THREAD CUTTING DATA

VARDEX

WORK PIECE MATERIAL			HARDNESS HB	SURFACE SPEED COATED m/min	SURFACE SPEED UNCOATED m/min
P STEEL	Carbon Steel	Low Carbon (C=0.1-0.25 %)	125	115-190	
		Medium Carbon (C=0.25-0.55 %)	150	100-175	
		High Carbon (C=0.55-0.85 %)	170	90-165	
	Low Alloy Steel (Alloying Elements ≤ 5%)	Non Hardened	180	100-180	
		Hardened	275	75-140	
		Hardened	350	70-135	
	High Alloy Steel (Alloying Elements > 5%)	Annealed	200	80-120	
		Hardened	325	50-100	
	Cast Steel	Low Alloy (Alloying Elements <5%)	200	70-130	
		High Alloy (Alloying Elements >5%)	225	60-120	
M STAINLESS STEEL	Stainless Steel Ferritic	Non Hardened	200	70-130	
		Hardened	330	60-117	
	Stainless Steel Austenitic	Austenitic	180	90-140	
		Super Austenitic	200	40-110	
	Stainless Steel Cast Ferritic	Non Hardened	200	90-120	
		Hardened	330	65-110	
	Stainless Steel Cast Austenitic	Austenitic	200	85-110	
		Hardened	330	60-100	
K CAST IRON	Malleable Cast Iron	Ferritic (Short Chips)	130	60-70	
		Pearlitic (Long Chips)	230	60-145	
	Gray Cast Iron	Low Tensile Strength	180	70-130	
		High Tensile Strength	260	60-115	
	Nodular Sg Iron	Ferritic	160	126-160	
		Pearlitic	260	90-120	
N NON-FERROUS	Aluminum Alloy Wrought	Non Aging	60	100-365	100-250
		Aged	100	80-220	80-160
	Aluminium Alloy	Cast	75	200-400	80-120
		Cast & Aged	90	200-280	70-100
		Cast Si 13-22%	130	60-180	50-120
	Copper & Copper Alloy	Brass	90	80-225	70-170
		Bronze & Non Leaded Copper	100	80-255	70-170
S HRSA	High Temperature Alloy	Annealed (Iron Based)	200	45-60	30-50
		Aged (Iron Based)	280	30-50	25-40
		Annealed (Nickel Or Cobalt Based)	250	20-30	20-30
		Aged (Nickel Or Cobalt Based)	350	15-25	15-25
	Titanium Alloy	Pure 99.5 Ti	400Rm	140-170	60-100
		A+B Alloys	1050Rm	50-70	40-60
H HARD MATERIALS	Hardened Steel	Hardened & Tempered Steel	45-50HRc	45-60	
			51-55HRc	40-50	

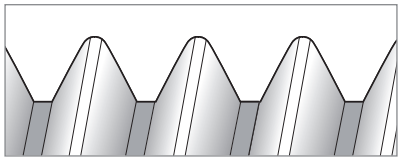
Calculating RPM

- **RPM**

$$n = \frac{vc \times 1000}{\pi \times Dia}$$

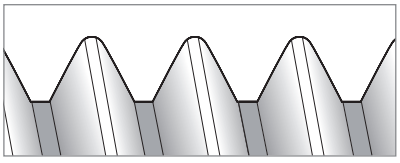
Thread Hand

LEFT-HAND THREAD



A thread which when viewed axially, winds in an anti-clockwise and receding direction (LH).

RIGHT-HAND THREAD



A thread which when viewed axially, winds in a clockwise and receding dIrection (RH).