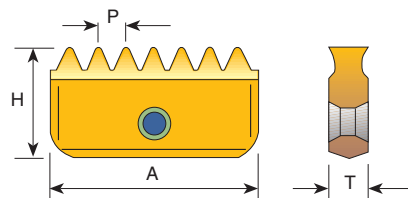
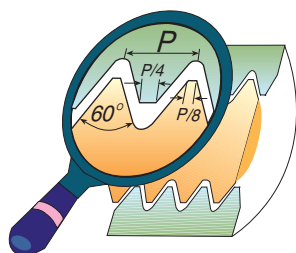


ISO



Pitch mm		Insert Size = A				
		12	14	21	30	40
0.5	Ext.					
0.5	Int.	* 12 I 0.5 ISO	14 I 0.5 ISO			
0.75	Ext.		14 E 0.75 ISO			
0.75	Int.	* 12 I 0.75 ISO	14 I 0.75 ISO			
1.0	Ext.		14 E 1.0 ISO	21 E 1.0 ISO		
1.0	Int.	* 12 I 1.0 ISO	14 I 1.0 ISO	21 I 1.0 ISO		
1.25	Ext.		14 E 1.25 ISO			
1.25	Int.	* 12 I 1.25 ISO	14 I 1.25 ISO			
1.5	Ext.		14 E 1.5 ISO	21 E 1.5 ISO	30 E 1.5 ISO	40 E 1.5 ISO
1.5	Int.	* 12 I 1.5 ISO	14 I 1.5 ISO	21 I 1.5 ISO	30 I 1.5 ISO	40 I 1.5 ISO
1.75	Ext.		14 E 1.75 ISO			
1.75	Int.		14 I 1.75 ISO	21 I 1.75 ISO		
2.0	Ext.		14 E 2.0 ISO	21 E 2.0 ISO	30 E 2.0 ISO	40 E 2.0 ISO
2.0	Int.		14 I 2.0 ISO	21 I 2.0 ISO	30 I 2.0 ISO	40 I 2.0 ISO
2.5	Ext.		14 E 2.5 ISO	21 E 2.5 ISO		
2.5	Int.		14 I 2.5 ISO	21 I 2.5 ISO		
3.0	Ext.			21 E 3.0 ISO	30 E 3.0 ISO	40 E 3.0 ISO
3.0	Int.			21 I 3.0 ISO	30 I 3.0 ISO	40 I 3.0 ISO
3.5	Ext.				30 E 3.5 ISO	
3.5	Int.			21 I 3.5 ISO	30 I 3.5 ISO	40 I 3.5 ISO
4.0	Ext.				30 E 4.0 ISO	40 E 4.0 ISO
4.0	Int.				30 I 4.0 ISO	40 I 4.0 ISO
4.5	Ext.					
4.5	Int.				30 I 4.5 ISO	40 I 4.5 ISO
5.0	Ext.					40 E 5.0 ISO
5.0	Int.				30 I 5.0 ISO	40 I 5.0 ISO
5.5	Ext.					
5.5	Int.					40 I 5.5 ISO
6.0	Ext.					40 E 6.0 ISO
6.0	Int.					40 I 6.0 ISO
H		6.3	7.5	12	16	20
T		2.9	3.1	4.7	5.5	6.3

* One cutting edge

Order example: 14 I 1.5 ISO MT7

Mill Thread Inserts Speed and Feed Selection

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed m/min MT7
P	Low and Medium Carbon Steels	115-280
	High Carbon Steels	130-200
	Alloy Steels, Treated Steels	105-180
M	Stainless Steels	130-190
	Cast Steels	150-190
K	Cast Iron	80-170
N	Non- Ferrous and Aluminum	180-340
	Synthetics, Duroplastics, Thermoplastics	115-460
S	Nickel Alloys, Titanium Alloys	25- 90

Recommended FEED RATE : 0.05 - 0.15 mm

Spiral Mill Thread Inserts Speed and Feed Selection

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed m/min MT7
P	Low and Medium Carbon Steels	145-360
	High Carbon Steels	165-255
	Alloy Steels, Treated Steels	135-230
M	Stainless Steels	165-245
	Cast Steels	190-245
K	Cast Iron	100-220
N	Non- Ferrous and Aluminum	230-440
	Synthetics, Duroplastics, Thermoplastics	145-590
S	Nickel Alloys, Titanium Alloys	30-115

Recommended FEED RATE : 0.05 - 0.15 mm

As you may note, cutting speed is shown in range terms. In most standard cases choosing a speed in the middle of the range would be a good choice for a start.

For hard metals reduce cutting speed.