

MEXM2

	Material Group ISO 513	P2 P3 P4 K1 K2			P4 P5 K3			P6 K4			H1 H4 H5			
	Hardness/Rm	< 1000 N/mm ²			< 35 HRC			35 - 45 HRC			45 - 55 HRC			
	ap x ae	ap x D			ap x D			ap x D			ap x D			
	Vc (m/min)	70-110			50-90			30-70			20-40			
	D (mm)	ap (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)
	0.3	0.02	40000	0.004	320	40000	0.004	290	40000	0.003	255	31800	0.003	180
	0.4	0.02	40000	0.006	480	40000	0.005	430	39800	0.005	380	23900	0.004	200
	0.5	0.03	40000	0.007	560	40000	0.006	500	31800	0.006	355	19100	0.005	185
	0.6	0.03	40000	0.008	640	37200	0.007	540	26500	0.006	340	15900	0.006	180
	0.8	0.04	35800	0.010	720	27900	0.009	500	19900	0.008	320	11900	0.007	165
1	0.05	28700	0.012	690	22300	0.011	480	15900	0.010	305	9600	0.008	160	
1.2	0.06	23900	0.022	1050	18600	0.020	740	13300	0.018	470	8000	0.015	245	
1.4	0.07	20500	0.024	980	15900	0.022	690	11400	0.019	440	6800	0.017	230	
1.5	0.08	19100	0.025	960	14900	0.023	670	10600	0.020	425	6400	0.018	225	
1.6	0.08	17900	0.026	930	13900	0.023	650	10000	0.021	415	6000	0.018	220	
1.8	0.09	15900	0.028	890	12400	0.025	620	8800	0.022	395	5300	0.020	210	
2	0.10	14300	0.030	860	11100	0.027	600	8000	0.024	190	4800	0.021	200	

- 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