TYPHOON HVA

HIGH PERFORMANCE - STAINLESS STEEL

High performance tools for stainless steel (ISO M), steel (ISO P), and HRSA super alloys (ISO S) below 45 HRC.

Punte ad alto rendimento per la foratura di acciaio inossidabile (ISO M), acciaio (ISO P) e super leghe (ISO S) sino a 45 HRC.

Hochleistungsbohrer für das Bohren von rostfreiem Stahl (ISO M), Stahl (ISO P) und Superlegierungen (ISO S) bis 45 HRC

Forets haute performance pour le perçage de l'acier inoxydable (ISO M), de l'acier (ISO P) et des super alliages (ISO S) jusqu'à 45 HRC.

Brocas de alto rendimiento para el taladrado de acero inoxidable (ISO M), acero (ISO P) e y súper aleaciones (ISO S) hasta 45 HRC.

Высокопроизводительный инструмент для обработки нержавеющей стали (ISO M), стали (ISO P) и жаропрочных сплавов (ISO S) с твёрдостью до 45 HRC.

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HIGH PERFORMANCE - STAINLESS STEEL

- Self-centering geometry: large chisel edge for highly accurate holes
- Straight cutting edge: short chips for easy evacuation and high reliability
- Large back taper geometry: reduces the torque and improves the cutting efficiency
- Chip pocket design: smooth surface to reduce welding and wide space to improve chip ejection
- Substrate: specifically selected nano grain for high wear resistance, long and reliable life
- Coating: improved new coating technology for high wear resistance

- Affûtage autocentré
large arête transversale pour des trous très précis
- Profil de l'arête droit et renforcé : il génère des copeaux courts et garantit une grande fiabilité
- Géométrie du corps avec conicité arrière pour faciliter l'action de coupe
- Géométrie des goujures: surface lisse pour réduire les problèmes de collage et faciliter l'évacuation des copeaux
- Substrat: des nanograins spécifiquement sélectionnés pour une haute résistance à l'usure, une durée de vie longue et fiable
- Revêtement:
nouvelle technologie de revêtement améliorée pour une haute résistance à l'usure

- Affilatura autocentrante: il particolare design del tagliente trasversale permette forature molto precise
- Profilo del tagliente diritto e rinforzato: genera trucioli corti e garantisce grande affidabilità
- Geometria del corpo con ampia conicità posteriore per agevolare l'azione di taglio
- Geometria delle gole: elevata finitura per ridurre il fenomeno dell'incollaggio e facilitare l'espulsione dei trucioli
- Substrato: nano grani selezionati per elevata resistenza all'usura, lunga durata e affidabilità
- Rivestimento: nuova tecnologia per elevata resistenza all'usura

- Afilado autocentrante amplio filo transversal para agujeros muy precisos
- Perfil del filo recto y reforzado: genera virutas cortas y garantiza una gran fiabilidad
- Geometría del cuerpo con conicidad posterior para facilitar la acción de corte
- Geometría de las ranuras:
Acabado superficial excelente para reducir el problema del encolado y facilitar la evacuación de las virutas
- Sustrato: nanograno específicamente seleccionado para una alta resistencia al desgaste y una vida útil larga y fiable
- Recubrimiento: nueva tecnología de alta resistencia al desgaste

- Selbstzentrierender Schliff: das besondere Design der Querschneide ermöglicht ein sehr präzises Bohren
- Gerades und verstärktes Schneidkantenprofil: zur Erzeugung kurzer Späne und Gewährleistung hoher Zuverlässigkeit
- Geometrie der Schneidkante mit speziellem Schliff zum Schutz von Schneidkante und Kanten
- Nutengeoemtrie: Glattere Oberflächen zur Vermeidung des Klebephänomens und zur Verbesserung der Spanabfuhr
- Substrat: Spezielle Nanokörnung für eine hohe Verschleissbeständigkeit und Standzeit.
- Beschichtung: Verbesserte Beschichtung für eine höhere Verschleissbeständigkeit.

