

# TM2930 CUTTING DATA



HOLE TYPE				
Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD	Max 2.5xD
<b>TM8053</b>	<b>TM3130</b>	<b>TM8153</b>	<b>TM2830</b>	<b>TM2930</b>

VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)					
<b>P</b>	1-5	Non-alloy Steel	<25	Emulsion	<b>15-25</b>	<b>10-20</b>	<b>15-25</b>	<b>10-20</b>	<b>10-20</b>
	6-9	Low alloy Steel	25-35	Emulsion	15-20	10-15	15-20	10-15	10-15
<b>M</b>	12-13	Ferritic / Martensitic Stainless steel		Neat oil	<b>8-13</b>	<b>5-10</b>	<b>8-13</b>	<b>5-10</b>	<b>5-10</b>
	14	Austenitic Stainless steel		Neat oil	<b>6-8</b>	<b>4-6</b>	<b>6-8</b>	<b>4-6</b>	<b>4-6</b>
<b>S</b>	31-35	HRSA Fe & Ni/Co Based		Neat oil	10-15	-	10-15	-	-
	36-37	Titanium & Titanium alloys		Neat oil	10-15	-	10-15	-	-

► 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.