

Exors of James **MILLS** Ltd.  
SUBSIDIARY OF GKN ROLLED & BRIGHT STEEL LTD

**BREDBURY STEEL WORKS**  
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**MACHINING STEELS WITH H.S.S. TOOLS**

(Revised June 1968)

CARBON AND FREE CUTTING STEELS									
Steel Group	Mills Steel Code	BS 970 Code	Mills Trade Name or Specification	Typical Surface Speed Range (Ft./Min.)		Average Relative Machinability		Approx. price ratio within each group	
				Coarse Feeds	Fine Feeds	General Datum Mills 1 = 100	Group Datum = 100	Wire	Bar
Free-Cutting Mild Steels	Mills 1	En 1A	Super Free Cutting	190	250	100	100	100	100
	Mills 1X		Super Free Cutting X	210	275	110	110	103	103
	Mills L1	En 1A	Ledloy Free Cutting	250	320	130	130	106	107
	Mills L1X		Ledloy Free Cutting X	275	350	143	143	109	109
	Mills L1B Mills TL1X	En 1B	Ledloy Four-Five Telstar	310 350	400 450	162 182	162 182	115 126	115 129
Mild Steels	Mills 3	En 3B	En 3B	105	135	55	100	100	100
	Mills L3	En 3B	Ledloy En 3B	135	175	71	130	107	107
	Mills TL 3	En 3B	Teled En 3B	190	250	100	182	128	130
0.40% Carbon Steels	Mills 8	En 8	En 8	85	110	45	100	100	100
	Mills L8	En 8	Ledloy En 8	110	145	58	130	106	106
	Mills TL8	En 8	Teled En 8	155	200	82	182	126	127
Sulphurised 0.40% Carbon Steels	Mills 8M	En 8M	En 8M	110	145	58	130	124	116
	Mills L8M	En 8M	Ledloy En 8M	145	190	76	169	130	122
	Mills TL8M	En 8M	Teled En 8M	205	260	106	236	150	143

**NOTES:**

- The trade mark **LEDLOY** denotes that the steel contains an appropriate addition of lead.
- The trade marks **TELSTAR** and **TELED** denote that the steel contains lead and tellurium.
- The following are classed as wires: Rounds, any size under 17/32" dia.; Squares, any size under 1/2" sq. Hexagons, any size under .438" A/F. All greater sizes are classed as bars.
- Similar machining data for many other qualities can be obtained from our Technical Sales Department.
- Threading speeds: Tapping and Diehead, 1/2 to 1 above speeds, depending on pitch.  
Nut Tapping, 1/3 to 2/3 above speeds, depending on pitch.

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