- Самоцентрирующаяся геометрия: особая конструкция режущей кромки обеспечивает очень точное сверление
- Прямые режущие кромки: формирование короткой стружки и высокая надежность
- Геометрия с обратным конусом: увеличивает эффективность обработки
- Геометрия канавки: гладкая поверхность для уменьшения наклепа и большое пространство для улучшения отвода стружки
- Субстрат: специальный нанозернистый твердый сплав для высокой износостойкости, долгого и надежного срока службы
- Покрытие: улучшенная новая технология покрытия для обеспечения высокой износостойкости

353HVA

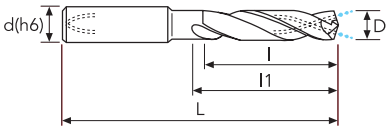
Stainless steel

3XD | DIN 6537K | HVA | MG PV350 | 140° | 30°

353HVA replaces 353SUH.
353HVA will be gradually available as soon as 353SUH stock is phased out

P	M	K	N	S	H
☆	★			☆	

★ 1st choice ☆ suitable



D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
3.00	+0.012/+0.002	6	14	20	62	353HVA0300	●
3.10	+0.016/+0.004	6	14	20	62	353HVA0310	●
3.20	+0.016/+0.004	6	14	20	62	353HVA0320	●
3.30	+0.016/+0.004	6	14	20	62	353HVA0330	●
3.40	+0.016/+0.004	6	14	20	62	353HVA0340	●
3.50	+0.016/+0.004	6	14	20	62	353HVA0350	●
3.60	+0.016/+0.004	6	14	20	62	353HVA0360	●
3.70	+0.016/+0.004	6	14	20	62	353HVA0370	●
3.80	+0.016/+0.004	6	17	24	66	353HVA0380	●
3.90	+0.016/+0.004	6	17	24	66	353HVA0390	●
4.00	+0.016/+0.004	6	17	24	66	353HVA0400	●
4.10	+0.016/+0.004	6	17	24	66	353HVA0410	●
4.20	+0.016/+0.004	6	17	24	66	353HVA0420	●
4.30	+0.016/+0.004	6	17	24	66	353HVA0430	●
4.40	+0.016/+0.004	6	17	24	66	353HVA0440	●
4.50	+0.016/+0.004	6	17	24	66	353HVA0450	●
4.60	+0.016/+0.004	6	17	24	66	353HVA0460	●
4.70	+0.016/+0.004	6	17	24	66	353HVA0470	●
4.80	+0.016/+0.004	6	20	28	66	353HVA0480	●
4.90	+0.016/+0.004	6	20	28	66	353HVA0490	●
5.00	+0.016/+0.004	6	20	28	66	353HVA0500	●
5.10	+0.016/+0.004	6	20	28	66	353HVA0510	●
5.20	+0.016/+0.004	6	20	28	66	353HVA0520	●
5.30	+0.016/+0.004	6	20	28	66	353HVA0530	●
5.40	+0.016/+0.004	6	20	28	66	353HVA0540	●
5.50	+0.016/+0.004	6	20	28	66	353HVA0550	●
5.60	+0.016/+0.004	6	20	28	66	353HVA0560	●
5.70	+0.016/+0.004	6	20	28	66	353HVA0570	●
5.80	+0.016/+0.004	6	20	28	66	353HVA0580	●
5.90	+0.016/+0.004	6	20	28	66	353HVA0590	●
6.00	+0.016/+0.004	6	20	28	66	353HVA0600	●
6.10	+0.021/+0.006	8	24	34	79	353HVA0610	●
6.20	+0.021/+0.006	8	24	34	79	353HVA0620	●
6.30	+0.021/+0.006	8	24	34	79	353HVA0630	●
6.40	+0.021/+0.006	8	24	34	79	353HVA0640	●
6.50	+0.021/+0.006	8	24	34	79	353HVA0650	●
6.60	+0.021/+0.006	8	24	34	79	353HVA0660	●
6.70	+0.021/+0.006	8	24	34	79	353HVA0670	●
6.80	+0.021/+0.006	8	24	34	79	353HVA0680	●

