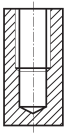
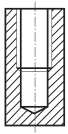
# TM1316 CUTTING DATA

| | | | | | HOLE TYPE | | | | |
|---|---|---|---|---|---|---|---|---|---|
| | | | | |  Max 3.0xD |  Max 3.0xD |  Max 2.0xD |  Max 2.5xD |  Max 2.5xD |
| | | | | | **TM0416** | **TM1817** | **TM5016** | **TM1316** | **TM1917** |
| VDI MATERIAL GROUP | | | HRc | COOLANT TYPE | **vc (m/min)** | | | | |
| **P** | 1-5 | Non-alloy Steel | <25 | Emulsion | **6-20** | **10-25** | **10-20** | **6-20** | **10-25** |
| | 6-9 | Low alloy Steel | 25-35 | Emulsion | **6-15** | **10-20** | **10-15** | **6-15** | **10-20** |
| **M** | 12-13 | Ferritic / Martensitic Stainless steel | | Neat oil | 5-10 | 8-13 | - | 5-10 | 8-13 |
| **K** | 17-20 | Nodular & Malleable Cast iron | | Neat oil or Emulsion | **5-15** | **8-20** | 5-15 | **5-15** | **8-20** |
| **N** | 21-25 | Aluminium | | Emulsion | **10-20** | **15-25** | 10-15 | **10-20** | **15-25** |
| | 26-28 | Copper & Copper alloys | | Emulsion | 15-35 | 20-40 | 8-35 | 15-35 | 20-40 |

▶ 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.