

CUTTING PARAMETERS

MEFCS4

	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 0.1D			1.5D x 0.1D			1.5D x 0.1D						1.5D x 0.1D		
	Vc (m/min)	90-110			60-80			40-60						30-50		
	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)
	3	10620	0.012	510	7430	0.010	300	5310	0.010	200	4250	0.010	160			
	4	7960	0.015	480	5570	0.013	280	3980	0.012	190	3180	0.012	150			
	5	6370	0.018	460	4460	0.015	270	3180	0.014	180	2550	0.014	150			
	6	5310	0.023	490	3720	0.020	290	2650	0.018	200	2120	0.018	160			
	8	3980	0.030	480	2790	0.026	280	1990	0.024	190	1590	0.024	150			
	10	3180	0.038	480	2230	0.032	290	1590	0.030	190	1270	0.030	150			
	12	2650	0.045	480	1860	0.038	280	1330	0.036	190	1060	0.036	150			
	14	2270	0.052	470	1590	0.044	280	1140	0.042	190	910	0.042	150			
	16	1990	0.058	460	1390	0.049	270	1000	0.046	190	800	0.046	150			
	18	1770	0.066	470	1240	0.056	280	880	0.053	190	710	0.053	150			
	20	1590	0.075	480	1110	0.064	280	800	0.060	190	640	0.060	150			

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