● stock standard ○ non-standard stock ∇ stock exhaustion

353HVA

Stainless steel

3XD | DIN 6537K | HVA | MG PV350 | 140° | 30°

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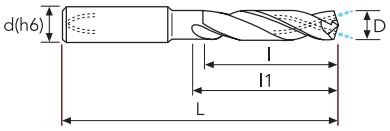
P	M	K	N	S	H
☆	★			☆	

★ 1st choice ☆ suitable



D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
6.90	+0.021/+0.006	8	24	34	79	353HVA0690	●
7.00	+0.021/+0.006	8	24	34	79	353HVA0700	●
7.10	+0.021/+0.006	8	29	41	79	353HVA0710	●
7.20	+0.021/+0.006	8	29	41	79	353HVA0720	●
7.30	+0.021/+0.006	8	29	41	79	353HVA0730	●
7.40	+0.021/+0.006	8	29	41	79	353HVA0740	●
7.50	+0.021/+0.006	8	29	41	79	353HVA0750	●
7.60	+0.021/+0.006	8	29	41	79	353HVA0760	●
7.70	+0.021/+0.006	8	29	41	79	353HVA0770	●
7.80	+0.021/+0.006	8	29	41	79	353HVA0780	●
7.90	+0.021/+0.006	8	29	41	79	353HVA0790	●
8.00	+0.021/+0.006	8	29	41	79	353HVA0800	●
8.10	+0.021/+0.006	10	35	47	89	353HVA0810	●
8.20	+0.021/+0.006	10	35	47	89	353HVA0820	●
8.30	+0.021/+0.006	10	35	47	89	353HVA0830	●
8.40	+0.021/+0.006	10	35	47	89	353HVA0840	●
8.50	+0.021/+0.006	10	35	47	89	353HVA0850	●
8.60	+0.021/+0.006	10	35	47	89	353HVA0860	●
8.70	+0.021/+0.006	10	35	47	89	353HVA0870	●
8.80	+0.021/+0.006	10	35	47	89	353HVA0880	●
8.90	+0.021/+0.006	10	35	47	89	353HVA0890	●
9.00	+0.021/+0.006	10	35	47	89	353HVA0900	●
9.10	+0.021/+0.006	10	35	47	89	353HVA0910	●
9.20	+0.021/+0.006	10	35	47	89	353HVA0920	●
9.30	+0.021/+0.006	10	35	47	89	353HVA0930	●
9.40	+0.021/+0.006	10	35	47	89	353HVA0940	●
9.50	+0.021/+0.006	10	35	47	89	353HVA0950	●
9.60	+0.021/+0.006	10	35	47	89	353HVA0960	●
9.70	+0.021/+0.006	10	35	47	89	353HVA0970	●
9.80	+0.021/+0.006	10	35	47	89	353HVA0980	●
9.90	+0.021/+0.006	10	35	47	89	353HVA0990	●
10.00	+0.021/+0.006	10	35	47	89	353HVA1000	●
10.10	+0.025/+0.007	12	40	55	102	353HVA1010	●
10.20	+0.025/+0.007	12	40	55	102	353HVA1020	●
10.30	+0.025/+0.007	12	40	55	102	353HVA1030	●
10.50	+0.025/+0.007	12	40	55	102	353HVA1050	●
10.60	+0.025/+0.007	12	40	55	102	353HVA1060	●
10.80	+0.025/+0.007	12	40	55	102	353HVA1080	●
11.00	+0.025/+0.007	12	40	55	102	353HVA1100	●

● stock standard ○ non-standard stock ∇ stock exhaustion

353HVA

Stainless steel

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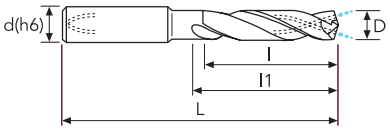


