

HOLE TYPE				
Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD	Max 2.5xD
TM3630	TM6430	TM2530	TM3830	TM6530

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

► 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.