



Thread Injector High Performance Threadmills Technical Information



- RedLine Thread Injector High Performance Threadmills are geared for top performance in a variety of different materials
- Designed to cut internal and external threads for greater versatility.
- With our free cutting geometry and AlTiN coating, you can count on RedLine threadmills to give you high performance, and long tool life at an extremely attractive price.

Threadmills Speeds & Feeds & Feedrate Adjustments

Workpiece Material	Speed (SFM)	Feedrate (Inches/Tooth) Per Cutting Tool Diameter						
		1/8	3/16	1/4	5/16	3/8	1/2	5/8
Aluminum	800-1400	.0005-.0010	.0010-.0015	.0015-.0025	.0020-.0030	.0030-.0045	.0035-.0055	.0050-.0070
Brass	600-800	.0005-.0010	.0010-.0015	.0015-.0025	.0020-.0030	.0030-.0045	.0035-.0045	.0050-.0060
Bronze	500-600	.0005-.0010	.0010-.0015	.0015-.0025	.0020-.0030	.0030-.0045	.0035-.0045	.0050-.0060
Cast Iron-Hard	200-300	.0003-.0006	.0005-.0010	.0008-.0015	.0010-.0020	.0015-.0025	.0020-.0030	.0030-.0040
Cast Iron-Soft	250-350	.0004-.0008	.0007-.0013	.0007-.0013	.0015-.0020	.0020-.0030	.0020-.0040	.0030-.0050
Hard Bronze	200-300	.0004-.0008	.0007-.0012	.0010-.0020	.0010-.0020	.0015-.0025	.0020-.0030	.0030-.0040
High Alloy Steel >25RC	250-400	.0003-.0006	.0005-.0010	.0008-.0015	.0020-.0020	.0015-.0025	.0020-.0030	.0030-.0040
Inconel	60-100	.0003-.0006	.0005-.0010	.0008-.0015	.0010-.0020	.0015-.0025	.0015-.0025	.0020-.0030
Low Alloy Steel <25RC	350-500	.0005-.0010	.0010-.0015	.0015-.0025	.0020-.0030	.0025-.0035	.0030-.0040	.0040-.0050
Magnesium	800-1400	.0005-.0010	.0010-.0015	.0015-.0025	.0020-.0030	.0030-.0045	.0035-.0055	.0050-.0070
Stainless	150-250	.0004-.0008	.0007-.0010	.0010-.0015	.0015-.0020	.0020-.0035	.0030-.0040	.0030-.0050
Titanium	80-150	.0003-.0006	.0005-.0010	.0008-.0015	.0010-.0020	.0015-.0025	.0015-.0025	.0025-.0035

NOTES: Speeds and Feeds listed are estimated and will vary by application.

Threadmill Calculation Formulas

Feedrate Adjustment	$\frac{(\text{Thread Major Diameter}) - (\text{Threadmill Diameter})}{(\text{Thread Major Diameter})} \times \text{Linear Feedrate}$
RPM	$\frac{3.8}{(\text{Threadmill Diameter})} \times \text{SFM}$
Linear IPM	$(\text{Inches per Tooth}) \times (\text{Number of Flutes}) \times \text{RPM}$