D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
11.20	+0.025/+0.007	12	40	55	102	353HVA1120	●
11.50	+0.025/+0.007	12	40	55	102	353HVA1150	●
11.80	+0.025/+0.007	12	40	55	102	353HVA1180	●
12.00	+0.025/+0.007	12	40	55	102	353HVA1200	●
12.10	+0.025/+0.007	14	43	60	107	353HVA1210	●
12.20	+0.025/+0.007	14	43	60	107	353HVA1220	●
12.50	+0.025/+0.007	14	43	60	107	353HVA1250	●
12.80	+0.025/+0.007	14	43	60	107	353HVA1280	●
13.00	+0.025/+0.007	14	43	60	107	353HVA1300	●
13.30	+0.025/+0.007	14	43	60	107	353HVA1330	●
13.50	+0.025/+0.007	14	43	60	107	353HVA1350	●
13.80	+0.025/+0.007	14	43	60	107	353HVA1380	●
14.00	+0.025/+0.007	14	43	60	107	353HVA1400	●
14.10	+0.025/+0.007	16	45	65	115	353HVA1410	●
14.20	+0.025/+0.007	16	45	65	115	353HVA1420	●
14.50	+0.025/+0.007	16	45	65	115	353HVA1450	●
15.00	+0.025/+0.007	16	49	65	115	353HVA1500	●
15.30	+0.025/+0.007	16	49	65	115	353HVA1530	●
15.50	+0.025/+0.007	16	49	65	115	353HVA1550	●
15.80	+0.025/+0.007	16	49	65	115	353HVA1580	●
16.00	+0.025/+0.007	16	49	65	115	353HVA1600	●
16.50	+0.025/+0.007	18	52	73	123	353HVA1650	●
17.00	+0.025/+0.007	18	52	73	123	353HVA1700	●
17.50	+0.025/+0.007	18	52	73	123	353HVA1750	●
18.00	+0.025/+0.007	18	52	73	123	353HVA1800	●
18.50	+0.029/+0.008	20	55	79	131	353HVA1850	●
19.00	+0.029/+0.008	20	55	79	131	353HVA1900	●
19.50	+0.029/+0.008	20	55	79	131	353HVA1950	●
20.00	+0.029/+0.008	20	55	79	131	353HVA2000	●

● stock standard ○ non-standard stock ∇ stock exhaustion

CUTTING PARAMETERS

353HVA

Ø RUN OUT <0.02mm	Material Group ISO 513	P1 P2	P3 P4	P5	P6	P7	P8
	Hardness/Rm	500÷700 N/mm²	600÷1000 N/mm²	900÷1200 N/mm²	1200÷1400 N/mm²	<700 N/mm²	850÷1200 N/mm²
	Vc (m/min)	**100÷140**	**80÷120**	**70÷90**	**50÷70**	**50÷70**	**20÷30**
	D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)
	3	0.118	0.106	0.095	0.083	0.077	0.046
	4	0.140	0.126	0.112	0.098	0.091	0.055
	5	0.161	0.145	0.129	0.113	0.105	0.063
	6	0.183	0.164	0.146	0.128	0.119	0.071
	7	0.204	0.184	0.163	0.143	0.133	0.080
	8	0.226	0.203	0.181	0.158	0.147	0.088
	9	0.247	0.223	0.198	0.173	0.161	0.096
	10	0.269	0.242	0.215	0.188	0.175	0.105
	11	0.280	0.252	0.224	0.196	0.182	0.109
	12	0.301	0.271	0.241	0.211	0.196	0.117
	13	0.323	0.290	0.258	0.226	0.210	0.126
	14	0.344	0.310	0.275	0.241	0.224	0.134
	15	0.366	0.329	0.292	0.256	0.238	0.143
	16	0.387	0.348	0.310	0.271	0.252	0.151
	17	0.398	0.358	0.318	0.278	0.259	0.155
	18	0.409	0.368	0.327	0.286	0.266	0.159
	19	0.419	0.377	0.335	0.293	0.273	0.164
	20	0.430	0.387	0.344	0.301	0.280	0.168

