

CUTTING PARAMETERS

MEF902

	Material Group ISO 513	P1 P2 P3			P4 M1 M2			P5 M3 M4 S1 S2 S4						M5 S3 S5		
	Hardness/Rm	< 700 N/mm ²			700-1000 N/mm ²			< 35 HRC						< 45 HRC		
	ap x ae	1.5D x 0.3D			1.5D x 0.3D			1.5D x 0.2D						D x 0.1D		
	Vc (m/min)	100-120			60-80			40-60						40-50		
	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)	n (rpm)	fn (mm/rev)	Vf (mm/min)
	6	5840	0.027	620	3720	0.023	340	2650	0.021	230	2390	0.021	200			
	8	4380	0.033	580	2790	0.028	320	1990	0.027	210	1790	0.027	190			
	10	3500	0.038	530	2230	0.032	290	1590	0.030	190	1430	0.030	170			
	12	2920	0.043	500	1860	0.036	270	1330	0.034	180	1190	0.034	160			
	14	2500	0.048	590	1590	0.040	320	1140	0.038	220	1020	0.038	190			
	16	2190	0.054	590	1390	0.046	320	1000	0.043	220	900	0.043	190			
	20	1750	0.069	730	1110	0.059	390	800	0.055	270	720	0.055	240			

INFO

TYPHOON
TA-HTA-4HTATYPHOON
PU-HPUTYPHOON
SUHTYPHOON
ALHTYPHOON
HRCTYPHOON
SUH MINITYPHOON
HL

C-SD-TA

LFTA

SUTA

HSS-HSS/CO
DRILLS

G2

MDTA

HF-VH/UP

MEF

ALU

MEX

UH

HSS/CO-HSSP
END MILLSCARBIDE
BURRS