



## TYPHOON SUH

HIGH PERFORMANCE - STAINLESS STEEL

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

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

🇩🇪 Hochleistungsbohrer für das Bohren von rostfreiem Stahl (ISO M), Stahl (ISO P), Gusseisen (ISO K) und Superlegierungen (ISO S) bis 45 HRC.

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

🇪🇸 Puntas de alto rendimiento para el taladro de acero inoxidable (ISO M), acero (ISO P), hierro fundido (ISO K) e súper aleaciones (ISO S) hasta 45 HRC.

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

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

**TYPHOON SUH**
**HIGH PERFORMANCE - STAINLESS STEEL**

INFO
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CARBIDE BURRS



- Self-centering geometry: highly accurate holes
- Straight cutting edge: short chips for easy evacuation and high reliability
- Special edge design: high performance and edge protection
- Back taper geometry: improves the cutting efficiency
- Chip pocket finishing: highly polished to reduce welding and improve chip ejection
- Large oil holes: improves coolant feed
- Substrate and coating: specifically selected for high wear resistance, long and reliable life



- Affûtage autocentré pour l'exécution de trous précis
- Profil de l'arête droit et renforcé : il génère des copeaux courts et garantit une grande fiabilité
- Géométrie de l'arête avec affûtage spécifique pour protéger l'arête et les angles
- Géométrie du corps avec conicité arrière pour faciliter l'action de coupe
- Finition des goujures : polie pour réduire le problème du collage et facilitent l'évacuation des copeaux
- Trous de lubrification avec géométrie modifiée pour un apport de lubrifiant plus important
- Substrat et revêtement spécifiques pour garantir durée et fiabilité



- Affilatura autocentrante per l'esecuzione di fori precisi
- Profilo del tagliente diritto e rinforzato: genera trucioli corti e garantisce grande affidabilità
- Geometria del tagliente con affilatura specifica a protezione del tagliente e degli spigoli
- Geometria del corpo con conicità posteriore per agevolare l'azione di taglio
- Finitura gole: lappate per ridurre il problema dell'incollaggio e facilitare l'evacuazione dei trucioli
- Fori di refrigerazione con geometria modificata per un maggior apporto di refrigerante
- Substrato e rivestimento specifici per garantire durata e affidabilità



- Afilado autocentrante para la ejecución de agujeros precisos
- Perfil del filo recto y reforzado: genera virutas cortas y garantiza una gran fiabilidad
- Geometría del filo con afilado específico para proteger el filo y los ángulos
- Geometría del cuerpo con conicidad posterior para facilitar la acción de corte
- Acabado ranuras: lapeadas para reducir el problema del encolado y facilitar la evacuación de las virutas
- Agujeros de refrigeración con geometría modificada para una mayor aportación de refrigerante
- Substrato y revestimiento específicos para garantizar duración y fiabilidad



- Selbstzentrierender Schliff für die Herstellung von präzisen Bohrungen
- Gerades und verstärktes Schneidkantenprofil: zur Erzeugung kurzer Späne und zur Gewährleistung hoher Zuverlässigkeit
- Geometrie der Schneidkante mit speziellem Schliff zum Schutz von Schneidkante und Kanten
- Geometrie des Körpers mit konischem hinteren Bereich zur Erleichterung des Schnittvorgangs
- Schlichtbearbeitung der Nuten: geläppt, um Probleme durch Verkleben zu reduzieren und um die Späneabführung zu erleichtern
- Kühlöffnungen mit abgeänderter Geometrie für einen verbesserten Kühlmittelzufluss
- Spezielles Trägermaterial und spezielle Beschichtung zur Gewährleistung von Standzeit und Zuverlässigkeit



- Самоцентрирующаяся геометрия: высокая точность отверстий
- Прямые режущие кромки: формирование короткой стружки и высокая надежность
- Геометрия режущей кромки со специальной заточкой: высокая производительность и защита кромок
- Геометрия с обратным конусом: увеличивает эффективность обработки
- Отполированные стружечные канавки: уменьшают вероятность приваривания стружки и облегчают ее вывод
- Широкие каналы для СОЖ: увеличена эффективность подвода СОЖ
- Специальное покрытие для повышения стойкости инструмента

