


CUTTING CONDITIONS

Threading | Thread mills | Cutting conditions

WH-VM-PNC

|  | Work Material | | Vc (m/min) | F (mm/tooth) |
|---|-----------------|--|------------|--------------|
| | | | | |
| Low Tensile Strength Steel | C~0,25% | | 60~90 | 0,02~0,08 |
| Medium Tensile Strength Steel | C~0,25% ~ 0,45% | | 60~90 | 0,02~0,08 |
| High Tensile Strength Steel | C~0,45% | | 60~90 | 0,02~0,08 |
| Alloy Steel | SCM | | 30~60 | 0,01~0,03 |
| Hardened Steel | 25~45 HRC | | 30~60 | 0,01~0,03 |
| | 45~55 HRC | | 30~60 | 0,01~0,03 |
| | 50~60 HRC | | - | - |
| Stainless Steel | SUS | | 60~90 | 0,02~0,08 |
| Tool Steel | SKD | | - | - |
| Cast Steel | SC | | 40~65 | 0,02~0,09 |
| Cast Iron | FC | | 50~100 | 0,03~0,1 |
| Ductile Cast Iron | FCD | | 50~70 | 0,03~0,1 |
| Copper | Cu | | - | - |
| Brass | Bs | | - | - |
| Brass Casting | BsC | | 50~100 | 0,02~0,06 |
| Bronze | PB | | 50~100 | 0,02~0,06 |
| Aluminium Rolled Steel | AL | | 50~100 | 0,02~0,06 |
| Aluminium Alloy Casting | AC, ADC | | 50~100 | 0,02~0,06 |
| Magnesium Alloy Casting | MC | | 50~100 | 0,02~0,06 |
| Zinc Alloy Casting | ZDC | | 50~100 | 0,02~0,06 |
| Titanium Alloy | Ti-6AL-4V | | 20~60 | 0,01~0,03 |
| Nickel Alloy | Inconel® | | 20~60 | 0,01~0,03 |
| Thermosetting plastic | - | | 50~100 | 0,02~0,06 |
| Thermoplastic | - | | 50~100 | 0,02~0,06 |