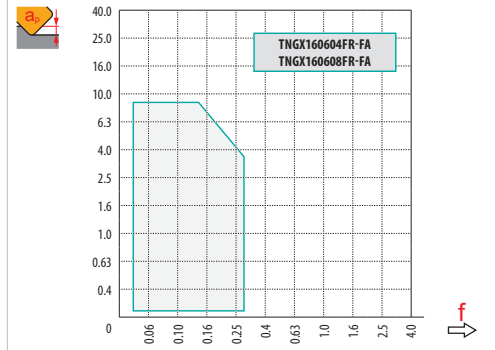
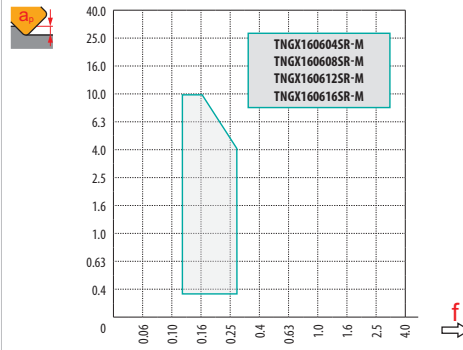
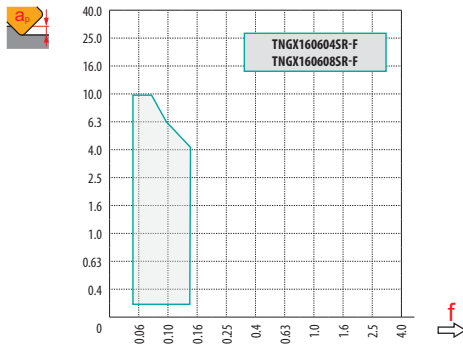


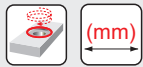


a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	.95	.85	.75	.85	.95	1.00	1.00	1.00	1.00
	.64	.64	.64	.64	.64	.65	.65	.67	.68	.71	.72	.74	.79	1.00

	TNGX 16-F	TNGX 16-M				TNGX 16-FA		
	.4	.8	.4	.8	1.2	1.6	.4	.8
	2.10	1.9	2.10	1.90	1.73	1.14	2.10	1.90



	3.0	4.5	6.0
	.18	.14	.10



DC	min	$d_{min} = DC^*$		$d = 1.25 DC$		$d = 1.5 DC$		$d = 1.75 DC$		$d \geq 2 DC$					
		SMAX	$a_{e max}$	SMAX	$a_{e max}$	SMAX	$a_{e max}$	SMAX	$a_{e max}$	SMAX	$a_{e max}$				
25	25	.14	1.3	31	.22	2.2	38	.33	3.0	44	.60	4.0	50	.70	5.0
32	32	.16	1.5	40	.33	2.8	48	.44	4.0	56	.70	5.0	64	.90	6.5
40	40	.22	2.0	50	.38	3.5	60	.55	5.0	70	.90	6.5	80	1.15	8.0
50	50	.27	2.5	63	.50	4.5	75	.70	6.5	88	1.00	8.0	100	1.40	10.0
63	63	.33	3.2	80	.60	5.5	95	.90	8.0	110	1.45	10.0	125	1.80	12.5
80	80	.55	4.0	100	1.00	7.0	120	1.45	10.0	140	2.15	13.0	160	2.60	16.0
100	100	.70	5.0	125	1.20	9.0	150	1.80	12.5	175	2.70	16.5	200	3.30	20.0
115	115	.85	6.0	145	1.50	10.0	175	1.90	14.5	200	2.80	19.0	230	3.80	23.0
125	125	.90	6.5	155	1.60	11.0	190	2.30	15.5	220	3.10	20.0	250	4.10	25.0
140	140	1.00	7.0	175	1.80	12.5	210	2.60	17.5	245	3.70	23.0	280	4.60	28.0
160	160	1.20	8.0	200	2.00	14.0	240	2.90	20.0	280	4.30	26.0	320	5.30	32.0
175	175	1.30	8.8	220	2.20	15.5	265	3.20	22.0	305	4.70	29.0	350	5.80	35.0

* Check feed rate reduction when hole diameter is between $d_{min} - 1.5 DC$.

