



### List 41000/41100 - EXOCARB® Thread Mill

### List 41050/41150 - EXOCARB® Thread Mill Oil

### List 42000/42001 - EXOCARB® Thread Mill NPT/NPTF

Work Material	SFM	Feed Rate (Inch/Tooth)	No. of Passes
Low Carbon Steel	300 - 420	0.0016 - 0.0050	1
Medium Carbon Steel	300 - 420	0.0016 - 0.0050	1
High Carbon Steel	250 - 420	0.0016 - 0.0050	1
Alloy Steel	180 - 350	0.0008 - 0.0040	1-2
Heat Treated Steel (28-34HRC)	160 - 300	0.0008 - 0.0040	1
Heat Treated Steel (34-40HRC)	130 - 260	0.0004 - 0.0040	1-2
Heat Treated Steel (40-50HRC)	65 - 250	0.0004 - 0.0040	2-4
Stainless Steel (300 - Series)	200 - 450	0.0016 - 0.0060	1-2
Stainless Steel (400 - Series)	165 - 400	0.0016 - 0.0060	1-2
Stainless Steel (15-5, 17-4PH)	130 - 350	0.0016 - 0.0060	2
Cast Iron	250 - 400	0.0008 - 0.0035	1
Ductile Cast Iron	210 - 280	0.0012 - 0.0040	1
Aluminum Alloy	300 - 500	0.0012 - 0.0040	1
Aluminum Alloy Casting Si [12]%	280 - 550	0.0012 - 0.0050	1
Aluminum Alloy Casting Si [12-16]%	250 - 460	0.0012 - 0.0040	1
Aluminum Alloy Casting with Si [16-20]%	210 - 400	0.0012 - 0.0040	1
Aluminum Alloy Casting with Si [20-25]%	200 - 350	0.0012 - 0.0040	1
Copper, Copper Casting	300 - 510	0.0012 - 0.0040	1
Brass, Brass Casting	300 - 510	0.0012 - 0.0040	1
Bronze, Bronze Casting (C6***,PB,PBC)	300 - 500	0.0012 - 0.0040	1
Magnesium Alloy Casting	210 - 410	0.0012 - 0.0050	1
Zinc Alloy Casting	180 - 380	0.0012 - 0.0050	1
Titanium Alloy (Ti-6Al-4V)	100 - 330	0.0012 - 0.0025	2
High Heat Resistance Alloy (Inconel)	65 - 260	0.0008 - 0.0020	2
High Heat Resistance Alloy (Inconel >40HRC)	65 - 200	0.0008 - 0.0020	4
Thermoplastic	220 - 510	0.0012 - 0.0050	1
Cobalt/Chrome Alloy (Stellite)	65 - 200	0.0016 - 0.0060	3

For chip loads, the smaller cutter diameters use a smaller chip load per tooth within a given range.  
Larger cutter diameters use the larger chip load per tooth within the given range.  
For programming help or other information, please contact our Engineering Department at 800-837-2223.

