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

TAWL2

WL2 (n and Vf = -20% ÷ -30%)

SLOTTING

Material Group ISO 513	P1 P2			P3 M1 K1			P4 M2 K2			P5 M3		
Hardness/Rm	≤ 700 N/mm²			600-800 N/mm²			800-1000 N/mm²			900-1200 N/mm²		
ap x ae	**0.3D x D**			**0.3D x D**			**0.3D x D**			**0.2D x D**		
Vc (m/min)	**30-50**			**25-35**			**20-30**			**12-18**		
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	4250	0.006	50	3180	0.005	30	2650	0.005	25	1590	0.004	15
4	3180	0.008	50	2390	0.007	35	1990	0.007	25	1190	0.006	15
5	2550	0.011	55	1910	0.010	35	1590	0.009	25	960	0.008	15
6	2120	0.014	60	1590	0.012	40	1330	0.011	30	800	0.010	15
8	1590	0.020	65	1190	0.018	45	1000	0.016	30	600	0.015	20
10	1270	0.025	65	960	0.023	45	800	0.020	30	480	0.019	20
12	1060	0.030	65	800	0.027	45	660	0.024	30	400	0.023	20
14	910	0.036	65	680	0.032	45	570	0.029	35	340	0.027	20
16	800	0.042	70	600	0.038	45	500	0.034	35	300	0.032	20
18	710	0.048	70	530	0.043	45	440	0.038	35	270	0.036	20
20	640	0.053	70	480	0.048	45	400	0.043	35	240	0.040	20
22	580	0.060	70	430	0.054	45	360	0.048	35	220	0.045	20
25	510	0.070	70	380	0.063	50	320	0.056	35	190	0.053	20
28	450	0.077	70	340	0.069	45	280	0.062	35	170	0.058	20
30	420	0.084	70	320	0.076	50	270	0.067	35	160	0.063	20

ap x ae	**≤ D5**	0.25D x D

SIDE MILLING

Material Group ISO 513	P1 P2			P3 M1 K1			P4 M2 K2			P5 M3		
Hardness/Rm	≤ 700 N/mm²			600-800 N/mm²			800-1000 N/mm²			900-1200 N/mm²		
ap x ae	**2D x 0.1D**			**2D x 0.1D**			**2D x 0.1D**			**2D x 0.1D**		
Vc (m/min)	**40-50**			**30-40**			**25-35**			**10-20**		
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	4780	0.006	60	3720	0.006	40	3180	0.005	30	1590	0.005	10
4	3580	0.009	65	2790	0.008	50	2390	0.007	30	1190	0.007	20
5	2870	0.012	70	2230	0.011	50	1910	0.009	40	960	0.009	20
6	2390	0.015	75	1860	0.014	50	1590	0.012	40	800	0.011	20
8	1790	0.022	80	1390	0.020	60	1190	0.018	40	600	0.017	20
10	1430	0.028	80	1110	0.025	60	960	0.022	40	480	0.021	20
12	1190	0.033	80	930	0.030	60	800	0.027	40	400	0.025	20
14	1020	0.040	80	800	0.036	60	680	0.032	40	340	0.030	20
16	900	0.046	85	700	0.042	60	600	0.037	40	300	0.035	20
18	800	0.052	85	620	0.047	60	530	0.042	40	270	0.039	20
20	720	0.059	85	560	0.053	60	480	0.047	40	240	0.044	20
22	650	0.065	85	510	0.059	60	430	0.052	50	220	0.049	20
25	570	0.077	90	450	0.069	60	380	0.062	50	190	0.058	20
28	510	0.085	85	400	0.076	60	340	0.068	50	170	0.064	20
30	480	0.092	90	370	0.083	60	320	0.074	50	160	0.069	20

ap x ae	**≤ D5**	1.5D x 0.05D