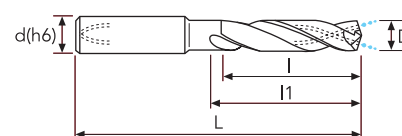
# 353SUH

stainless steel, polished flutes, SUH (through coolant)



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	353SUH0300	●
3.10	+0.016/+0.004	6	14	20	62	353SUH0310	●
3.20	+0.016/+0.004	6	14	20	62	353SUH0320	●
3.30	+0.016/+0.004	6	14	20	62	353SUH0330	●
3.40	+0.016/+0.004	6	14	20	62	353SUH0340	●
3.50	+0.016/+0.004	6	14	20	62	353SUH0350	●
3.60	+0.016/+0.004	6	14	20	62	353SUH0360	●
3.70	+0.016/+0.004	6	14	20	62	353SUH0370	●
3.80	+0.016/+0.004	6	17	24	66	353SUH0380	●
3.90	+0.016/+0.004	6	17	24	66	353SUH0390	●
4.00	+0.016/+0.004	6	17	24	66	353SUH0400	●
4.10	+0.016/+0.004	6	17	24	66	353SUH0410	●
4.20	+0.016/+0.004	6	17	24	66	353SUH0420	●
4.30	+0.016/+0.004	6	17	24	66	353SUH0430	●
4.40	+0.016/+0.004	6	17	24	66	353SUH0440	●
4.50	+0.016/+0.004	6	17	24	66	353SUH0450	●
4.60	+0.016/+0.004	6	17	24	66	353SUH0460	●
4.70	+0.016/+0.004	6	17	24	66	353SUH0470	●
4.80	+0.016/+0.004	6	20	28	66	353SUH0480	●
4.90	+0.016/+0.004	6	20	28	66	353SUH0490	●
5.00	+0.016/+0.004	6	20	28	66	353SUH0500	●
5.10	+0.016/+0.004	6	20	28	66	353SUH0510	●
5.20	+0.016/+0.004	6	20	28	66	353SUH0520	●
5.30	+0.016/+0.004	6	20	28	66	353SUH0530	●
5.40	+0.016/+0.004	6	20	28	66	353SUH0540	●
5.50	+0.016/+0.004	6	20	28	66	353SUH0550	●
5.60	+0.016/+0.004	6	20	28	66	353SUH0560	●
5.70	+0.016/+0.004	6	20	28	66	353SUH0570	●
5.80	+0.016/+0.004	6	20	28	66	353SUH0580	●
5.90	+0.016/+0.004	6	20	28	66	353SUH0590	●
6.00	+0.016/+0.004	6	20	28	66	353SUH0600	●
6.10	+0.021/+0.006	8	24	34	79	353SUH0610	●
6.20	+0.021/+0.006	8	24	34	79	353SUH0620	●
6.30	+0.021/+0.006	8	24	34	79	353SUH0630	●
6.40	+0.021/+0.006	8	24	34	79	353SUH0640	●
6.50	+0.021/+0.006	8	24	34	79	353SUH0650	●
6.60	+0.021/+0.006	8	24	34	79	353SUH0660	●
6.70	+0.021/+0.006	8	24	34	79	353SUH0670	●
6.80	+0.021/+0.006	8	24	34	79	353SUH0680	●

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CARBIDE BURRS

● stock standard ○ non-standard stock ▽ stock exhaustion

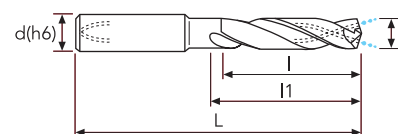
# 353SUH

stainless steel, polished flutes, SUH (through coolant)



