

# 355TA-355HTA

general purpose, TA and HTA (through coolant)

5XD

DIN 6537L

TA

HTA

MG PV200

140°

30°

**355TA 355HTA**



**355TA**



**355HTA**

P	M	K	N	S	H
★	☆	☆	☆	☆	☆

**355TA**

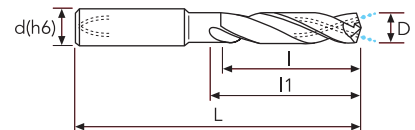
**355HTA**

★ 1st choice ☆ suitable

**355TA**



**355HTA**

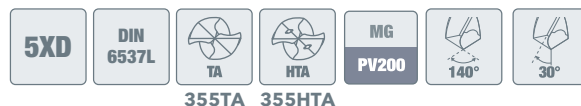


D(m7)	D Tol.	d(h6)	l	l1	L	355TA		355HTA	
						EDP No.	Stock	EDP No.	Stock
3.00	+0.012/+0.002	6	23	28	66	355TA0300	●	355HTA0300	●
3.10	+0.016/+0.004	6	23	28	66	355TA0310	●	355HTA0310	●
3.20	+0.016/+0.004	6	23	28	66	355TA0320	●	355HTA0320	●
3.30	+0.016/+0.004	6	23	28	66	355TA0330	●	355HTA0330	●
3.40	+0.016/+0.004	6	23	28	66	355TA0340	●	355HTA0340	●
3.50	+0.016/+0.004	6	23	28	66	355TA0350	●	355HTA0350	●
3.60	+0.016/+0.004	6	23	28	66	355TA0360	●	355HTA0360	●
3.70	+0.016/+0.004	6	23	28	66	355TA0370	●	355HTA0370	●
3.80	+0.016/+0.004	6	29	36	74	355TA0380	●	355HTA0380	●
3.90	+0.016/+0.004	6	29	36	74	355TA0390	●	355HTA0390	●
4.00	+0.016/+0.004	6	29	36	74	355TA0400	●	355HTA0400	●
4.10	+0.016/+0.004	6	29	36	74	355TA0410	●	355HTA0410	●
4.20	+0.016/+0.004	6	29	36	74	355TA0420	●	355HTA0420	●
4.30	+0.016/+0.004	6	29	36	74	355TA0430	●	355HTA0430	●
4.40	+0.016/+0.004	6	29	36	74	355TA0440	●	355HTA0440	●
4.50	+0.016/+0.004	6	29	36	74	355TA0450	●	355HTA0450	●
4.60	+0.016/+0.004	6	29	36	74	355TA0460	●	355HTA0460	●
4.70	+0.016/+0.004	6	29	36	74	355TA0470	●	355HTA0470	●
4.80	+0.016/+0.004	6	35	44	82	355TA0480	●	355HTA0480	●
4.90	+0.016/+0.004	6	35	44	82	355TA0490	●	355HTA0490	●
5.00	+0.016/+0.004	6	35	44	82	355TA0500	●	355HTA0500	●
5.10	+0.016/+0.004	6	35	44	82	355TA0510	●	355HTA0510	●
5.20	+0.016/+0.004	6	35	44	82	355TA0520	●	355HTA0520	●
5.30	+0.016/+0.004	6	35	44	82	355TA0530	●	355HTA0530	●
5.40	+0.016/+0.004	6	35	44	82	355TA0540	●	355HTA0540	●
5.50	+0.016/+0.004	6	35	44	82	355TA0550	●	355HTA0550	●
5.60	+0.016/+0.004	6	35	44	82	355TA0560	●	355HTA0560	●
5.70	+0.016/+0.004	6	35	44	82	355TA0570	●	355HTA0570	●
5.80	+0.016/+0.004	6	35	44	82	355TA0580	●	355HTA0580	●
5.90	+0.016/+0.004	6	35	44	82	355TA0590	●	355HTA0590	●
6.00	+0.016/+0.004	6	35	44	82	355TA0600	●	355HTA0600	●
6.10	+0.021/+0.006	8	43	53	91	355TA0610	●	355HTA0610	●
6.20	+0.021/+0.006	8	43	53	91	355TA0620	●	355HTA0620	●
6.30	+0.021/+0.006	8	43	53	91	355TA0630	●	355HTA0630	●
6.40	+0.021/+0.006	8	43	53	91	355TA0640	●	355HTA0640	●
6.50	+0.021/+0.006	8	43	53	91	355TA0650	●	355HTA0650	●
6.60	+0.021/+0.006	8	43	53	91	355TA0660	●	355HTA0660	●
6.70	+0.021/+0.006	8	43	53	91	355TA0670	●	355HTA0670	●
6.80	+0.021/+0.006	8	43	53	91	355TA0680	●	355HTA0680	●

