

■ TOP DRILL G • TDG532/TDG533/TDG534 • WN10HD™ • Through Coolant • Metric

| | | | | | | | | | | | | |
|----------------|------------|-----------------------|---------------------------------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|--|
| | | | | | | | | | | | | |
| | | Cutting Speed – vc | Recommended Feed Rate (f) by Diameter | | | | | | | | | |
| | | Range – m/min | | | | | | | | | | |
| Material Group | | min – min | Tool Diameter (mm) | 3,0 | 4,0 | 6,0 | 8,0 | 10,0 | 12,0 | 16,0 | 20,0 | |
| N | 21 | 100 – 450 | mm/r | 0,16–0,25 | 0,19–0,29 | 0,23–0,35 | 0,27–0,42 | 0,31–0,50 | 0,36–0,57 | 0,44–0,69 | 0,52–0,82 | |
| | 22, 23, 24 | 100 – 300 | mm/r | 0,15–0,23 | 0,17–0,28 | 0,21–0,34 | 0,25–0,39 | 0,30–0,46 | 0,34–0,54 | 0,42–0,67 | 0,52–0,82 | |
| | 26 | 100 – 250 | mm/r | 0,16–0,28 | 0,15–0,32 | 0,19–0,36 | 0,23–0,40 | 0,25–0,44 | 0,28–0,48 | 0,32–0,56 | 0,35–0,63 | |

Metric tolerance

| nominal size range | D1 tolerance m7 | D tolerance h6 |
|--------------------|-----------------|----------------|
| >3–6 | 0,004/0,016 | 0,000/-0,008 |
| >6–10 | 0,006/0,021 | 0,000/-0,009 |
| >10–18 | 0,007/0,025 | 0,000/-0,011 |
| >18–25,4 | 0,008/0,029 | 0,000/-0,013 |

