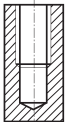
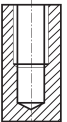
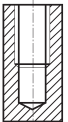


HOLE TYPE				
				
Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD	Max 2.5xD
TM3630	TM6430	TM2630	TM3830	TM6530

VDI MATERIAL GROUP	HRc	COOLANT TYPE
P		
1-5	Non-alloy Steel	<25
6-9	Low alloy Steel	25-35
M		
12-13	Ferritic / Martensitic Stainless steel	Neat oil
14	Austenitic Stainless steel	Neat oil

vc (m/min)				
10-20	10-20	10-20	10-20	10-20
10-15	10-15	10-15	10-15	10-15
5-10	5-10	5-10	5-10	5-10
4-6	4-6	4-6	4-6	4-6

► 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.