● stock standard ○ non-standard stock ▽ stock exhaustion

# 355TA-355HTA

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★	☆	☆	☆	☆	
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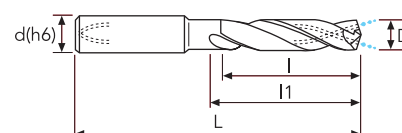
355TA  
355HTA

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D(m7)	D Tol.	d(h6)	l	l1	L	355TA		355HTA	
						EDP No.	Stock	EDP No.	Stock
6.90	+0.021/+0.006	8	43	53	91	355TA0690	●	355HTA0690	●
7.00	+0.021/+0.006	8	43	53	91	355TA0700	●	355HTA0700	●
7.10	+0.021/+0.006	8	43	53	91	355TA0710	●	355HTA0710	●
7.20	+0.021/+0.006	8	43	53	91	355TA0720	●	355HTA0720	●
7.30	+0.021/+0.006	8	43	53	91	355TA0730	●	355HTA0730	●
7.40	+0.021/+0.006	8	43	53	91	355TA0740	●	355HTA0740	●
7.50	+0.021/+0.006	8	43	53	91	355TA0750	●	355HTA0750	●
7.60	+0.021/+0.006	8	43	53	91	355TA0760	●	355HTA0760	●
7.70	+0.021/+0.006	8	43	53	91	355TA0770	●	355HTA0770	●
7.80	+0.021/+0.006	8	43	53	91	355TA0780	●	355HTA0780	●
7.90	+0.021/+0.006	8	43	53	91	355TA0790	●	355HTA0790	●
8.00	+0.021/+0.006	8	43	53	91	355TA0800	●	355HTA0800	●
8.10	+0.021/+0.006	10	49	61	103	355TA0810	●	355HTA0810	●
8.20	+0.021/+0.006	10	49	61	103	355TA0820	●	355HTA0820	●
8.30	+0.021/+0.006	10	49	61	103	355TA0830	●	355HTA0830	●
8.40	+0.021/+0.006	10	49	61	103	355TA0840	●	355HTA0840	●
8.50	+0.021/+0.006	10	49	61	103	355TA0850	●	355HTA0850	●
8.60	+0.021/+0.006	10	49	61	103	355TA0860	●	355HTA0860	●
8.70	+0.021/+0.006	10	49	61	103	355TA0870	●	355HTA0870	●
8.80	+0.021/+0.006	10	49	61	103	355TA0880	●	355HTA0880	●
8.90	+0.021/+0.006	10	49	61	103	355TA0890	●	355HTA0890	●
9.00	+0.021/+0.006	10	49	61	103	355TA0900	●	355HTA0900	●
9.10	+0.021/+0.006	10	49	61	103	355TA0910	●	355HTA0910	●
9.20	+0.021/+0.006	10	49	61	103	355TA0920	●	355HTA0920	●
9.30	+0.021/+0.006	10	49	61	103	355TA0930	●	355HTA0930	●
9.40	+0.021/+0.006	10	49	61	103	355TA0940	●	355HTA0940	●
9.50	+0.021/+0.006	10	61	61	103	355TA0950	●	355HTA0950	●
9.60	+0.021/+0.006	10	61	61	103	355TA0960	●	355HTA0960	●
9.70	+0.021/+0.006	10	61	61	103	355TA0970	●	355HTA0970	●
9.80	+0.021/+0.006	10	61	61	103	355TA0980	●	355HTA0980	●
9.90	+0.021/+0.006	10	61	61	103	355TA0990	●	355HTA0990	●
10.00	+0.021/+0.006	10	61	61	103	355TA1000	●	355HTA1000	●
10.10	+0.025/+0.007	12	71	71	118	355TA1010	●		
10.20	+0.025/+0.007	12	71	71	118	355TA1020	●	355HTA1020	●
10.30	+0.025/+0.007	12	71	71	118	355TA1030	●		
10.40	+0.025/+0.007	12	71	71	118	355TA1040	○		
10.50	+0.025/+0.007	12	71	71	118	355TA1050	●	355HTA1050	●
10.60	+0.025/+0.007	12	71	71	118	355TA1060	●		
10.70	+0.025/+0.007	12	71	71	118	355TA1070	●		