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☆	★	☆	☆	☆	

★ 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	353SUH0690	●
7.00	+0.021/+0.006	8	24	34	79	353SUH0700	●
7.10	+0.021/+0.006	8	29	41	79	353SUH0710	●
7.20	+0.021/+0.006	8	29	41	79	353SUH0720	●
7.30	+0.021/+0.006	8	29	41	79	353SUH0730	●
7.40	+0.021/+0.006	8	29	41	79	353SUH0740	●
7.50	+0.021/+0.006	8	29	41	79	353SUH0750	●
7.60	+0.021/+0.006	8	29	41	79	353SUH0760	●
7.70	+0.021/+0.006	8	29	41	79	353SUH0770	●
7.80	+0.021/+0.006	8	29	41	79	353SUH0780	●
7.90	+0.021/+0.006	8	29	41	79	353SUH0790	●
8.00	+0.021/+0.006	8	29	41	79	353SUH0800	●
8.10	+0.021/+0.006	10	35	47	89	353SUH0810	●
8.20	+0.021/+0.006	10	35	47	89	353SUH0820	●
8.30	+0.021/+0.006	10	35	47	89	353SUH0830	●
8.40	+0.021/+0.006	10	35	47	89	353SUH0840	●
8.50	+0.021/+0.006	10	35	47	89	353SUH0850	●
8.60	+0.021/+0.006	10	35	47	89	353SUH0860	●
8.70	+0.021/+0.006	10	35	47	89	353SUH0870	●
8.80	+0.021/+0.006	10	35	47	89	353SUH0880	●
8.90	+0.021/+0.006	10	35	47	89	353SUH0890	●
9.00	+0.021/+0.006	10	35	47	89	353SUH0900	●
9.10	+0.021/+0.006	10	35	47	89	353SUH0910	●
9.20	+0.021/+0.006	10	35	47	89	353SUH0920	●
9.30	+0.021/+0.006	10	35	47	89	353SUH0930	●
9.40	+0.021/+0.006	10	35	47	89	353SUH0940	●
9.50	+0.021/+0.006	10	35	47	89	353SUH0950	●
9.60	+0.021/+0.006	10	35	47	89	353SUH0960	●
9.70	+0.021/+0.006	10	35	47	89	353SUH0970	●
9.80	+0.021/+0.006	10	35	47	89	353SUH0980	●
9.90	+0.021/+0.006	10	35	47	89	353SUH0990	●
10.00	+0.021/+0.006	10	35	47	89	353SUH1000	●
10.20	+0.025/+0.007	12	40	55	102	353SUH1020	●
10.50	+0.025/+0.007	12	40	55	102	353SUH1050	●
10.80	+0.025/+0.007	12	40	55	102	353SUH1080	●
11.00	+0.025/+0.007	12	40	55	102	353SUH1100	●
11.20	+0.025/+0.007	12	40	55	102	353SUH1120	○
11.30	+0.025/+0.007	12	40	55	102	353SUH1130	○
11.50	+0.025/+0.007	12	40	55	102	353SUH1150	●

