



UH250

	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	0.05D x 0.2D			0.05D x 0.2D			0.05D x 0.2D			0.05D x 0.2D		
	Vc (m/min)	120-160			90-130			70-90			50-70		
D (mm)	D (eff.) (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	0.44	30000	0.015	900	30000	0.014	810	25480	0.012	610	19110	0.011	400
2	0.87	22290	0.021	950	17520	0.019	670	12740	0.017	430	9550	0.015	280
3	1.31	14860	0.027	810	11680	0.024	570	8490	0.022	370	6370	0.019	240
4	1.74	11150	0.037	820	8760	0.033	580	6370	0.029	370	4780	0.026	240
5	2.18	8920	0.045	800	7010	0.041	570	5100	0.036	370	3820	0.032	240
6	2.62	7430	0.051	760	5840	0.046	540	4250	0.041	350	3180	0.036	230
8	3.49	5570	0.060	660	4380	0.054	470	3180	0.048	300	2390	0.042	200
10	4.36	4460	0.068	610	3500	0.061	430	2550	0.054	280	1910	0.048	180
12	5.23	3720	0.077	570	2920	0.069	400	2120	0.061	260	1590	0.054	170
14	6.10	3180	0.089	570	2500	0.080	400	1820	0.071	260	1360	0.062	170
16	6.97	2790	0.102	570	2190	0.092	400	1590	0.082	260	1190	0.071	170
18	7.85	2480	0.115	570	1950	0.103	400	1420	0.092	260	1060	0.080	170
20	8.72	2230	0.132	590	1750	0.119	420	1270	0.106	270	960	0.092	180

	α	n (rpm)	Vf (mm/min)
	30°	x 0.8	x 0.8
	15°	x 0.7	x 0.7
	0°	x 0.6	x 0.6

INFO

TYPHOON
TA-HTA-4HTATYPHOON
PU-HPUTYPHOON
SUHTYPHOON
ALHTYPHOON
HRCTYPHOON
SUH MINITYPHOON
HL

C-SD-TA

LFTA

SUTA

HSS-HSS/CO
DRILLS

G2

MDTA

HF VH/UP

MEF

ALU

MEX

UH

HSS/CO-HSSP
END MILLSCARBIDE
BURRS