

# UH411

|           | 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                | <b>D x 0.05D</b> |             |         | <b>D x 0.05D</b> |             |         | <b>D x 0.05D</b> |             |         | <b>D x 0.05D</b> |             |  |
|           | Vc (m/min)             | <b>90-130</b>    |             |         | <b>60-100</b>    |             |         | <b>50-70</b>     |             |         | <b>30-50</b>     |             |  |
| 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) |  |
| <b>3</b>  | 11680                  | 0.027            | 1260        | 8490    | 0.024            | 830         | 6370    | 0.022            | 550         | 4250    | 0.019            | 320         |  |
| <b>4</b>  | 8760                   | 0.036            | 1260        | 6370    | 0.032            | 830         | 4780    | 0.029            | 550         | 3180    | 0.025            | 320         |  |
| <b>5</b>  | 7010                   | 0.041            | 1140        | 5100    | 0.036            | 740         | 3820    | 0.032            | 495         | 2550    | 0.028            | 290         |  |
| <b>6</b>  | 5840                   | 0.045            | 1050        | 4250    | 0.041            | 690         | 3180    | 0.036            | 460         | 2120    | 0.032            | 265         |  |
| <b>8</b>  | 4380                   | 0.059            | 1020        | 3180    | 0.053            | 670         | 2390    | 0.047            | 445         | 1590    | 0.041            | 260         |  |
| <b>10</b> | 3500                   | 0.077            | 1070        | 2550    | 0.069            | 700         | 1910    | 0.061            | 470         | 1270    | 0.054            | 270         |  |
| <b>12</b> | 2920                   | 0.090            | 1050        | 2120    | 0.081            | 690         | 1590    | 0.072            | 460         | 1060    | 0.063            | 265         |  |

- 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