

# TM3416 CUTTING DATA



HOLE TYPE			
Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD
<b>TM3316</b>	<b>TM6416</b>	<b>TM3416</b>	<b>TM6516</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>6-20</b>	<b>6-20</b>	<b>6-20</b>
	6-9	Low alloy Steel	25-35	Emulsion	<b>6-15</b>	<b>6-15</b>	<b>6-15</b>	<b>6-15</b>
<b>M</b>	12-13	Ferritic / Martensitic Stainless steel		Neat oil	5-10	5-10	5-10	5-10
<b>K</b>	17-20	Nodular & Malleable Cast iron		Neat oil or Emulsion	<b>5-15</b>	<b>5-15</b>	<b>5-15</b>	<b>5-15</b>
<b>N</b>	21-25	Aluminium		Emulsion	<b>10-20</b>	<b>10-20</b>	<b>10-20</b>	<b>10-20</b>
	26-28	Copper & Copper alloys		Emulsion	15-35	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.