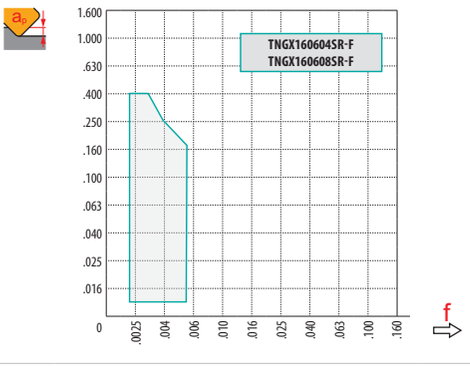
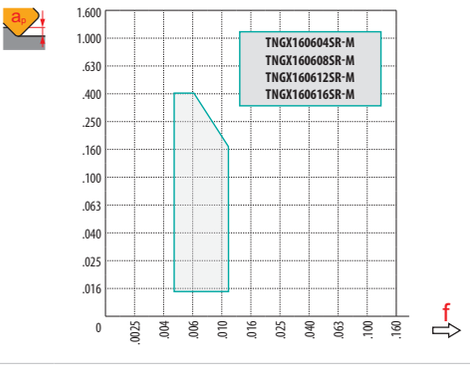
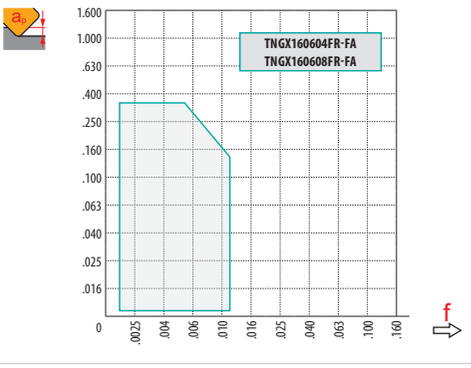
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	.95	.85	.75	.85	.95	1.00	1.00	1.00	1.00
⇨ X.f	.64	.64	.64	.64	.64	.65	.65	.67	.68	.71	.72	.74	.79	1.00

	TNGX 16-F		TNGX 16-M				TNGX 16-FA	
RE (mm)	.4	.8	.4	.8	1.2	1.6	.4	.8
BS (inch)	.083	.075	.083	.075	.068	.045	.083	.075







(inch)

a_p	.118	.177	.236
f	.007	.006	.004

(inch)

DC		d_{min} = DC *			d = 1.25 DC			d = 1.5 DC			d = 1.75 DC			d ≥ 2 DC	
	min	SMAX	$a_{e\,max}$		SMAX	$a_{e\,max}$		SMAX	$a_{e\,max}$		SMAX	$a_{e\,max}$		SMAX	$a_{e\,max}$
.984	.984	.006	.051	1.220	.009	.087	1.496	.013	.118	1.732	.024	.157	1.969	.028	.197
1.260	1.260	.006	.059	1.575	.013	.110	1.890	.017	.157	2.205	.028	.197	2.520	.035	.256
1.575	1.575	.009	.079	1.969	.015	.138	2.362	.022	.197	2.756	.035	.256	3.150	.045	.315
1.969	1.969	.011	.098	2.480	.020	.177	2.953	.028	.256	3.465	.039	.315	3.937	.055	.394
2.480	2.480	.013	.126	3.150	.024	.217	3.740	.035	.315	4.331	.057	.394	4.921	.071	.492
3.150	3.150	.022	.157	3.937	.039	.276	4.724	.057	.394	5.512	.085	.512	6.299	.102	.630
3.937	3.937	.028	.197	4.921	.047	.354	5.906	.071	.492	6.890	.106	.650	7.874	.130	.787
4.528	4.528	.033	.236	5.709	.059	.394	6.890	.075	.571	7.874	.110	.748	9.055	.150	.906
4.921	4.921	.035	.256	6.102	.063	.433	7.480	.091	.610	8.661	.122	.787	9.843	.161	.984
5.512	5.512	.039	.276	6.890	.071	.492	8.268	.102	.689	9.646	.146	.906	11.024	.181	1.102
6.299	6.299	.047	.315	7.874	.079	.551	9.449	.114	.787	11.024	.169	1.024	12.598	.209	1.260
6.890	6.890	.051	.346	8.661	.087	.610	10.433	.126	.866	12.008	.185	1.142	13.780	.228	1.378

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