

TM6830 CUTTING DATA



HOLE TYPE				
Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD	Max 2.5xD
TM6730	TM0516	TM6830	TM1730	TM3716

VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)					
P	1-5	Non-alloy Steel	<25	Emulsion	10-20	12-20	10-20	15-20	12-20
	6-9	Low alloy Steel	25-35	Emulsion	10-15	-	10-15	-	-
M	12-13	Ferritic / Martensitic Stainless steel		Neat oil	5-10	-	5-10	5-10	-
	14	Austenitic Stainless steel		Neat oil	4-6	-	4-6	4-6	-
N	21-25	Aluminium		Emulsion	-	10-20	-	-	10-20
	26-28	Copper & Copper alloys		Emulsion	-	8-12	-	-	8-12

► 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.