
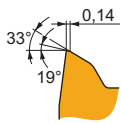




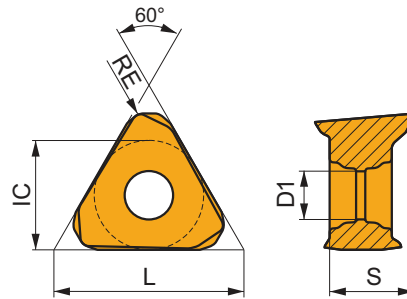
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| Product | RE [mm] | P | | | M | | | K | | | N | | | S | | | H | | | | |
|---|------------|---------------|-----------------|------------|---------------|-----------------|------------|---------------|-----------------|------------|---------------|-----------------|------------|---------------|-----------------|------------|---------------|-----------------|------------|---|---|
| | | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] | | |
|   M geometry with positive design for light to medium machining. | 0.4 | 8215 | 0.4 | 190 | 0.15 | 3.0 | 110 | 0.14 | 3.0 | 180 | 0.15 | 3.0 | — | — | — | 45 | 0.11 | 2.4 | — | — | — |
| | | M6330 | 0.4 | 165 | 0.15 | 3.0 | 115 | 0.14 | 3.0 | — | — | — | 45 | 0.11 | 2.4 | — | — | — | — | — | — |
| | | M8310 | 0.4 | 205 | 0.15 | 3.0 | 100 | 0.14 | 3.0 | 190 | 0.15 | 3.0 | — | — | — | — | — | — | — | — | — |
| | | M8330 | 0.4 | 190 | 0.15 | 3.0 | 110 | 0.14 | 3.0 | 180 | 0.15 | 3.0 | — | — | — | 45 | 0.11 | 2.4 | — | — | — |
| | | M8340 | 0.4 | 170 | 0.15 | 3.0 | 100 | 0.14 | 3.0 | 160 | 0.15 | 3.0 | — | — | — | 40 | 0.11 | 2.4 | — | — | — |
| TNGX 160608SR-M | 0.8 | 8215 | 0.8 | 230 | 0.15 | 3.0 | 135 | 0.14 | 3.0 | 215 | 0.15 | 3.0 | — | — | — | 55 | 0.11 | 2.4 | — | — | — |
| | | M6330 | 0.8 | 195 | 0.15 | 3.0 | 135 | 0.14 | 3.0 | — | — | — | 55 | 0.11 | 2.4 | — | — | — | — | — | |
| | | M8310 | 0.8 | 245 | 0.15 | 3.0 | 120 | 0.14 | 3.0 | 230 | 0.15 | 3.0 | — | — | — | — | — | — | — | — | |
| | | M8330 | 0.8 | 225 | 0.15 | 3.0 | 135 | 0.14 | 3.0 | 210 | 0.15 | 3.0 | — | — | — | 55 | 0.11 | 2.4 | — | — | — |
| | | M8340 | 0.8 | 205 | 0.15 | 3.0 | 120 | 0.14 | 3.0 | 190 | 0.15 | 3.0 | — | — | — | 50 | 0.11 | 2.4 | — | — | — |
| | | M8345 | 0.8 | 160 | 0.15 | 3.0 | 95 | 0.14 | 3.0 | — | — | — | — | — | 40 | 0.11 | 2.4 | — | — | — | |
| | | M9325 | 0.8 | 285 | 0.15 | 3.0 | — | — | — | 270 | 0.15 | 3.0 | — | — | — | — | — | — | — | — | — |
| | | M9340 | 0.8 | 260 | 0.15 | 3.0 | 155 | 0.14 | 3.0 | — | — | — | — | — | 65 | 0.11 | 2.4 | — | — | — | |
| TNGX 160612SR-M | 1.2 | M8330 | 1.2 | 235 | 0.15 | 3.0 | 140 | 0.14 | 3.0 | 220 | 0.15 | 3.0 | — | — | — | 55 | 0.11 | 2.4 | — | — | — |
| | | M8340 | 1.2 | 215 | 0.15 | 3.0 | 125 | 0.14 | 3.0 | 200 | 0.15 | 3.0 | — | — | — | 50 | 0.11 | 2.4 | — | — | — |
| TNGX 160616SR-M | 1.6 | M8310 | 1.6 | 275 | 0.15 | 3.0 | 140 | 0.14 | 3.0 | 260 | 0.15 | 3.0 | — | — | — | — | — | — | — | — | |
| | | M8330 | 1.6 | 250 | 0.15 | 3.0 | 150 | 0.14 | 3.0 | 235 | 0.15 | 3.0 | — | — | — | 60 | 0.11 | 2.4 | — | — | — |
| | | M8340 | 1.6 | 225 | 0.15 | 3.0 | 135 | 0.14 | 3.0 | 210 | 0.15 | 3.0 | — | — | — | 55 | 0.11 | 2.4 | — | — | — |


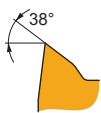
TNGX 16-FA



| | IC [mm] | D1 [mm] | L [mm] | S [mm] |
|------|------------|------------|-----------|-----------|
| 1606 | 9.525 | 4.40 | 16.50 | 6.58 |



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 [mm] | P | | | M | | | K | | | N | | | S | | | H | | |
|---|------------|---------------|-----------------|------------|---------------|-----------------|------------|---------------|-----------------|------------|---------------|-----------------|------------|---------------|-----------------|------------|---------------|-----------------|------------|
| | | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] | vc [m/min] | f [mm/tooth] | ap [mm] |
|   FA geometry with highly positive design for fine-finish to medium machining. | 0.4 | HF7 | — | — | — | — | — | — | — | — | 255 | 0.14 | 2.0 | — | — | — | — | — | — |
| | | M0315 | 0.4 | — | — | — | — | — | — | — | — | 585 | 0.14 | 2.0 | — | — | — | — | — |
| TNGX 160608FR-FA | 0.8 | HF7 | — | — | — | — | — | — | — | — | 300 | 0.14 | 2.0 | — | — | — | — | — | — |
| | | M0315 | 0.8 | — | — | — | — | — | — | — | 690 | 0.14 | 2.0 | — | — | — | — | — | — |