

HOLE TYPE				
Max 2.0xD	Max 2.0xD	Max 2.0xD	Max 3.0xD	Max 3.0xD
<b>TM1103</b>	<b>TM0731</b>	<b>TM0917</b>	<b>TM3817</b>	<b>TM3827</b>

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