

HOLE TYPE				
Max 2.0xD	Max 2.0xD	Max 2.0xD	Max 3.0xD	Max 3.0xD
TM1103	TM0731	TM0917	TM3817	TM3827

VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)					
P	1-5	Non-alloy Steel	<25	Emulsion	-	-	-	12-20	12-20
	6-9	Low alloy Steel	25-35	Emulsion	5-8	-	-	10-15	10-15
M	12-13	Ferritic / Martensitic Stainless steel		Neat oil	-	-	-	8-13	8-13
	14	Austenitic Stainless steel		Neat oil	-	-	-	6-8	6-8
K	15-16	Grey Cast iron		Neat oil or Emulsion	-	5-15	8-20	-	-
	17-20	Nodular & Malleable Cast iron		Neat oil or Emulsion	-	5-15	8-20	-	-
N	21-25	Aluminium		Emulsion	-	-	-	10-20	10-20
	26-28	Copper & Copper alloys		Emulsion	-	8-12	12-16	15-35	15-35
H	38	Hardened Steel	40-55	Neat oil	3-7	-	-	-	-
	39	Hardened Steel	55-60	Neat oil	3-7	-	-	-	-
	40-41	Chilled & Hardened Cast Iron	42-55	Neat oil	3-7	-	-	-	-

► 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.