Ø RUN OUT <0.02mm	Material Group ISO 513	M1	M2	M3			
	Hardness/Rm	<750 N/mm²	550÷850 N/mm²	650÷950 N/mm²			
	Vc (m/min)	**50÷70**	**45÷65**	**35÷50**			
	D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)			
	3	0.077	0.061	0.054			
	4	0.091	0.073	0.064			
	5	0.105	0.084	0.073			
	6	0.119	0.095	0.083			
	7	0.133	0.106	0.093			
	8	0.147	0.117	0.103			
	9	0.161	0.129	0.112			
	10	0.175	0.140	0.122			
	11	0.182	0.145	0.127			
	12	0.196	0.157	0.137			
	13	0.210	0.168	0.147			
	14	0.224	0.179	0.157			
	15	0.238	0.190	0.166			
	16	0.252	0.201	0.176			
	17	0.259	0.207	0.181			
	18	0.266	0.212	0.186			
	19	0.273	0.218	0.191			
	20	0.280	0.224	0.196			

CUTTING PARAMETERS

353HVA

	Material Group ISO 513	S1 S2	S3	S4	S5		
	Hardness/Rm	<35 N/mm²	35÷45 N/mm²				
	Vc (m/min)	**30÷50**	**25÷45**	**30÷45**	**25÷35**		
	D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
	3	0.053	0.037	0.051	0.043		
	4	0.063	0.044	0.060	0.050		
	5	0.073	0.051	0.069	0.058		
	6	0.082	0.058	0.078	0.066		
	7	0.092	0.064	0.087	0.074		
	8	0.102	0.071	0.097	0.081		
	9	0.111	0.078	0.106	0.089		
	10	0.121	0.085	0.115	0.097		
	11	0.126	0.088	0.119	0.101		
	12	0.135	0.095	0.129	0.108		
	13	0.145	0.102	0.138	0.116		
	14	0.155	0.108	0.147	0.124		
	15	0.164	0.115	0.156	0.132		
	16	0.174	0.122	0.165	0.139		
	17	0.179	0.125	0.170	0.143		
	18	0.184	0.129	0.175	0.147		
	19	0.189	0.132	0.179	0.151		
	20	0.194	0.135	0.185	0.155		

355HVA

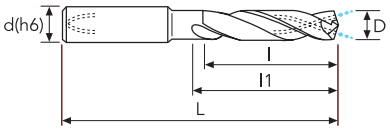
Stainless steel

5XD | DIN 6537L | HVA | MG PV350 | 140° | 30°

355HVA replaces 355SUH.
355HVA will be gradually available as soon as 355SUH stock is phased out