INFO
TYPHOON TA-HTA-4HTA
TYPHOON PU-HPJ
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

● stock standard ○ non-standard stock ▽ stock exhaustion

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355TA

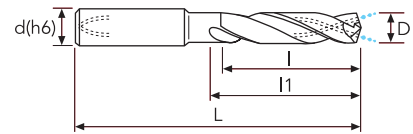
355HTA

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D(m7)	D Tol.	d(h6)	l	l1	L	355TA		355HTA	
						EDP No.	Stock	EDP No.	Stock
10.80	+0.025/+0.007	12	71	71	118	355TA1080	●	355HTA1080	●
10.90	+0.025/+0.007	12	71	71	118	355TA1090	○	355HTA1090	○
11.00	+0.025/+0.007	12	71	71	118	355TA1100	●	355HTA1100	●
11.10	+0.025/+0.007	12	71	71	118	355TA1110	○		
11.20	+0.025/+0.007	12	71	71	118	355TA1120	●	355HTA1120	●
11.30	+0.025/+0.007	12	71	71	118	355TA1130	●	355HTA1130	●
11.40	+0.025/+0.007	12	71	71	118	355TA1140	●		
11.50	+0.025/+0.007	12	71	71	118	355TA1150	●	355HTA1150	●
11.60	+0.025/+0.007	12	71	71	118	355TA1160	○		
11.70	+0.025/+0.007	12	71	71	118	355TA1170	●		
11.80	+0.025/+0.007	12	71	71	118	355TA1180	●	355HTA1180	●
11.90	+0.025/+0.007	12	71	71	118	355TA1190	○		
12.00	+0.025/+0.007	12	71	71	118	355TA1200	●	355HTA1200	●
12.20	+0.025/+0.007	14	77	77	124	355TA1220	●	355HTA1220	●
12.50	+0.025/+0.007	14	77	77	124	355TA1250	●	355HTA1250	●
12.80	+0.025/+0.007	14	77	77	124			355HTA1280	●
13.00	+0.025/+0.007	14	77	77	124	355TA1300	●	355HTA1300	●
13.30	+0.025/+0.007	14	77	77	124			355HTA1330	●
13.50	+0.025/+0.007	14	77	77	124	355TA1350	●	355HTA1350	●
13.80	+0.025/+0.007	14	77	77	124			355HTA1380	●
14.00	+0.025/+0.007	14	77	77	124	355TA1400	●	355HTA1400	●
14.50	+0.025/+0.007	16	83	83	133	355TA1450	●	355HTA1450	●
15.00	+0.025/+0.007	16	83	83	133	355TA1500	●	355HTA1500	●
15.30	+0.025/+0.007	16	83	83	133			355HTA1530	●
15.50	+0.025/+0.007	16	83	83	133	355TA1550	●	355HTA1550	●
15.80	+0.025/+0.007	16	83	83	133			355HTA1580	●
16.00	+0.025/+0.007	16	83	83	133	355TA1600	●	355HTA1600	●
16.50	+0.025/+0.007	18	93	93	143	355TA1650	●	355HTA1650	●
17.00	+0.025/+0.007	18	93	93	143	355TA1700	●	355HTA1700	●
17.50	+0.025/+0.007	18	93	93	143	355TA1750	●	355HTA1750	●
18.00	+0.025/+0.007	18	93	93	143	355TA1800	●	355HTA1800	●
18.50	+0.029/+0.008	20	101	101	153	355TA1850	●	355HTA1850	●
19.00	+0.029/+0.008	20	101	101	153	355TA1900	●	355HTA1900	●
19.50	+0.029/+0.008	20	101	101	153	355TA1950	○	355HTA1950	●
20.00	+0.029/+0.008	20	101	101	153	355TA2000	●	355HTA2000	●

