
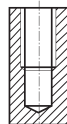
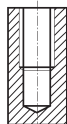


			HOLE TYPE				
							
			Max 3.0xD	Max 2.5xD	Max 2.5xD		
			TM2716	TM6316	TM2330		
VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)			
P	1-5	Non-alloy Steel	<25	Emulsion	6-20	6-20	-
	6-9	Low alloy Steel	25-35	Emulsion	3-15	3-15	3-15
	10-11	High alloy Steel, Tool Steel	35-45	Neat oil or Emulsion	3-5	3-5	-
M	12-13	Ferritic / Martensitic Stainless steel		Neat oil	5-10	-	-
	14	Austenitic Stainless steel		Neat oil	4-6	4-6	4-6
N	26-28	Copper & Copper alloys		Emulsion	-	-	25-35
S	31-35	HRSA Fe & Ni/Co Based		Neat oil	10-15	10-15	-
	36-37	Titanium & Titanium alloys		Neat oil	10-15	10-15	-

► 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.