

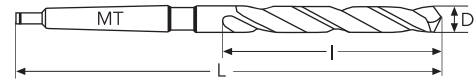
241LS

LS type for deep holes, MT shank, long



P	M	K	N	S	H
★	☆	★			

★ 1st choice ☆ suitable



D(h8)	D Tol.	MT	I	L	PACKAGING	EDP No.	Stock
13.00	0/-0.027	1	134	215	1	P241LS1300	●
14.00	0/-0.027	1	142	223	1	P241LS1400	●
14.50	0/-0.027	2	147	245	1	P241LS1450	●
15.00	0/-0.027	2	147	245	1	P241LS1500	●
15.50	0/-0.027	2	153	251	1	P241LS1550	●
16.00	0/-0.027	2	153	251	1	P241LS1600	●
16.50	0/-0.027	2	159	257	1	P241LS1650	●
17.00	0/-0.027	2	159	257	1	P241LS1700	●
17.50	0/-0.027	2	165	263	1	P241LS1750	●
18.00	0/-0.027	2	165	263	1	P241LS1800	●
18.50	0/-0.033	2	171	269	1	P241LS1850	●
19.00	0/-0.033	2	171	269	1	P241LS1900	●
19.50	0/-0.033	2	177	275	1	P241LS1950	●
20.00	0/-0.033	2	177	275	1	P241LS2000	●
21.00	0/-0.033	2	184	282	1	P241LS2100	●
22.00	0/-0.033	2	191	289	1	P241LS2200	●
23.00	0/-0.033	2	198	296	1	P241LS2300	●
24.00	0/-0.033	3	206	327	1	P241LS2400	●
25.00	0/-0.033	3	206	327	1	P241LS2500	●
26.00	0/-0.033	3	214	335	1	P241LS2600	●
27.00	0/-0.033	3	222	343	1	P241LS2700	●
28.00	0/-0.033	3	222	343	1	P241LS2800	●
29.00	0/-0.033	3	230	351	1	P241LS2900	●
30.00	0/-0.033	3	230	351	1	P241LS3000	●

● stock standard ○ non-standard stock ▽ stock exhaustion

CUTTING PARAMETERS

241LS

Material Group ISO 513	P1 P2			P3 P4			M1 M2			K1 K2		
	500-700 N/mm ²			600-1000 N/mm ²			< 750 N/mm ²			150-350 HB		
Vc (m/min)	15-25			10-20			10-14			20-30		
D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
13	490	0.160	80	370	0.136	50	290	0.112	32	610	0.176	110
14	450	0.170	75	340	0.145	49	270	0.119	32	570	0.187	110
15	420	0.180	75	320	0.153	49	250	0.126	32	530	0.198	100
16	400	0.200	80	300	0.170	51	240	0.140	34	500	0.220	110
17	370	0.190	70	280	0.162	45	220	0.133	29	470	0.209	100
18	350	0.205	70	270	0.174	47	210	0.144	30	440	0.226	100
19	340	0.220	75	250	0.187	47	200	0.154	31	420	0.242	100
20	320	0.235	75	240	0.200	48	190	0.165	31	400	0.259	100
21	300	0.250	75	230	0.213	49	180	0.175	32	380	0.275	100
22	290	0.265	75	220	0.225	50	170	0.186	32	360	0.292	100
23	280	0.280	80	210	0.238	50	170	0.196	33	350	0.308	110
24	270	0.295	80	200	0.251	50	160	0.207	33	330	0.325	110
25	250	0.310	80	190	0.264	50	150	0.217	33	320	0.341	110
26	240	0.325	80	180	0.276	50	150	0.228	34	310	0.358	110
27	240	0.340	80	180	0.289	52	140	0.238	33	290	0.374	110
28	230	0.355	80	170	0.302	51	140	0.249	35	280	0.391	110
29	220	0.370	80	160	0.315	50	130	0.259	34	270	0.407	110
30	210	0.385	80	160	0.327	52	130	0.270	35	270	0.424	110

- INFO
- TYPHOON TA-HTA-4HTA
- TYPHOON PU-HPU
- TYPHOON SUH
- TYPHOON ALH
- TYPHOON HRC
- TYPHOON SUH MINI
- TYPHOON HL
- C-SD-TA
- LFTA
- SUTA
- HSS-HSS/CO DRILLS
- G2
- MDTA
- HF VH/UP
- MEF
- ALU
- MEX
- UH
- HSS/CO-HSSP END MILLS
- CARBIDE BURRS