● stock standard ○ non-standard stock ▽ stock exhaustion

### 355TA

	Material Group ISO 513	P1 P2			P3 P4			P5			P6		
	Hardness/Rm	500-700 N/mm <sup>2</sup>			600-1000 N/mm <sup>2</sup>			900-1200 N/mm <sup>2</sup>			1200-1400 N/mm <sup>2</sup>		
	Vc (m/min)	80-100			70-90			40-60			20-40		
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
3	9550	0.085	810	8490	0.068	580	5310	0.060	320	3180	0.043	140	
4	7170	0.094	670	6370	0.075	480	3980	0.065	260	2390	0.047	110	
5	5730	0.102	580	5100	0.082	420	3180	0.071	230	1910	0.051	100	
6	4780	0.115	550	4250	0.092	390	2650	0.080	210	1590	0.057	90	
7	4090	0.128	520	3640	0.102	370	2270	0.089	200	1360	0.064	90	
8	3580	0.140	500	3180	0.112	360	1990	0.098	200	1190	0.070	80	
9	3180	0.153	490	2830	0.122	350	1770	0.107	190	1060	0.077	80	
10	2870	0.166	480	2550	0.133	340	1590	0.116	180	960	0.083	80	
11	2610	0.179	470	2320	0.143	330	1450	0.125	180	870	0.089	80	
12	2390	0.196	470	2120	0.156	330	1330	0.137	180	800	0.098	80	
13	2200	0.213	470	1960	0.170	330	1220	0.149	180	730	0.106	80	
14	2050	0.230	470	1820	0.184	330	1140	0.161	180	680	0.115	80	
15	1910	0.247	470	1700	0.197	340	1060	0.173	180	640	0.123	80	
16	1790	0.264	470	1590	0.211	340	1000	0.184	180	600	0.132	80	
17	1690	0.281	470	1500	0.224	340	940	0.196	180	560	0.140	80	
18	1590	0.298	470	1420	0.238	340	880	0.208	180	530	0.149	80	
19	1510	0.315	470	1340	0.252	340	840	0.220	180	500	0.157	80	
20	1430	0.332	470	1270	0.265	340	800	0.232	190	480	0.166	80	

### 355HTA

	Material Group ISO 513	P1 P2			P3 P4			P5			P6		
	Hardness/Rm	500-700 N/mm <sup>2</sup>			600-1000 N/mm <sup>2</sup>			900-1200 N/mm <sup>2</sup>			1200-1400 N/mm <sup>2</sup>		
	Vc (m/min)	100-120			80-100			60-80			40-60		
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
3	11680	0.094	1090	9550	0.070	670	7430	0.056	420	5310	0.047	250	
4	8760	0.111	970	7170	0.083	590	5570	0.066	370	3980	0.055	220	
5	7010	0.128	890	5730	0.096	550	4460	0.077	340	3180	0.064	200	
6	5840	0.145	840	4780	0.108	520	3720	0.087	320	2650	0.072	190	
7	5000	0.162	810	4090	0.121	500	3180	0.097	310	2270	0.081	180	
8	4380	0.179	780	3580	0.134	480	2790	0.107	300	1990	0.089	180	
9	3890	0.196	760	3180	0.147	470	2480	0.117	290	1770	0.098	170	
10	3500	0.213	740	2870	0.159	460	2230	0.128	280	1590	0.106	170	
11	3180	0.221	700	2610	0.166	430	2030	0.133	270	1450	0.111	160	
12	2920	0.238	690	2390	0.179	430	1860	0.143	270	1330	0.119	160	
13	2690	0.255	690	2200	0.191	420	1710	0.153	260	1220	0.128	160	
14	2500	0.272	680	2050	0.204	420	1590	0.163	260	1140	0.136	160	
15	2340	0.289	680	1910	0.217	410	1490	0.173	260	1060	0.145	150	
16	2190	0.306	670	1790	0.230	410	1390	0.184	260	1000	0.153	150	
17	2060	0.315	650	1690	0.236	400	1310	0.189	250	940	0.157	150	
18	1950	0.323	630	1590	0.242	390	1240	0.194	240	880	0.162	140	
19	1840	0.332	610	1510	0.249	380	1170	0.199	230	840	0.166	140	
20	1750	0.340	600	1430	0.255	360	1110	0.204	230	800	0.170	140	

