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

CUTTING PARAMETERS

TAFM

FM (n and Vf = -20% ÷ -30%)

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		**0.25D x 0.75D**			**0.25D x 0.75D**			**0.25D x 0.75D**			**0.25D x 0.75D**		
	Vc (m/min)		**40-60**			**30-50**			**25-35**			**15-25**		
	D (mm)	Z (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)
	40	**8**	400	0.060	190	320	0.054	140	240	0.048	90	160	0.045	60
	50	**8**	320	0.070	180	250	0.063	125	190	0.056	85	130	0.053	55
	63	**8**	250	0.080	200	200	0.072	145	150	0.064	95	100	0.060	60
	80	**10**	200	0.100	200	160	0.090	145	120	0.080	95	80	0.075	60
	100	**10**	160	0.120	190	130	0.108	140	100	0.096	95	60	0.090	55