● stock standard ○ non-standard stock ▽ stock exhaustion

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3XD

DIN  
6537K

SUH

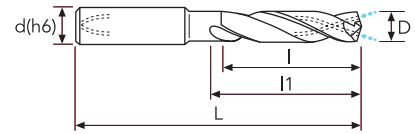
MG  
PV300

140°

30°

P	M	K	N	S	H
☆	★	☆	☆	☆	☆

★ 1st choice ☆ suitable



D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
11.80	+0.025/+0.007	12	40	55	102	353SUH1180	●
12.00	+0.025/+0.007	12	40	55	102	353SUH1200	●
12.20	+0.025/+0.007	14	43	60	107	353SUH1220	●
12.50	+0.025/+0.007	14	43	60	107	353SUH1250	●
12.80	+0.025/+0.007	14	43	60	107	353SUH1280	●
13.00	+0.025/+0.007	14	43	60	107	353SUH1300	●
13.30	+0.025/+0.007	14	43	60	107	353SUH1330	●
13.50	+0.025/+0.007	14	43	60	107	353SUH1350	●
13.80	+0.025/+0.007	14	43	60	107	353SUH1380	●
14.00	+0.025/+0.007	14	43	60	107	353SUH1400	●
14.50	+0.025/+0.007	16	45	65	115	353SUH1450	●
15.00	+0.025/+0.007	16	65	65	115	353SUH1500	●
15.30	+0.025/+0.007	16	65	65	115	353SUH1530	●
15.50	+0.025/+0.007	16	65	65	115	353SUH1550	●
15.80	+0.025/+0.007	16	65	65	115	353SUH1580	●
16.00	+0.025/+0.007	16	65	65	115	353SUH1600	●
16.50	+0.025/+0.007	18	73	73	123	353SUH1650	●
17.00	+0.025/+0.007	18	73	73	123	353SUH1700	●
17.50	+0.025/+0.007	18	73	73	123	353SUH1750	●
18.00	+0.025/+0.007	18	73	73	123	353SUH1800	●
18.50	+0.029/+0.008	20	79	79	131	353SUH1850	●
19.00	+0.029/+0.008	20	79	79	131	353SUH1900	●
19.50	+0.029/+0.008	20	79	79	131	353SUH1950	●
20.00	+0.029/+0.008	20	79	79	131	353SUH2000	●

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CARBIDE BURRS

● stock standard ○ non-standard stock ▽ stock exhaustion

### 353SUH

	Material Group ISO 513	P1 P2			P3 P4			P5			P6		
	Hardness/Rm	500-700 N/mm <sup>2</sup>			600-1000 N/mm <sup>2</sup>			900-1200 N/mm <sup>2</sup>			1200-1400 N/mm <sup>2</sup>		
	Vc (m/min)	130-150			100-140			80-100			55-75		
	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)
<b>3</b>	14860	0.118	1760	12740	0.106	1360	9550	0.095	900	6900	0.083	570	
<b>4</b>	11150	0.140	1560	9550	0.126	1200	7170	0.112	800	5180	0.098	510	
<b>5</b>	8920	0.161	1440	7640	0.145	1110	5730	0.129	740	4140	0.113	470	
<b>6</b>	7430	0.183	1360	6370	0.164	1050	4780	0.146	700	3450	0.128	440	
<b>7</b>	6370	0.204	1300	5460	0.184	1000	4090	0.163	670	2960	0.143	420	
<b>8</b>	5570	0.226	1260	4780	0.203	970	3580	0.181	650	2590	0.158	410	
<b>9</b>	4950	0.247	1220	4250	0.223	950	3180	0.198	630	2300	0.173	400	
<b>10</b>	4460	0.269	1200	3820	0.242	920	2870	0.215	620	2070	0.188	390	
<b>11</b>	4050	0.280	1130	3470	0.252	870	2610	0.224	580	1880	0.196	370	
<b>12</b>	3720	0.301	1120	3180	0.271	860	2390	0.241	580	1730	0.211	360	
<b>13</b>	3430	0.323	1110	2940	0.290	850	2200	0.258	570	1590	0.226	360	
<b>14</b>	3180	0.344	1090	2730	0.310	850	2050	0.275	560	1480	0.241	360	
<b>15</b>	2970	0.366	1090	2550	0.329	840	1910	0.292	560	1380	0.256	350	
<b>16</b>	2790	0.387	1080	2390	0.348	830	1790	0.310	550	1290	0.271	350	
<b>17</b>	2620	0.398	1040	2250	0.358	810	1690	0.318	540	1220	0.278	340	
<b>18</b>	2480	0.409	1010	2120	0.368	780	1590	0.327	520	1150	0.286	330	
<b>19</b>	2350	0.419	990	2010	0.377	760	1510	0.335	510	1090	0.293	320	
<b>20</b>	2230	0.430	960	1910	0.387	740	1430	0.344	490	1040	0.301	310	