- 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

### 355TA

Material Group ISO 513	M1 M2			M3			M4			M5		
	< 750 N/mm <sup>2</sup>			550-850 N/mm <sup>2</sup>			650-950 N/mm <sup>2</sup>			850-1200 N/mm <sup>2</sup>		
	30-50			25-35			20-30			15-25		
D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
3	4250	0.060	250	3180	0.048	150	2650	0.042	110	2120	0.030	60
4	3180	0.065	210	2390	0.052	130	1990	0.046	90	1590	0.033	50
5	2550	0.071	180	1910	0.057	110	1590	0.050	80	1270	0.036	50
6	2120	0.080	170	1590	0.064	100	1330	0.056	70	1060	0.040	40
7	1820	0.089	160	1360	0.071	100	1140	0.062	70	910	0.045	40
8	1590	0.098	160	1190	0.079	90	1000	0.069	70	800	0.049	40
9	1420	0.107	150	1060	0.086	90	880	0.075	70	710	0.054	40
10	1270	0.116	150	960	0.093	90	800	0.081	60	640	0.058	40
11	1160	0.125	140	870	0.100	90	720	0.087	60	580	0.062	40
12	1060	0.137	150	800	0.109	90	660	0.096	60	530	0.068	40
13	980	0.149	150	730	0.119	90	610	0.104	60	490	0.074	40
14	910	0.161	150	680	0.129	90	570	0.112	60	450	0.080	40
15	850	0.173	150	640	0.138	90	530	0.121	60	420	0.086	40
16	800	0.184	150	600	0.148	90	500	0.129	60	400	0.092	40
17	750	0.196	150	560	0.157	90	470	0.137	60	370	0.098	40
18	710	0.208	150	530	0.167	90	440	0.146	60	350	0.104	40
19	670	0.220	150	500	0.176	90	420	0.154	60	340	0.110	40
20	640	0.232	150	480	0.186	90	400	0.162	60	320	0.116	40



### 355HTA

Material Group ISO 513	M1 M2			M3			M4			M5		
	< 750 N/mm <sup>2</sup>			550-850 N/mm <sup>2</sup>			650-950 N/mm <sup>2</sup>			850-1200 N/mm <sup>2</sup>		
	30-50			25-35			20-30			10-20		
D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
3	4250	0.060	250	3180	0.048	150	2650	0.042	110	1590	0.036	60
4	3180	0.077	240	2390	0.061	150	1990	0.054	110	1190	0.046	50
5	2550	0.085	220	1910	0.068	130	1590	0.060	90	960	0.051	50
6	2120	0.094	200	1590	0.075	120	1330	0.065	90	800	0.056	40
7	1820	0.111	200	1360	0.088	120	1140	0.077	90	680	0.066	50
8	1590	0.128	200	1190	0.102	120	1000	0.089	90	600	0.077	50
9	1420	0.136	190	1060	0.109	120	880	0.095	80	530	0.082	40
10	1270	0.149	190	960	0.119	110	800	0.104	80	480	0.089	40
11	1160	0.153	180	870	0.122	110	720	0.107	80	430	0.092	40
12	1060	0.170	180	800	0.136	110	660	0.119	80	400	0.102	40
13	980	0.183	180	730	0.146	110	610	0.128	80	370	0.110	40
14	910	0.196	180	680	0.156	110	570	0.137	80	340	0.117	40
15	850	0.208	180	640	0.167	110	530	0.146	80	320	0.125	40
16	800	0.221	180	600	0.177	110	500	0.155	80	300	0.133	40
17	750	0.230	170	560	0.184	100	470	0.161	80	280	0.138	40
18	710	0.242	170	530	0.194	100	440	0.170	70	270	0.145	40
19	670	0.255	170	500	0.204	100	420	0.179	70	250	0.153	40
20	640	0.264	170	480	0.211	100	400	0.184	70	240	0.158	40



- INFO
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- 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

