

CUTTING PARAMETERS

UHCS2

	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	0.3D x D			0.2D x D			0.2D x D			0.1D x D		
	Vc (m/min)	80-120			60-100			50-70			30-50		
	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)
	1	30000	0.007	420	25480	0.006	320	19110	0.006	215	12740	0.005	125
	2	15920	0.012	380	12740	0.011	280	9550	0.010	185	6370	0.008	105
	3	10620	0.017	360	8490	0.015	260	6370	0.014	175	4250	0.012	100
	4	7960	0.023	370	6370	0.021	260	4780	0.018	175	3180	0.016	100
	5	6370	0.030	380	5100	0.027	280	3820	0.024	185	2550	0.021	105
6	5310	0.038	400	4250	0.034	290	3180	0.030	195	2120	0.027	115	
8	3980	0.050	400	3180	0.045	290	2390	0.040	190	1590	0.035	110	
10	3180	0.065	410	2550	0.059	300	1910	0.052	200	1270	0.046	115	
12	2650	0.080	420	2120	0.072	310	1590	0.064	205	1060	0.056	120	

- 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