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

WDD 45° - 60°

DOVETAIL A 45°-60°

Material Group ISO 513		P1 P2 P3 P4			M1 M2			K1 K2			N1 N2 N3 N4		
Hardness/Rm		< 800 N/mm²			< 750 N/mm²			< 350 HB					
ap x ae		**0.2D x 0.15D**			**0.2D x 0.15D**			**0.2D x 0.15D**			**0.2D x 0.15D**		
Vc (m/min)		**30-50**			**15-25**			**30-40**			**50-70**		
D (mm)	z	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)
16	**6**	800	0.015	70	400	0.011	25	700	0.013	55	1190	0.017	120
20	**6**	640	0.017	65	320	0.012	20	560	0.014	45	960	0.018	105
22	**6**	580	0.018	65	290	0.013	20	510	0.015	45	870	0.020	105
25	**8**	510	0.020	80	250	0.014	20	450	0.017	45	760	0.022	100
28	**8**	450	0.023	80	230	0.016	20	400	0.019	45	680	0.025	100
32	**10**	400	0.025	100	200	0.018	20	350	0.021	45	600	0.028	100
38	**12**	340	0.028	115	170	0.020	20	290	0.024	40	500	0.031	90