



Thread Injector High Performance End or Side Coolant Threadmills Technical Information

- RedLine Thread Injector High Performance Coolant Fed Threadmills are geared for top performance in a variety of different materials
- Coolant Fed Threadmills found on pages 343, 347 & 349.

End or Side Coolant Threadmills Speeds & Feeds

| Material | Grades | SFM | Threadmill Diameter (IPT) | | | | | | | | |
|-----------------------------|--|---------|---------------------------|----------------|-----------------|----------------|-----------------|----------------|----------------|----------------|----------------|
| | | | 1/16 (.0625) | 1/8 (.1250) | 3/16 (.1875) | 1/4 (.2500) | 5/16 (.3125) | 3/8 (.3750) | 1/2 (.5000) | 5/8 (.6250) | 3/4 (.7500) |
| P - Steels | | | | | | | | | | | |
| High Strength Tool Steel | A2, D2, P20, H11, H13, S2, 01 | 400 | .0001 | .0001 | .0001 | .0002 | .0004 | .0010 | .0012 | .0015 | .0020 |
| Low Carbon | A36, 12L14, 12L15, 1005, 1018, 1020, 1108-1119, 1213-1215, 1513-1518, 4012, 5015, 9310 | 600 | .0025 | .0030 | .0030 | .0040 | .0050 | .0050 | .0060 | .0060 | .0060 |
| Medium Carbon | 1040-1095, 1140-1151, 1330-1345, 1520-1572, 4023-4063, 4120-4161, 4330-4340, 4620-4640, 8620-8660, 8740-8750, 6150, 51000, 52100 | 525-575 | .0010 | .0003-.0010 | .0003-.0030 | .0005-.0020 | .0006-.0030 | .0007-.0030 | .0010-.0040 | .0015-.0040 | .0015-.0040 |
| M - Stainless Steels | | | | | | | | | | | |
| Austenitic | 301-304L, 310, 316L, 321, 347 | 525 | .0008 | .0010 | .0010 | .0015 | .0015 | .0020 | .0030 | .0030 | .0040 |
| Martensitic | 403, 410, 416, 420, 430, 431, 440 | 550 | .0008 | .0010 | .0010 | .0015 | .0015 | .0020 | .0030 | .0030 | .0040 |
| Precipitation Hardening | 12/8, 15/5, 17/4, AM-350/355/363, PH13-8MO, PH14-8/MO | 300 | .0008 | .0010 | .0010 | .0010 | .0015 | .0015 | .0020 | .0020 | .0020 |
| K - Cast Irons | | | | | | | | | | | |
| Ductile | A536, J434, 60-40-18 | 600 | .0010 | .0010 | .0015 | .0015 | .0020 | .0030 | .0040 | .0040 | .0040 |
| Gray | A48, A436, A319, Class 20, G4000 | 600 | .0010 | .0010 | .0015 | .0015 | .0020 | .0030 | .0040 | .0040 | .0040 |
| Malleable | A220, A602, J158 | 600 | .0010 | .0010 | .0015 | .0015 | .0020 | .0030 | .0040 | .0040 | .0040 |
| N - Non-Ferrous | | | | | | | | | | | |
| Aluminum Alloys | 2014, 2024, 6061, 7075 | 1700 | .0015 | .0020 | .0020 | .0030 | .0030 | .0040 | .0050 | .0050 | .0050 |
| Aluminum High Silicon | A380, A390 | 450 | .0004 | .0005 | .0010 | .0015 | .0020 | .0020 | .0025 | .0030 | .0050 |
| Brass/Bronze | Aluminum Bronze, Low Silicon Bronze | 1700 | .0010 | .0020 | .0020 | .0030 | .0030 | .0040 | .0050 | .0050 | .0050 |
| Composites | G-10, Fiberglass, Graphite, Graphite Epoxy, Plastics | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A | N/A |
| Copper | | 1000 | .0004 | .0004 | .0005 | .0006 | .0006 | .0008 | .0010 | .0012 | .0012 |
| Magnesium | | 1000 | .0004 | .0010 | .0010 | .0020 | .0020 | .0020 | .0030 | .0050 | .0050 |
| S - High Temp Alloys | | | | | | | | | | | |
| Cobalt Base | Stellite, HS-21, Haynes 25/188, X40, L605 | 150 | .0001 | .0002 | .0004 | .0005 | .0005 | .0007 | .0008 | .0010 | .0012 |
| Iron Base | Incoloy 800-802, Multmet N-155, Timkin 16-25-6, Carpenter 22-b3 | 150 | .0001 | .0002 | .0004 | .0005 | .0005 | .0007 | .0008 | .0010 | .0012 |
| Nickel Base | Inconel 625/718, Inco 700, 713C, 718, Monel 400-401, 404, K401, Rene, Rene 41 & 95 Hastelloy, Waspoloy, Udimet 500 & 700 | 120 | .0005 | .0005 | .0005 | .0010 | .0010 | .0015 | .0020 | .0020 | .0020 |
| Titanium | Commercially Pure, 6Al-4V, ASTM 1/2/3, 6Al-25N-4Zr-2Mo-Si, Ti-8Al-1Mo, Ti-8Al-4Mo | 100 | .0005 | .0005 | .0005 | .0010 | .0010 | .0015 | .0020 | .0020 | .0020 |

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