P	M	K	N	S	H
☆	★			☆	

★ 1st choice ☆ suitable



D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
3.00	+0.012/+0.002	6	23	28	66	355HVA0300	●
3.10	+0.016/+0.004	6	23	28	66	355HVA0310	●
3.20	+0.016/+0.004	6	23	28	66	355HVA0320	●
3.30	+0.016/+0.004	6	23	28	66	355HVA0330	●
3.40	+0.016/+0.004	6	23	28	66	355HVA0340	●
3.50	+0.016/+0.004	6	23	28	66	355HVA0350	●
3.60	+0.016/+0.004	6	23	28	66	355HVA0360	●
3.70	+0.016/+0.004	6	23	28	66	355HVA0370	●
3.80	+0.016/+0.004	6	29	36	74	355HVA0380	●
3.90	+0.016/+0.004	6	29	36	74	355HVA0390	●
4.00	+0.016/+0.004	6	29	36	74	355HVA0400	●
4.10	+0.016/+0.004	6	29	36	74	355HVA0410	●
4.20	+0.016/+0.004	6	29	36	74	355HVA0420	●
4.30	+0.016/+0.004	6	29	36	74	355HVA0430	●
4.40	+0.016/+0.004	6	29	36	74	355HVA0440	●
4.50	+0.016/+0.004	6	29	36	74	355HVA0450	●
4.60	+0.016/+0.004	6	29	36	74	355HVA0460	●
4.70	+0.016/+0.004	6	29	36	74	355HVA0470	●
4.80	+0.016/+0.004	6	35	44	82	355HVA0480	●
4.90	+0.016/+0.004	6	35	44	82	355HVA0490	●
5.00	+0.016/+0.004	6	35	44	82	355HVA0500	●
5.10	+0.016/+0.004	6	35	44	82	355HVA0510	●
5.20	+0.016/+0.004	6	35	44	82	355HVA0520	●
5.30	+0.016/+0.004	6	35	44	82	355HVA0530	●
5.40	+0.016/+0.004	6	35	44	82	355HVA0540	●
5.50	+0.016/+0.004	6	35	44	82	355HVA0550	●
5.60	+0.016/+0.004	6	35	44	82	355HVA0560	●
5.70	+0.016/+0.004	6	35	44	82	355HVA0570	●
5.80	+0.016/+0.004	6	35	44	82	355HVA0580	●
5.90	+0.016/+0.004	6	35	44	82	355HVA0590	●
6.00	+0.016/+0.004	6	35	44	82	355HVA0600	●
6.10	+0.021/+0.006	8	43	53	91	355HVA0610	●
6.20	+0.021/+0.006	8	43	53	91	355HVA0620	●
6.30	+0.021/+0.006	8	43	53	91	355HVA0630	●
6.40	+0.021/+0.006	8	43	53	91	355HVA0640	●
6.50	+0.021/+0.006	8	43	53	91	355HVA0650	●
6.60	+0.021/+0.006	8	43	53	91	355HVA0660	●
6.70	+0.021/+0.006	8	43	53	91	355HVA0670	●
6.80	+0.021/+0.006	8	43	53	91	355HVA0680	●

355HVA

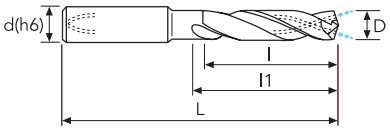
Stainless steel

5XD | DIN 6537L | HVA | MG PV350 | 140° | 30°

355HVA replaces 355SUH.
355HVA will be gradually available as soon as 355SUH stock is phased out

P	M	K	N	S	H
☆	★			☆	

★ 1st choice ☆ suitable



D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
6.90	+0.021/+0.006	8	43	53	91	355HVA0690	●
7.00	+0.021/+0.006	8	43	53	91	355HVA0700	●
7.10	+0.021/+0.006	8	43	53	91	355HVA0710	●
7.20	+0.021/+0.006	8	43	53	91	355HVA0720	●
7.30	+0.021/+0.006	8	43	53	91	355HVA0730	●
7.40	+0.021/+0.006	8	43	53	91	355HVA0740	●
7.50	+0.021/+0.006	8	43	53	91	355HVA0750	●
7.60	+0.021/+0.006	8	43	53	91	355HVA0760	●
7.70	+0.021/+0.006	8	43	53	91	355HVA0770	●
7.80	+0.021/+0.006	8	43	53	91	355HVA0780	●
7.90	+0.021/+0.006	8	43	53	91	355HVA0790	●
8.00	+0.021/+0.006	8	43	53	91	355HVA0800	●
8.10	+0.021/+0.006	10	49	61	103	355HVA0810	●
8.20	+0.021/+0.006	10	49	61	103	355HVA0820	●
8.30	+0.021/+0.006	10	49	61	103	355HVA0830	●
8.40	+0.021/+0.006	10	49	61	103	355HVA0840	●
8.50	+0.021/+0.006	10	49	61	103	355HVA0850	●
8.60	+0.021/+0.006	10	49	61	103	355HVA0860	●
8.70	+0.021/+0.006	10	49	61	103	355HVA0870	●
8.80	+0.021/+0.006	10	49	61	103	355HVA0880	●
8.90	+0.021/+0.006	10	49	61	103	355HVA0890	●
9.00	+0.021/+0.006	10	49	61	103	355HVA0900	●
9.10	+0.021/+0.006	10	49	61	103	355HVA0910	●
9.20	+0.021/+0.006	10	49	61	103	355HVA0920	●
9.30	+0.021/+0.006	10	49	61	103	355HVA0930	●
9.40	+0.021/+0.006	10	49	61	103	355HVA0940	●
9.50	+0.021/+0.006	10	49	61	103	355HVA0950	●
9.60	+0.021/+0.006	10	49	61	103	355HVA0960	●
9.70	+0.021/+0.006	10	49	61	103	355HVA0970	●
9.80	+0.021/+0.006	10	49	61	103	355HVA0980	●
9.90	+0.021/+0.006	10	49	61	103	355HVA0990	●
10.00	+0.021/+0.006	10	49	61	103	355HVA1000	●
10,10	+0.025/+0.007	12	52	71	118	355HVA1010	●
10.20	+0.025/+0.007	12	52	71	118	355HVA1020	●
10.30	+0.025/+0.007	12	52	71	118	355HVA1030	●
10.50	+0.025/+0.007	12	52	71	118	355HVA1050	●
10,60	+0.025/+0.007	12	52	71	118	355HVA1060	●
10.80	+0.025/+0.007	12	52	71	118	355HVA1080	●
11.00	+0.025/+0.007	12	52	71	118	355HVA1100	●