### 355TA

	Material Group ISO 513	K1			K2			K3			K4		
	Hardness/Rm	150-250 HB			150-350 HB			120-260 HB			250-500 HB		
	Vc (m/min)	80-100			70-90			40-60			20-40		
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
3	9550	0.085	810	8490	0.068	580	5310	0.060	320	3180	0.043	140	
4	7170	0.094	670	6370	0.075	480	3980	0.065	260	2390	0.047	110	
5	5730	0.102	580	5100	0.082	420	3180	0.071	230	1910	0.051	100	
6	4780	0.115	550	4250	0.092	390	2650	0.080	210	1590	0.057	90	
7	4090	0.128	520	3640	0.102	370	2270	0.089	200	1360	0.064	90	
8	3580	0.140	500	3180	0.112	360	1990	0.098	200	1190	0.070	80	
9	3180	0.153	490	2830	0.122	350	1770	0.107	190	1060	0.077	80	
10	2870	0.166	480	2550	0.133	340	1590	0.116	180	960	0.083	80	
11	2610	0.179	470	2320	0.143	330	1450	0.125	180	870	0.089	80	
12	2390	0.196	470	2120	0.156	330	1330	0.137	180	800	0.098	80	
13	2200	0.213	470	1960	0.170	330	1220	0.149	180	730	0.106	80	
14	2050	0.230	470	1820	0.184	330	1140	0.161	180	680	0.115	80	
15	1910	0.247	470	1700	0.197	340	1060	0.173	180	640	0.123	80	
16	1790	0.264	470	1590	0.211	340	1000	0.184	180	600	0.132	80	
17	1690	0.281	470	1500	0.224	340	940	0.196	180	560	0.140	80	
18	1590	0.298	470	1420	0.238	340	880	0.208	180	530	0.149	80	
19	1510	0.315	470	1340	0.252	340	840	0.220	180	500	0.157	80	
20	1430	0.332	470	1270	0.265	340	800	0.232	190	480	0.166	80	

### 355HTA

	Material Group ISO 513	K1			K2			K3			K4		
	Hardness/Rm	150-250 HB			150-350 HB			120-260 HB			250-500 HB		
	Vc (m/min)	90-110			70-90			50-70			40-60		
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
3	10620	0.094	990	8490	0.084	710	6370	0.075	480	5310	0.065	350	
4	7960	0.111	880	6370	0.099	630	4780	0.088	420	3980	0.077	310	
5	6370	0.128	810	5100	0.115	590	3820	0.102	390	3180	0.089	280	
6	5310	0.145	770	4250	0.130	550	3180	0.116	370	2650	0.101	270	
7	4550	0.162	730	3640	0.145	530	2730	0.129	350	2270	0.113	260	
8	3980	0.179	710	3180	0.161	510	2390	0.143	340	1990	0.125	250	
9	3540	0.196	690	2830	0.176	500	2120	0.156	330	1770	0.137	240	
10	3180	0.213	680	2550	0.191	490	1910	0.170	320	1590	0.149	240	
11	2900	0.221	640	2320	0.199	460	1740	0.177	310	1450	0.155	220	
12	2650	0.238	630	2120	0.214	450	1590	0.190	300	1330	0.167	220	
13	2450	0.255	620	1960	0.230	450	1470	0.204	300	1220	0.179	220	
14	2270	0.272	620	1820	0.245	450	1360	0.218	300	1140	0.190	220	
15	2120	0.289	610	1700	0.260	440	1270	0.231	290	1060	0.202	210	
16	1990	0.306	610	1590	0.275	440	1190	0.245	290	1000	0.214	210	
17	1870	0.315	590	1500	0.283	420	1120	0.252	280	940	0.220	210	
18	1770	0.323	570	1420	0.291	410	1060	0.258	270	880	0.226	200	
19	1680	0.332	560	1340	0.298	400	1010	0.265	270	840	0.232	190	
20	1590	0.340	540	1270	0.306	390	960	0.272	260	800	0.238	190	

- INFO
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- CARBIDE BURRS

### 355HTA

Material Group ISO 513	N1 > 5% Si			N2			N4					
	Hardness/Rm											
	Vc (m/min)			180-220			160-200			160-180		
D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)			
3	21230	0.112	2380	19110	0.101	1930	18050	0.090	1620			
4	15920	0.133	2110	14330	0.119	1710	13540	0.106	1440			
5	12740	0.153	1950	11460	0.138	1580	10830	0.122	1330			
6	10620	0.173	1840	9550	0.156	1490	9020	0.139	1250			
7	9100	0.194	1760	8190	0.174	1430	7730	0.155	1200			
8	7960	0.214	1710	7170	0.193	1380	6770	0.171	1160			
9	7080	0.235	1660	6370	0.211	1340	6020	0.188	1130			
10	6370	0.255	1620	5730	0.230	1320	5410	0.204	1100			
11	5790	0.265	1540	5210	0.239	1240	4920	0.212	1040			
12	5310	0.286	1520	4780	0.257	1230	4510	0.228	1030			
13	4900	0.306	1500	4410	0.275	1210	4160	0.245	1020			
14	4550	0.326	1490	4090	0.294	1200	3870	0.261	1010			
15	4250	0.347	1470	3820	0.312	1190	3610	0.277	1000			
16	3980	0.367	1460	3580	0.330	1180	3380	0.294	990			
17	3750	0.377	1420	3370	0.340	1140	3180	0.302	960			
18	3540	0.388	1370	3180	0.349	1110	3010	0.310	930			
19	3350	0.398	1330	3020	0.358	1080	2850	0.318	910			
20	3180	0.408	1300	2870	0.367	1050	2710	0.326	880			



