



## List 16620/16625 - A Brand AT-1

## List 16630/16631 - A Brand AT-1 NPT/NPTF

Work Material		Cutting Speed (SFM)	Feed Rate (in/t)
Low Carbon Steel	~C0.25%	260 - 790	0.0004 - 0.002
Medium Carbon Steel	C0.25%~0.45%	260 - 790	0.0004 - 0.002
High Carbon Steel	C0.45%~	260 - 790	0.0004 - 0.002
Alloy Steel	4140, 4340, 8620	200 - 650	0.0004 - 0.002
Hardened Steel	25-45 HRC	260 - 650	0.0004 - 0.002
	45-55 HRC	-	-
	50-60 HRC	-	-
Stainless Steel	300-series, 400-series	200 - 790	0.0004 - 0.002
Tool Steel	D2, H13, A6	-	-
Cast Steel	-	200 - 790	0.0004 - 0.002
Cast Iron	-	260 - 790	0.0004 - 0.002
Ductile Cast Iron	-	200 - 790	0.0004 - 0.002
Copper	-	260 - 790	0.001 - 0.004
Brass	B21, B36	260 - 790	0.001 - 0.004
Brass Casting	B62	260 - 790	0.001 - 0.004
Bronze	B124, B103, B159	260 - 790	0.001 - 0.004
Aluminum	6061, 7075, 2014	260 - 790	0.001 - 0.004
Aluminum Alloy Casting	-	330 - 1000	0.002 - 0.008
Magnesium Alloy Casting	-	330 - 1000	0.002 - 0.008
Zinc Alloy Casting	-	330 - 1000	0.002 - 0.008
Titanium Alloy	Ti-6Al-4V	-	-
Nickel Alloy	Inconel	-	-
Thermosetting Plastic	-	260 - 650	0.001 - 0.004
Thermo Plastic	-	260 - 650	0.001 - 0.004

1. The indicated speeds and feeds are for water-soluble coolant.
2. Water-soluble coolant is not suitable for threading magnesium alloy.
3. Please adjust the cutting conditions depending on the rigidity of the machine, tool holders, and workpiece clamping.
4. If the threading length is long, or when machining a large-pitch thread, reduce the feed rate and take multiple passes.
5. If a machined parallel internal thread is tapered and prevents the go-gauge from going through, add a zero cut/spring pass.

