



### Indicative cutting speed for thread inserts

Indicative cutting speed (m/min)	
Material	U35 (P30 P45 TIALN)
Steel < 750 N/mm <sup>2</sup>	120 – 160
Steel < 1200 N/mm <sup>2</sup>	90 - 140
Stainless steel < 900 N/mm <sup>2</sup>	80 – 120