

# TAWLB2

WLB2 (n and Vf = -20% ÷ -30%)

| Material Group<br>ISO 513 |               | P1 P2                   |           |             | P3 M1 K1                  |           |             | P4 M2 K2                   |           |             | P5 M3                      |           |             |
|---------------------------|---------------|-------------------------|-----------|-------------|---------------------------|-----------|-------------|----------------------------|-----------|-------------|----------------------------|-----------|-------------|
| Hardness/Rm               |               | ≤ 700 N/mm <sup>2</sup> |           |             | 600-800 N/mm <sup>2</sup> |           |             | 800-1000 N/mm <sup>2</sup> |           |             | 900-1200 N/mm <sup>2</sup> |           |             |
| ap x ae                   |               | 0.1 D x 0.2 D           |           |             | 0.1 D x 0.2 D             |           |             | 0.1 D x 0.2 D              |           |             | 0.1 D x 0.2 D              |           |             |
| Vc (m/min)                |               | 30-50                   |           |             | 25-35                     |           |             | 20-30                      |           |             | 12-18                      |           |             |
| 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) |
| 3                         | 1.80          | 4250                    | 0.034     | 290         | 3180                      | 0.031     | 190         | 2650                       | 0.027     | 140         | 1590                       | 0.026     | 80          |
| 4                         | 2.40          | 3180                    | 0.051     | 320         | 2390                      | 0.046     | 220         | 1990                       | 0.041     | 160         | 1190                       | 0.038     | 90          |
| 5                         | 3.00          | 2550                    | 0.060     | 300         | 1910                      | 0.054     | 200         | 1590                       | 0.048     | 150         | 960                        | 0.045     | 90          |
| 6                         | 3.60          | 2120                    | 0.070     | 300         | 1590                      | 0.063     | 200         | 1330                       | 0.056     | 150         | 800                        | 0.052     | 80          |
| 8                         | 4.80          | 1590                    | 0.080     | 250         | 1190                      | 0.072     | 170         | 1000                       | 0.064     | 130         | 600                        | 0.060     | 70          |
| 10                        | 6.00          | 1270                    | 0.094     | 240         | 960                       | 0.084     | 160         | 800                        | 0.075     | 120         | 480                        | 0.070     | 70          |
| 12                        | 7.20          | 1060                    | 0.111     | 230         | 800                       | 0.099     | 160         | 660                        | 0.088     | 120         | 400                        | 0.083     | 70          |
| 14                        | 8.40          | 910                     | 0.128     | 230         | 680                       | 0.115     | 160         | 570                        | 0.102     | 120         | 340                        | 0.096     | 70          |
| 16                        | 9.60          | 800                     | 0.145     | 230         | 600                       | 0.130     | 160         | 500                        | 0.116     | 120         | 300                        | 0.108     | 70          |
| 18                        | 10.80         | 710                     | 0.162     | 230         | 530                       | 0.145     | 150         | 440                        | 0.129     | 110         | 270                        | 0.121     | 70          |
| 20                        | 12.00         | 640                     | 0.179     | 230         | 480                       | 0.161     | 150         | 400                        | 0.143     | 110         | 240                        | 0.134     | 60          |



| α   | n (rpm) | Vf (mm/min) |
|-----|---------|-------------|
| 15° | x 1.1   | x 1.1       |

- 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