

TM8153 CUTTING DATA



HOLE TYPE				
Max 3.0xD	Max 3.0xD	Max 2.5xD	Max 2.5xD	Max 2.5xD
TM8053	TM3130	TM8153	TM2830	TM2930

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