

TAWSH3

	Material Group ISO 513	P1 P2			P3 M1 K1			P4 M2 K2			P5 M3		
	Hardness/Rm	≤ 700 N/mm ²			600-800 N/mm ²			800-1000 N/mm ²			900-1200 N/mm ²		
	ap x ae	0.3D x D			0.3D x D			0.3D x D			0.3D x D		
	Vc (m/min)	40-60			30-50			25-35			15-25		
	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)
	6	2650	0.020	155	2120	0.018	115	1590	0.015	70	1060	0.014	45
	8	1990	0.029	170	1590	0.026	125	1190	0.022	75	800	0.020	50
	10	1590	0.036	170	1270	0.032	125	960	0.027	80	640	0.025	50
	12	1330	0.043	170	1060	0.039	125	800	0.032	80	530	0.030	50
	14	1140	0.051	175	910	0.046	125	680	0.038	80	450	0.036	50
16	1000	0.060	180	800	0.054	130	600	0.045	80	400	0.042	50	
18	880	0.069	185	710	0.062	135	530	0.052	85	350	0.049	50	
20	800	0.079	190	640	0.071	135	480	0.059	85	320	0.055	55	

	Material Group ISO 513	P1 P2			P3 M1 K1			P4 M2 K2			P5 M3		
	Hardness/Rm	≤ 700 N/mm ²			600-800 N/mm ²			800-1000 N/mm ²			900-1200 N/mm ²		
	ap x ae	1.5D x 0.5D			1.5D x 0.5D			1.5D x 0.3D			1.5D x 0.3D		
	Vc (m/min)	50-70			40-60			25-35			20-30		
	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)
	6	3180	0.018	175	2650	0.017	130	1860	0.015	80	1330	0.013	50
	8	2390	0.024	170	1990	0.021	130	1390	0.019	80	1000	0.017	50
	10	1910	0.035	200	1590	0.031	150	1110	0.028	90	800	0.024	60
	12	1590	0.043	205	1330	0.039	155	930	0.035	95	660	0.030	60
	14	1360	0.052	210	1140	0.047	160	800	0.041	100	570	0.036	60
16	1190	0.062	220	1000	0.055	165	700	0.049	105	500	0.043	65	
18	1060	0.072	230	880	0.065	170	620	0.058	110	440	0.051	65	
20	960	0.083	240	800	0.075	180	560	0.067	110	400	0.058	70	

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