

TOOL SELECTION

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CUTWEL PRO INDEXABLE THREAD MILLING INSERTS METRIC, UNC, UNF, BSW, BSP, BSF, BSPT, NPT & NPTF		1028
CUTWEL PRO INDEXABLE THREAD MILLING HOLDERS SINGLE TOOTH, 2 TOOTH AND 5 TOOTH		1031
VARDEX STANDARD INDEXABLE THREAD MILLING INSERTS METRIC, UNC, UNF, BSW, BSF, BSPT, NPT, NPTF & PG		1033
VARDEX STANDARD INDEXABLE THREAD MILLING HOLDERS STRAIGHT FLUTE & CONICAL FLUTE • STANDARD LENGTH, LONG LENGTH, TWIN FLUTE & TWIN OFFSET		1038
VARDEX DEEP HOLE INDEXABLE THREAD MILLING INSERTS METRIC, UNC, UNF, 60° PARTIAL PROFILE, 55° PARTIAL PROFILE, NPT & NPTF		1040
VARDEX DEEP HOLE INDEXABLE THREAD MILLING HOLDERS STEEL & CARBIDE SHANK		1045

CUTWEL PRO THREAD MILL RECOMMENDED CUTTING CONDITIONS

Group	WORKPIECE Material	Cutting Speed (m/min)	Feed Rate (mm)
P Steel	Low and Medium Carbon Steels	115-280	0.05 - 0.15
	High Carbon Steels	130-200	
	Alloy Steels, Treated Steels	105-180	
M Stainless Steel	Stainless Steels	130-190	
	Cast Steels	150-190	
S HRSA's	Nickel Alloys and Titanium Alloys	25-90	
K Cast Iron	Cast Iron	80-70	
N Non Ferrous	Non-Ferrous and Aluminium	180-340	
	Synthetics, Duroplastics and Thermoplastics	115-460	