

TM5016 CUTTING DATA



HOLE TYPE				
Max 3.0xD	Max 3.0xD	Max 2.0xD	Max 2.5xD	Max 2.5xD
TM0416	TM1817	TM5016	TM1316	TM1917

VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)					
P	1-5	Non-alloy Steel	<25	Emulsion	6-20	10-25	10-20	6-20	10-25
	6-9	Low alloy Steel	25-35	Emulsion	6-15	10-20	10-15	6-15	10-20
M	12-13	Ferritic / Martensitic Stainless steel		Neat oil	5-10	8-13	-	5-10	8-13
K	17-20	Nodular & Malleable Cast iron		Neat oil or Emulsion	5-15	8-20	5-15	5-15	8-20
N	21-25	Aluminium		Emulsion	10-20	15-25	10-15	10-20	15-25
	26-28	Copper & Copper alloys		Emulsion	15-35	20-40	8-35	15-35	20-40

► 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.