

TM7210 CUTTING DATA



HOLE TYPE				
Max 3.0xD	Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD
TM7010	TM7110	TM7328	TM7210	TM7428

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

► 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.