355HVA

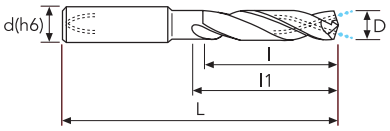
Stainless steel

5XD | DIN 6537L | HVA | MG PV350 | 140° | 30°

355HVA replaces 355SUH.
355HVA will be gradually available as soon as 355SUH stock is phased out

P	M	K	N	S	H
☆	★			☆	

★ 1st choice ☆ suitable



D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
11,10	+0.025/+0.007	12	52	71	118	355HVA1110	●
11.20	+0.025/+0.007	12	52	71	118	355HVA1120	●
11.30	+0.025/+0.007	12	52	71	118	355HVA1130	●
11.50	+0.025/+0.007	12	52	71	118	355HVA1150	●
11.80	+0.025/+0.007	12	52	71	118	355HVA1180	●
12.00	+0.025/+0.007	12	52	71	118	355HVA1200	●
12,10	+0.025/+0.007	14	63	77	124	355HVA1210	●
12.20	+0.025/+0.007	14	63	77	124	355HVA1220	●
12.50	+0.025/+0.007	14	63	77	124	355HVA1250	●
12.80	+0.025/+0.007	14	63	77	124	355HVA1280	●
13.00	+0.025/+0.007	14	63	77	124	355HVA1300	●
13.30	+0.025/+0.007	14	63	77	124	355HVA1330	●
13.50	+0.025/+0.007	14	63	77	124	355HVA1350	●
13.80	+0.025/+0.007	14	63	77	124	355HVA1380	●
14.00	+0.025/+0.007	14	63	77	124	355HVA1400	●
14.10	+0.025/+0.007	16	67	83	133	355HVA1410	●
14.20	+0.025/+0.007	16	67	83	133	355HVA1420	●
14.50	+0.025/+0.007	16	67	83	133	355HVA1450	●
15.00	+0.025/+0.007	16	67	83	133	355HVA1500	●
15.30	+0.025/+0.007	16	67	83	133	355HVA1530	●
15.50	+0.025/+0.007	16	67	83	133	355HVA1550	●
15.80	+0.025/+0.007	16	67	83	133	355HVA1580	●
16.00	+0.025/+0.007	16	67	83	133	355HVA1600	●
16.50	+0.025/+0.007	18	75	93	143	355HVA1650	●
17.00	+0.025/+0.007	18	75	93	143	355HVA1700	●
17.50	+0.025/+0.007	18	75	93	143	355HVA1750	●
18.00	+0.025/+0.007	18	75	93	143	355HVA1800	●
18.50	+0.029/+0.008	20	81	101	153	355HVA1850	●
19.00	+0.029/+0.008	20	81	101	153	355HVA1900	●
19.50	+0.029/+0.008	20	81	101	153	355HVA1950	●
20.00	+0.029/+0.008	20	81	101	153	355HVA2000	●

