

HOLE TYPE				
Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD	Max 2.5xD
<b>TM3630</b>	<b>TM6430</b>	<b>TM2530</b>	<b>TM3830</b>	<b>TM6530</b>

VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)					
<b>P</b>	1-5	Non-alloy Steel	<25	Emulsion	<b>10-20</b>	<b>10-20</b>	<b>10-20</b>	<b>10-20</b>	<b>10-20</b>
	6-9	Low alloy Steel	25-35	Emulsion	10-15	10-15	10-15	10-15	10-15
<b>M</b>	12-13	Ferritic / Martensitic Stainless steel		Neat oil	<b>5-10</b>	<b>5-10</b>	<b>5-10</b>	<b>5-10</b>	<b>5-10</b>
	14	Austenitic Stainless steel		Neat oil	<b>4-6</b>	<b>4-6</b>	<b>4-6</b>	<b>4-6</b>	<b>4-6</b>

► 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.