	0.0021	0.0025	0.0030	0.0035	0.0040	0.0045	
<b>Austenitic &amp; Martensitic</b> 303, 316, 321, 304, 410, 416, 422, 430	250-350	0.0005	0.0010	0.0015	0.0020	0.0030	0.0035	0.0040	0.0045	0.0050	
<b>HIGH TEMP ALLOYS</b>		<b>ISO-S</b>									
<b>Nickel Base</b> Inconel, Hastelloy, Monel	80-130	0.0003	0.0005	0.0008	0.0010	0.0015	0.0020	0.0025	0.0030	0.0035	
<b>STEELS</b>		<b>ISO-P</b>									
<b>Medium Carbon Steel</b> 1045, 4140, 4340, 52100, <46HrC	250	0.0003	0.0005	0.0008	0.0009	0.0010	0.0015	0.0020	0.0025	0.0030	
<b>Medium Carbon Steel</b> 1030, 4130, 40140, 25-35HrC	300	0.0005	0.0010	0.0015	0.0020	0.0030	0.0035	0.0040	0.0045	0.0050	
<b>Low Carbon Steel</b> 1018, 12L-14, <25 HrC	500	0.0005	0.0010	0.0015	0.0020	0.0030	0.0035	0.0040	0.0045	0.0050	
<b>CAST IRONS</b>		<b>ISO-K</b>									
<b>Ductile Iron</b> Ductile Cast Iron	300	0.0006	0.0007	0.0010	0.0015	0.0020	0.0025	0.0030	0.0035	0.0040	
<b>Cast Iron</b> Cast Iron	350-500	0.0005	0.0006	0.0009	0.0010	0.0015	0.0020	0.0025	0.0030	0.0035	
<b>TITANIUM</b>		<b>ISO-S</b>									
<b>Titanium Alloys</b> 6AL-4V	200-250	0.0003	0.0005	0.0008	0.0010	0.0015	0.0020	0.0025	0.0030	0.0035	
<b>ALUMINUM</b>		<b>ISO-N</b>									
T-6061, T7075	1000	0.0005	0.0010	0.0015	0.0020	0.0030	0.0035	0.0040	0.0045	0.0050	
<b>BRASS</b>		<b>ISO-N</b>									
Free Machining	800	0.0005	0.0010	0.0015	0.0020	0.0030	0.0035	0.0040	0.0045	0.0050	

MATERIAL	M/MIN	CUTTING DIAMETER - METRIC									
		3.5mm	5mm	6.5mm	8mm	9.5mm	13mm	16mm	19mm	24mm	
CHIP PER TOOTH											
<b>STAINLESS STEELS</b>		<b>ISO-M</b>									
<b>Precipitation</b> 13-8, 15-5, 17-4PH	53	0.01mm	0.03mm	0.04mm	0.05mm	0.06mm	0.08mm	0.09mm	0.10mm	0.11mm	
<b>Austenitic &amp; Martensitic</b> 303, 316, 321, 304, 410, 416, 422, 430	76-107	0.01mm	0.03mm	0.04mm	0.05mm	0.08mm	0.09mm	0.10mm	0.11mm	0.13mm	
<b>HIGH TEMP ALLOYS</b>		<b>ISO-S</b>									
<b>Nickel Base</b> Inconel, Hastelloy, Monel	24-40	0.01mm	0.01mm	0.02mm	0.03mm	0.04mm	0.05mm	0.06mm	0.08mm	0.09mm	
<b>STEELS</b>		<b>ISO-P</b>									
<b>Medium Carbon Steel</b> 1045, 4140, 4340, 52100, <46HrC	76	0.01mm	0.01mm	0.02mm	0.02mm	0.03mm	0.04mm	0.05mm	0.06mm	0.08mm	
<b>Medium Carbon Steel</b> 1030, 4130, 40140, 25-35HrC	90	0.01mm	0.03mm	0.04mm	0.05mm	0.08mm	0.09mm	0.10mm	0.11mm	0.13mm	
<b>Low Carbon Steel</b> 1018, 12L-14, <25 HrC	152	0.01mm	0.03mm	0.04mm	0.05mm	0.08mm	0.09mm	0.10mm	0.11mm	0.13mm	
<b>CAST IRONS</b>		<b>ISO-K</b>									
<b>Ductile Iron</b> Ductile Cast Iron	90	0.02mm	0.02mm	0.03mm	0.04mm	0.05mm	0.06mm	0.08mm	0.09mm	0.10mm	
<b>Cast Iron</b> Cast Iron	107-152	0.01mm	0.02mm	0.02mm	0.03mm	0.04mm	0.05mm	0.06mm	0.08mm	0.09mm	
<b>TITANIUM</b>		<b>ISO-S</b>									
<b>Titanium Alloys</b> 6AL-4V	60-76	0.01mm	0.01mm	0.02mm	0.03mm	0.04mm	0.05mm	0.06mm	0.08mm	0.09mm	
<b>ALUMINUM</b>		<b>ISO-N</b>									
T-6061, T7075	305	0.01mm	0.03mm	0.04mm	0.05mm	0.08mm	0.09mm	0.10mm	0.11mm	0.13mm	
<b>BRASS</b>		<b>ISO-N</b>									
Free Machining	244	0.01mm	0.03mm	0.04mm	0.05mm	0.08mm	0.09mm	0.10mm	0.11mm	0.13mm	

**Note:** All technical data provided are suggested starting points. They may be increase or decreased depending on machine condition, depth of cut, finish required, coolant, etc. Call our TECHNICAL SERVICE Team with questions



# VARIOUS MATERIAL

MULTI FLUTE • STRAIGHT FLUTE, NPT THREAD MILLS

SERIES: TM-\_\_-NPT-S

Carbide	MULTI FLUTES	0°	AlTiN	60°		HRC <52	<table border="1"> <tr> <td>P</td> <td>K</td> </tr> <tr> <td>M</td> <td>S</td> </tr> <tr> <td>H</td> <td>N</td> </tr> </table>	P	K	M	S	H	N
P	K												
M	S												
H	N												

MIN THREAD DIA./PITCH	CUTTER DIA $D_1$	SHK $D_2$	LOC $L_2$	OAL $L_1$	FLUTE	PART NAME	AlTiN EDP
1/16-27NPT	0.218	1/4	1/2	2-1/2	4	TM-1/16-27NPT-S	17572
1/8-27NPT	0.300	5/16	19/32	3	4	TM-1/8-27NPT-S	17573
1/4-18NPT	0.360	3/8	5/8	3-1/2	4	TM-1/4-18NPT-S	17574
3/8-18NPT	0.425	7/16	3/4	4	4	TM-3/8-18NPT-S	17575
1/2-14NPT	0.490	1/2	1	4	6	TM-1/2-14NPT-S	17576
1-11.5NPT	0.620	5/8	1-1/8	4	6	TM-1-11.5NPT-S	17577
2.5-8NPT	0.990	1	1-1/2	5	6	TM-2.5-8NPT-S	17578



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