CUTTING PARAMETERS

355HVA

Ø RUN OUT <0.02mm	Material Group ISO 513	P1 P2	P3 P4	P5	P6	P7	P8
	Hardness/Rm	500÷700 N/mm²	600÷1000 N/mm²	900÷1200 N/mm²	1200÷1400 N/mm²	<700 N/mm²	850÷1200 N/mm²
	Vc (m/min)	**100÷140**	**80÷120**	**70÷90**	**50÷70**	**50÷70**	**20÷30**
	D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)
	3	0.101	0.075	0.060	0.050	0.065	0.039
	4	0.119	0.089	0.071	0.059	0.077	0.046
	5	0.137	0.103	0.082	0.069	0.089	0.053
	6	0.155	0.117	0.093	0.078	0.101	0.061
	7	0.174	0.130	0.104	0.087	0.113	0.068
	8	0.192	0.144	0.115	0.096	0.125	0.075
	9	0.210	0.158	0.126	0.105	0.137	0.082
	10	0.228	0.171	0.137	0.114	0.148	0.089
	11	0.238	0.178	0.143	0.119	0.154	0.093
	12	0.256	0.192	0.154	0.128	0.166	0.100
	13	0.274	0.206	0.164	0.137	0.178	0.107
	14	0.292	0.219	0.175	0.146	0.190	0.114
	15	0.311	0.233	0.186	0.155	0.202	0.121
	16	0.329	0.247	0.197	0.164	0.214	0.128
	17	0.338	0.254	0.203	0.169	0.220	0.132
	18	0.347	0.260	0.208	0.174	0.226	0.135
	19	0.356	0.267	0.214	0.178	0.232	0.139
	20	0.366	0.274	0.219	0.183	0.238	0.143

Ø RUN OUT <0.02mm	Material Group ISO 513	M1	M2	M3			
	Hardness/Rm	<750 N/mm²	550÷850 N/mm²	650÷950 N/mm²			
	Vc (m/min)	**50÷70**	**45÷65**	**35÷50**			
	D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)			
	3	0.065	0.052	0.046			
	4	0.077	0.062	0.054			
	5	0.089	0.071	0.062			
	6	0.101	0.081	0.071			
	7	0.113	0.090	0.079			
	8	0.125	0.100	0.087			
	9	0.137	0.109	0.096			
	10	0.148	0.119	0.104			
	11	0.154	0.124	0.108			
	12	0.166	0.133	0.116			
	13	0.178	0.143	0.125			
	14	0.190	0.152	0.133			
	15	0.202	0.162	0.141			
	16	0.214	0.171	0.150			
	17	0.220	0.176	0.154			
	18	0.226	0.181	0.158			
	19	0.232	0.185	0.162			
	20	0.238	0.190	0.166			

CUTTING PARAMETERS

355HVA

	Material Group ISO 513	S1 S2	S3	S4	S5		
	Hardness/Rm	<35 N/mm²	35÷45 N/mm²				
	Vc (m/min)	**30÷50**	**25÷45**	**30÷45**	**25÷35**		
	D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
	3	0.045	0.032	0.043	0.036		
	4	0.053	0.037	0.051	0.043		
	5	0.062	0.043	0.059	0.049		
	6	0.070	0.049	0.066	0.056		
	7	0.078	0.055	0.074	0.063		
	8	0.086	0.060	0.082	0.069		
	9	0.095	0.066	0.090	0.076		
	10	0.103	0.072	0.098	0.082		
	11	0.107	0.075	0.102	0.086		
	12	0.115	0.081	0.109	0.092		
	13	0.123	0.086	0.117	0.099		
	14	0.132	0.092	0.125	0.105		
	15	0.140	0.098	0.133	0.112		
	16	0.148	0.104	0.141	0.118		
	17	0.152	0.106	0.145	0.122		
	18	0.156	0.109	0.148	0.125		
	19	0.160	0.112	0.152	0.128		
	20	0.164	0.115	0.156	0.132		