- INFO
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### 355TA

	Material Group ISO 513	S1 S2			S3			S4			S5		
	Hardness/Rm	< 35 HRC			35-45 HRC								
	Vc (m/min)	20-30			10-20			25-35			15-25		
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
3	2650	0.038	100	1590	0.027	40	3180	0.036	120	2120	0.031	60	
4	1990	0.042	80	1190	0.029	40	2390	0.040	100	1590	0.034	50	
5	1590	0.046	70	960	0.032	30	1910	0.044	80	1270	0.037	50	
6	1330	0.052	70	800	0.036	30	1590	0.049	80	1060	0.041	40	
7	1140	0.057	70	680	0.040	30	1360	0.055	70	910	0.046	40	
8	1000	0.063	60	600	0.044	30	1190	0.060	70	800	0.050	40	
9	880	0.069	60	530	0.048	30	1060	0.065	70	710	0.055	40	
10	800	0.075	60	480	0.052	30	960	0.071	70	640	0.060	40	
11	720	0.080	60	430	0.056	20	870	0.076	70	580	0.064	40	
12	660	0.088	60	400	0.062	20	800	0.084	70	530	0.070	40	
13	610	0.096	60	370	0.067	20	730	0.091	70	490	0.077	40	
14	570	0.103	60	340	0.072	20	680	0.098	70	450	0.083	40	
15	530	0.111	60	320	0.078	20	640	0.105	70	420	0.089	40	
16	500	0.119	60	300	0.083	20	600	0.113	70	400	0.095	40	
17	470	0.126	60	280	0.088	20	560	0.120	70	370	0.101	40	
18	440	0.134	60	270	0.094	30	530	0.127	70	350	0.107	40	
19	420	0.142	60	250	0.099	20	500	0.134	70	340	0.113	40	
20	400	0.149	60	240	0.104	30	480	0.142	70	320	0.119	40	

### 355HTA

	Material Group ISO 513	S1 S2			S3			S4			S5		
	Hardness/Rm	< 35 HRC			35-45 HRC								
	Vc (m/min)	25-35			15-25			40-50			25-35		
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)
3	3180	0.039	120	2120	0.027	60	4780	0.037	180	3180	0.031	100	
4	2390	0.047	110	1590	0.033	50	3580	0.044	160	2390	0.037	90	
5	1910	0.054	100	1270	0.037	50	2870	0.051	150	1910	0.043	80	
6	1590	0.062	100	1060	0.043	50	2390	0.059	140	1590	0.050	80	
7	1360	0.068	90	910	0.048	40	2050	0.065	130	1360	0.054	70	
8	1190	0.077	90	800	0.054	40	1790	0.073	130	1190	0.061	70	
9	1060	0.085	90	710	0.060	40	1590	0.081	130	1060	0.068	70	
10	960	0.094	90	640	0.065	40	1430	0.089	130	960	0.075	70	
11	870	0.102	90	580	0.071	40	1300	0.097	130	870	0.082	70	
12	800	0.111	90	530	0.077	40	1190	0.105	120	800	0.088	70	
13	730	0.116	90	490	0.082	40	1100	0.111	120	730	0.093	70	
14	680	0.123	80	450	0.086	40	1020	0.117	120	680	0.099	70	
15	640	0.130	80	420	0.091	40	960	0.124	120	640	0.104	70	
16	600	0.136	80	400	0.095	40	900	0.129	120	600	0.109	70	
17	560	0.145	80	370	0.101	40	840	0.137	120	560	0.116	60	
18	530	0.153	80	350	0.107	40	800	0.145	120	530	0.122	60	
19	500	0.162	80	340	0.113	40	750	0.153	120	500	0.129	60	
20	480	0.170	80	320	0.119	40	720	0.162	120	480	0.136	70	

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