

### AccuThread™ T3 | Imperial (inch)

ISO	Material	Hardness (BHN)	Speed (SFM)	Chipload per Tooth (IPT) by Cutter Diameter					
				0.055 to 0.125	0.126 to 0.188	0.189 to 0.250	0.251 to 0.312	0.313 to 0.375	0.376 to 0.500
P	Free Machining Steel 1118, 1215, 12L14, etc.	100 - 150	375	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
		150 - 200	275	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
		200 - 250	225	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
	Low Carbon Steel 1010, 1020, 1025, 1522, 1144, etc.	85 - 125	375	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
		125 - 175	275	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
		175 - 225	225	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
	Medium Carbon Steel 1030, 1040, 1050, 1527, 1140, 1151, etc.	225 - 275	200	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
		125 - 175	225	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
		175 - 225	200	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
	Alloy Steel 4140, 5140, 8640, etc.	225 - 275	175	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
		275 - 325	150	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
		325 - 375	125	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
		125 - 175	225	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
		175 - 225	200	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
	High Strength Alloy 4340, 4330V, 300M, etc.	225 - 275	175	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
		275 - 325	150	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
		325 - 375	125	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
	Structural Steel A36, A285, A516, etc.	225 - 300	175	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
300 - 350		150	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026	
350 - 400		125	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026	
Tool Steel H-13, H-21, A-4, O-2, S-3, etc.	100 - 150	225	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030	
	150 - 250	200	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030	
	250 - 350	150	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030	
S	High Temp Alloy Hastelloy B, Inconel 600, etc.	150 - 200	175	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
		200 - 250	125	0.0008	0.0010	0.0012	0.0016	0.0020	0.0026
	Titanium Alloy	140 - 220	100	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
		220 - 310	75	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
	Aerospace Alloy S82	185 - 275	100	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
		275 - 350	75	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
M	Stainless Steel 416, 420, etc.	140 - 220	100	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
		220 - 310	75	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
	Stainless Steel 300 Series 304, 316, 17-4PH, etc.	185 - 275	100	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
		275 - 350	75	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
	Super Duplex Stainless Steel	135 - 185	125	0.0008	0.0010	0.0012	0.0016	0.0018	0.0020
185 - 275		75	0.0008	0.0010	0.0012	0.0016	0.0018	0.0020	
H	Hardened Steels	135 - 185	125	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
		185 - 275	75	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
K	Cast Iron Grey, Ductile, Nodular	45 - 50	175	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
		50 - 55	125	0.0006	0.0008	0.0012	0.0016	0.0018	0.0020
		120 - 150	275	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
		150 - 200	250	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
		200 - 220	225	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
N	Wrought Aluminum	220 - 260	200	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
		260 - 320	200	0.0008	0.0010	0.0014	0.0018	0.0020	0.0030
		30	500	0.0010	0.0012	0.0018	0.0020	0.0030	0.0040
		180	450	0.0010	0.0012	0.0018	0.0020	0.0030	0.0040
Cast Aluminum	30 - 180	250	0.0010	0.0012	0.0018	0.0020	0.0030	0.0040	
	Brass	30 - 100	500	0.0010	0.0012	0.0018	0.0020	0.0030	0.0040