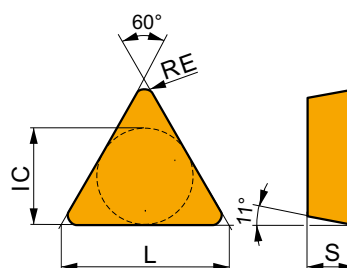




TPUN

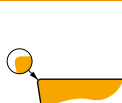


	IC	L	S
	[mm]	[mm]	[mm]
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18
2204	12.700	22.00	4.76
2706	15.875	27.50	6.35
3306	19.050	33.00	6.35



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]



For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

TPUN 110304	6640	0.4	135	0.10	1.2	—	—	—	125	0.10	1.2	—	—	—	—	—	—	—	—
TPUN 110308	6640	0.8	125	0.18	1.2	—	—	—	115	0.18	1.2	—	—	—	—	—	—	—	—
TPUN 160304	6640	0.4	135	0.10	1.5	—	—	—	125	0.10	1.5	—	—	—	—	—	—	—	—
TPUN 160308	6640	0.8	125	0.18	1.5	—	—	—	115	0.18	1.5	—	—	—	—	—	—	—	—
TPUN 160312	6640	1.2	125	0.20	1.5	—	—	—	115	0.20	1.5	—	—	—	—	—	—	—	—
TPUN 220408	6640	0.8	120	0.18	2.0	—	—	—	110	0.18	2.0	—	—	—	—	—	—	—	—
TPUN 220412	6640	1.2	120	0.20	2.0	—	—	—	110	0.20	2.0	—	—	—	—	—	—	—	—



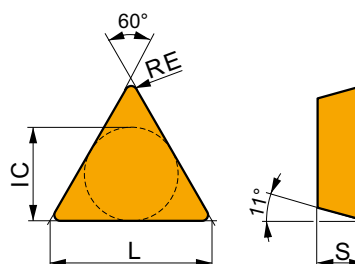
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

TPUN 270616S	6640	1.6	60	0.30	7.0	—	—	—	55	0.30	7.0	—	—	—	—	—	—	—	—
TPUN 330620S	6640	2.0	65	0.30	5.0	—	—	—	60	0.30	5.0	—	—	—	—	—	—	—	—

TPGN CER

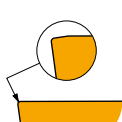


	IC	L	S
	[mm]	[mm]	[mm]
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18



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]



For machining with high speeds and continuous cuts.

TPGN 110304 T01020	TC100	0.4	—	—	—	—	—	—	460	0.10	1.5	—	—	—	—	—	—	—	—
TPGN 110308 T01020	TC100	0.8	—	—	—	—	—	—	425	0.20	1.5	—	—	—	—	—	—	—	—