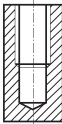
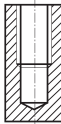


HOLE TYPE			
			
Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD
TM6716	TB0116	TM6816	TB0216

VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)			
P	1-5	Non-alloy Steel	<25	Emulsion	6-20	6-20	6-20
	6-9	Low alloy Steel	25-35	Emulsion	6-15	6-15	6-15
M	12-13	Ferritic / Martensitic Stainless steel		Neat oil	5-10	5-10	5-10
K	17-20	Nodular & Malleable Cast iron		Neat oil or Emulsion	5-15	5-15	5-15
N	21-25	Aluminium		Emulsion	10-20	10-20	10-20
	26-28	Copper & Copper alloys		Emulsion	15-35	15-35	15-35

► Lighter text denotes secondary application

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up.
 The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.