



AlTiN Coated

UN Thread Internal & External

Size	Cutting ø	Thread Lgth	OAL	Shk ø	# Flutes	AlTiN Coated	
						Part #	Item #
6-32	.100	.218	2	1/8	3	RM20101	1
8-32	.115	.250	2	1/8	3	RM20103	2
8-36	.115	.250	2	1/8	3	RM20105	3
10-24	.120	.312	2	3/16	3	RM20107	4
10-32	.120	.312	2	3/16	3	RM20109	5
1/4-20	.180	.500	2-1/2	3/16	3	RM20111	6
1/4-28	.180	.500	2-1/2	3/16	3	RM20113	7
5/16-18	.240	.625	2-1/2	1/4	3	RM20115	8
5/16-24	.240	.625	2-1/2	1/4	3	RM20117	9
3/8-16	.290	.750	3	5/16	4	RM20119	10
3/8-24	.290	.750	3	5/16	4	RM20121	11
7/16-14	.340	.875	3	3/8	4	RM20123	12
7/16-20	.340	.875	3	3/8	4	RM20125	13
1/2-13	.350	.875	3-1/2	3/8	4	RM20127	14
1/2-20	.350	.875	3-1/2	3/8	4	RM20129	15
9/16-12	.370	.875	3-1/2	1/2	4	RM20131	16
9/16-18	.370	.875	3-1/2	1/2	4	RM20133	17
5/8-11	.470	1.250	3-1/2	1/2	5	RM20135	18
5/8-18	.470	1.250	3-1/2	1/2	5	RM20137	19
3/4-10	.495	1.250	3-1/2	1/2	5	RM20139	20
3/4-16	.495	1.250	3-1/2	1/2	5	RM20141	21
7/8-9	.620	1.250	3-1/2	5/8	5	RM20143	22
7/8-14	.620	1.250	3-1/2	5/8	5	RM20145	23
1-8	.620	1.375	4	3/4	5	RM20147	24
1-12	.620	1.375	4	3/4	5	RM20149	25

Cutting Diameter Tolerances
+.000, -.002



Technical data found on page 114.





AITiN Coated

NPT Pipe Thread Internal & External

Size	Cutting ϕ	Thread Lgth	OAL	Shk ϕ	# Flutes	AITiN Coated	
						Part #	Item #
1/16-27	.245	.437	2-1/2	1/4	3	RM20200	1
1/8-27	.310	.437	2-1/2	5/16	4	RM20202	2
1/4-18	.305	.625	3	3/8	4	RM20204	3
3/8-18	.305	.625	3	3/8	4	RM20206	4
1/2-14	.495	.875	3-1/2	1/2	4	RM20208	5
3/4-14	.495	.875	3-1/2	1/2	4	RM20210	6
1-11-1/2	.620	1.125	4	3/4	5	RM20212	7



AITiN Coated

NPTF Pipe Thread Internal & External

Size	Cutting ϕ	Thread Lgth	OAL	Shk ϕ	# Flutes	AITiN Coated	
						Part #	Item #
1/16-27	.245	.437	2-1/2	1/4	3	RM20301	8
1/8-27	.310	.437	2-1/2	5/16	4	RM20303	9
1/4-18	.305	.625	3	3/8	4	RM20305	10
3/8-18	.305	.625	3	3/8	4	RM20307	11
1/2-14	.495	.875	3-1/2	1/2	4	RM20309	12
3/4-14	.495	.875	3-1/2	1/2	4	RM20311	13
1-11-1/2	.620	1.125	4	3/4	5	RM20313	14



Technical data found on page 114.





AlTiN Coated

Metric Thread Internal & External

Size	Cutting ø	Thread Lgth	OAL	Shk ø	# Flutes	AlTiN Coated	
						Part #	Item #
M4 X .70	.115	.250	2	1/8	3	RM20420	1
M4.5 X .75	.120	.250	2	1/8	3	RM20422	2
M5 X .80	.120	.312	2	3/16	3	RM20424	3
M6 X 1.00	.170	.500	2-1/2	3/16	3	RM20426	4
M8 X .75	.235	.625	2-1/2	1/4	3	RM20428	5
M8 X 1.00	.235	.625	2-1/2	1/4	3	RM20430	6
M8 X 1.25	.235	.625	2-1/2	1/4	3	RM20432	7
M10 X 1.25	.300	.750	3	5/16	4	RM20434	8
M10 X 1.50	.300	.750	3	5/16	4	RM20436	9
M12 X 1.00	.360	.875	3-1/2	3/8	4	RM20438	10
M12 X 1.25	.360	.875	3-1/2	3/8	4	RM20440	11
M12 X 1.75	.360	.875	3-1/2	3/8	4	RM20442	12
M14 X 1.50	.360	.875	3-1/2	3/8	4	RM20444	13
M16 X 2.00	.470	1.250	3-1/2	1/2	5	RM20446	14
M18 X 2.50	.470	1.250	3-1/2	1/2	5	RM20448	15
M20 X 3.00	.470	1.250	3-1/2	5/8	5	RM20450	16

Cutting Diameter Tolerances
+.000, -.002



Technical data found on page 114.





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	$(\text{Inches per Tooth}) \times (\text{Number of Flutes}) \times \text{RPM}$

