

Speeds and Feeds



Haas Micro Thread			◎ : Excellent	Inch and Metric	
			○ : Good	Threading	
ISO	VDI 3323	Material Description	Recommend	Speeds	
P	1~5	Non-alloy steel	◎	SFM (ft/min)	558 ~ 656
				Vc (m/min)	170 ~ 200
	6~9	Low alloy steel	◎	SFM (ft/min)	312 ~ 525
				Vc (m/min)	95 ~ 160
	10~11	High-Alloyed Steel	◎	SFM (ft/min)	279 ~ 312
				Vc (m/min)	105 ~ 140
M	12~13	Ferritic & Martensitic	○	SFM (ft/min)	344 ~ 459
				Vc (m/min)	105 ~ 140
	14	Austenitic Stainless Steel	○	SFM (ft/min)	312 ~ 427
				Vc (m/min)	95 ~ 130
K	15~16	Grey cast iron	◎	SFM (ft/min)	459 ~ 623
				Vc (m/min)	140 ~ 190
	17~18	Nodular cast iron	◎	SFM (ft/min)	459 ~ 623
				Vc (m/min)	140 ~ 190
N	21~30	Non-Ferrous Metals (Al)		SFM (ft/min)	
				Vc (m/min)	
S	31~37	Superalloys & Titanium	○	SFM (ft/min)	33 ~ 246
				Vc (m/min)	10 ~ 75
H	38~41	Hard Materials		SFM (ft/min)	
				Vc (m/min)	

Pitch	mm	0.5	0.75	1	1.25	1.5	1.75
	tpi	48	32	24	20	16	14
No. of Passes		6~9	6~11	6~12	8~14	9~15	11~18