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

CUTTING PARAMETERS

UH600

	Material Group ISO 513	P3 P4 P5 K2 K3			P6 K4 H1 H4 H5			H2			H3		
	Hardness/Rm	< 45 HRC			45 - 55 HRC			55 - 60 HRC			60 - 65 HRC		
	ap x ae	**1.5D x 0.1D**			**1.5D x 0.05D**			**1.5D x 0.05D**			**1.5D x 0.05D**		
	Vc (m/min)	**140-180**			**100-140**			**80-100**			**60-80**		
L SIDE MILLING	D (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)
	3	16990	0.008	860	12740	0.008	580	9550	0.007	390	7430	0.006	260
	4	12740	0.012	920	9550	0.011	620	7170	0.010	410	5570	0.008	280
	5	10190	0.014	880	7640	0.013	590	5730	0.012	400	4460	0.010	270
	6	8490	0.018	920	6370	0.016	620	4780	0.014	410	3720	0.013	280
	8	6370	0.028	1050	4780	0.025	710	3580	0.022	470	2790	0.019	320
	10	5100	0.034	1030	3820	0.030	690	2870	0.027	460	2230	0.024	310
	12	4250	0.041	1040	3180	0.037	700	2390	0.033	470	1860	0.029	320
	14	3640	0.048	1050	2730	0.043	710	2050	0.038	470	1590	0.034	320
	16	3180	0.056	1080	2390	0.051	730	1790	0.045	480	1390	0.039	330
	18	2830	0.066	1120	2120	0.059	760	1590	0.053	500	1240	0.046	340
	20	2550	0.078	1190	1910	0.070	800	1430	0.062	540	1110	0.055	360