

# WWK

	Material Group ISO 513		P1 P2 P3 P4			M1 M2			K1 K2			N1 N2 N3 N4		
	Hardness/Rm		< 800 N/mm <sup>2</sup>			< 750 N/mm <sup>2</sup>			< 350 HB					
	ap x ae		DIN Norm 6888			DIN Norm 6888			DIN Norm 6888			DIN Norm 6888		
	Vc (m/min)		25-35			12-18			20-30			40-60		
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)	
10.5	8	910	0.010	75	450	0.007	25	760	0.009	50	1520	0.011	135	
13.5	8	710	0.018	100	350	0.012	35	590	0.015	70	1180	0.019	180	
16.5	8	580	0.025	115	290	0.018	40	480	0.021	80	970	0.028	215	
19.5	8	490	0.033	125	240	0.023	45	410	0.028	90	820	0.036	235	
22.5	10	420	0.040	170	210	0.028	60	350	0.034	120	710	0.044	310	
25.5	10	370	0.045	165	190	0.032	60	310	0.038	120	620	0.050	305	
28.5	10	340	0.050	170	170	0.035	60	280	0.043	120	560	0.055	310	
32.5	12	290	0.055	190	150	0.039	70	240	0.047	135	490	0.061	355	

- 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