

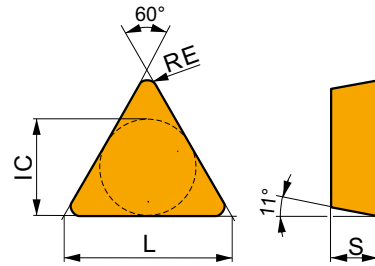
CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----



TPMR

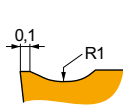


	IC	L	S
	[mm]	[mm]	[mm]
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



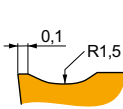
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



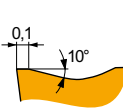
Geometry 46 for fine to finish machining, and continuous to interrupted cuts.

TPMR 110304E-46	6640	0.4	■	140	0.15	1.0	■	80	0.14	1.0	■	130	0.15	1.0	■	—	—	—	—	—	—
	T9325	0.4	■	175	0.15	1.0	■	105	0.15	1.0	■	165	0.15	1.0	■	—	—	—	—	—	—
	T9335	0.4	■	150	0.15	1.0	■	90	0.15	1.0	■	—	—	—	■	—	—	—	—	—	—
TPMR 110308E-46	6640	0.8	■	170	0.15	1.0	■	100	0.14	1.0	■	160	0.15	1.0	■	—	—	—	—	—	—
	T9325	0.8	■	205	0.15	1.0	■	120	0.15	1.0	■	190	0.15	1.0	■	—	—	—	—	—	—
	T9335	0.8	■	180	0.15	1.0	■	105	0.15	1.0	■	—	—	—	■	—	—	—	—	—	—



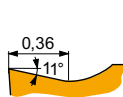
Geometry 47 for finish to semi-rough machining, and continuous to interrupted cuts.

TPMR 160304E-47	6640	0.4	■	120	0.20	1.5	■	70	0.18	1.5	■	110	0.20	1.5	■	—	—	—	—	—	—
	T9325	0.4	■	150	0.20	1.5	■	90	0.18	1.5	■	140	0.20	1.5	■	—	—	—	—	—	—
	T9335	0.4	■	125	0.20	1.5	■	75	0.18	1.5	■	—	—	—	■	—	—	—	—	—	—
TPMR 160308E-47	6640	0.8	■	140	0.20	1.5	■	80	0.18	1.5	■	130	0.20	1.5	■	—	—	—	—	—	—
	T9325	0.8	■	175	0.20	1.5	■	105	0.18	1.5	■	165	0.20	1.5	■	—	—	—	—	—	—
	T9335	0.8	■	150	0.20	1.5	■	90	0.18	1.5	■	—	—	—	■	—	—	—	—	—	—
TPMR 160312E-47	T9325	1.2	■	185	0.20	1.5	■	110	0.18	1.5	■	175	0.20	1.5	■	—	—	—	—	—	—
	T9335	1.2	■	160	0.20	1.5	■	95	0.18	1.5	■	—	—	—	■	—	—	—	—	—	—



Geometry 61 for finish machining with moderate feeds and depths of cut, and continuous to interrupted cuts.

TPMR 160308E-61	T9325	0.8	■	135	0.35	1.8	■	80	0.32	1.8	■	125	0.35	1.8	■	—	—	—	—	—	—
	T9335	0.8	■	120	0.35	1.8	■	70	0.32	1.8	■	—	—	—	■	—	—	—	—	—	—



PF2 geometry for fine to finish machining, and continuous cuts.

TPMR 110304-PF2	TT010	0.4	■	255	0.10	0.5	■	150	0.10	0.5	■	—	—	—	■	—	—	—	—	—	—
TPMR 160304-PF2	TT010	0.4	■	255	0.10	0.5	■	150	0.10	0.5	■	—	—	—	■	—	—	—	—	—	—