

# TM1416 CUTTING DATA



HOLE TYPE				
Max 3.0xD	Max 3.0xD	Max 2.0xD	Max 2.5xD	Max 2.5xD
<b>TM0416</b>	<b>TM1817</b>	<b>TM5016</b>	<b>TM1416</b>	<b>TM1917</b>

VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)					
<b>P</b>	1-5	Non-alloy Steel	<25	Emulsion	<b>6-20</b>	<b>10-25</b>	<b>10-20</b>	<b>6-20</b>	<b>10-25</b>
	6-9	Low alloy Steel	25-35	Emulsion	<b>6-15</b>	<b>10-20</b>	<b>10-15</b>	<b>6-15</b>	<b>10-20</b>
<b>M</b>	12-13	Ferritic / Martensitic Stainless steel		Neat oil	5-10	8-13	-	5-10	8-13
<b>K</b>	17-20	Nodular & Malleable Cast iron		Neat oil or Emulsion	<b>5-15</b>	<b>8-20</b>	5-15	<b>5-15</b>	<b>8-20</b>
<b>N</b>	21-25	Aluminium		Emulsion	<b>10-20</b>	<b>15-25</b>	10-15	<b>10-20</b>	<b>15-25</b>
	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.