

# TM7110 CUTTING DATA



HOLE TYPE				
Max 3.0xD	Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD
<b>TM7010</b>	<b>TM7110</b>	<b>TM7328</b>	<b>TM7210</b>	<b>TM7428</b>

VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)					
<b>P</b>	6-9	Low alloy Steel	25-35	Emulsion	<b>3-15</b>	<b>3-15</b>	<b>3-15</b>	<b>3-15</b>	<b>3-15</b>
<b>S</b>	31-35	HRSA Fe & Ni/Co Based		Neat oil	-	<b>2-15</b>	<b>2-15</b>	<b>2-15</b>	<b>2-15</b>
	36-37	Titanium & Titanium alloys		Neat oil	<b>4-15</b>	4-15	-	<b>4-15</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.