	Material Group ISO 513	M1 M2			M3			M4			M5		
	Hardness/Rm	< 750 N/mm <sup>2</sup>			550-850 N/mm <sup>2</sup>			650-950 N/mm <sup>2</sup>			850-1200 N/mm <sup>2</sup>		
	Vc (m/min)	50-70			40-60			30-40			20-30		
	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)
<b>3</b>	6370	0.077	490	5310	0.061	330	3720	0.054	200	2650	0.046	120	
<b>4</b>	4780	0.091	430	3980	0.073	290	2790	0.064	180	1990	0.055	110	
<b>5</b>	3820	0.105	400	3180	0.084	270	2230	0.073	160	1590	0.063	100	
<b>6</b>	3180	0.119	380	2650	0.095	250	1860	0.083	150	1330	0.071	90	
<b>7</b>	2730	0.133	360	2270	0.106	240	1590	0.093	150	1140	0.080	90	
<b>8</b>	2390	0.147	350	1990	0.117	230	1390	0.103	140	1000	0.088	90	
<b>9</b>	2120	0.161	340	1770	0.129	230	1240	0.112	140	880	0.096	80	
<b>10</b>	1910	0.175	330	1590	0.140	220	1110	0.122	140	800	0.105	80	
<b>11</b>	1740	0.182	320	1450	0.145	210	1010	0.127	130	720	0.109	80	
<b>12</b>	1590	0.196	310	1330	0.157	210	930	0.137	130	660	0.117	80	
<b>13</b>	1470	0.210	310	1220	0.168	200	860	0.147	130	610	0.126	80	
<b>14</b>	1360	0.224	300	1140	0.179	200	800	0.157	130	570	0.134	80	
<b>15</b>	1270	0.238	300	1060	0.190	200	740	0.166	120	530	0.143	80	
<b>16</b>	1190	0.252	300	1000	0.201	200	700	0.176	120	500	0.151	80	
<b>17</b>	1120	0.259	290	940	0.207	190	660	0.181	120	470	0.155	70	
<b>18</b>	1060	0.266	280	880	0.212	190	620	0.186	120	440	0.159	70	
<b>19</b>	1010	0.273	280	840	0.218	180	590	0.191	110	420	0.164	70	
<b>20</b>	960	0.280	270	800	0.224	180	560	0.196	110	400	0.168	70	





### 353SUH

	Material Group ISO 513	K1			K2			K3			K4		
	Hardness/Rm	150-250 HB			150-350 HB			120-260 HB			250-500 HB		
	Vc (m/min)	110-130			90-110			70-90			55-75		
	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)
3	12740	0.118	1510	10620	0.106	1130	8490	0.095	800	6900	0.083	570	
4	9550	0.140	1330	7960	0.126	1000	6370	0.112	710	5180	0.098	510	
5	7640	0.161	1230	6370	0.145	920	5100	0.129	660	4140	0.113	470	
6	6370	0.183	1160	5310	0.164	870	4250	0.146	620	3450	0.128	440	
7	5460	0.204	1120	4550	0.184	840	3640	0.163	590	2960	0.143	420	
8	4780	0.226	1080	3980	0.203	810	3180	0.181	570	2590	0.158	410	
9	4250	0.247	1050	3540	0.223	790	2830	0.198	560	2300	0.173	400	
10	3820	0.269	1030	3180	0.242	770	2550	0.215	550	2070	0.188	390	
11	3470	0.280	970	2900	0.252	730	2320	0.224	520	1880	0.196	370	
12	3180	0.301	960	2650	0.271	720	2120	0.241	510	1730	0.211	360	
13	2940	0.323	950	2450	0.290	710	1960	0.258	510	1590	0.226	360	
14	2730	0.344	940	2270	0.310	700	1820	0.275	500	1480	0.241	360	
15	2550	0.366	930	2120	0.329	700	1700	0.292	500	1380	0.256	350	
16	2390	0.387	920	1990	0.348	690	1590	0.310	490	1290	0.271	350	
17	2250	0.398	890	1870	0.358	670	1500	0.318	480	1220	0.278	340	
18	2120	0.409	870	1770	0.368	650	1420	0.327	460	1150	0.286	330	
19	2010	0.419	840	1680	0.377	630	1340	0.335	450	1090	0.293	320	
20	1910	0.430	820	1590	0.387	620	1270	0.344	440	1040	0.301	310	

	Material Group ISO 513	N2			N4								
	Hardness/Rm												
	Vc (m/min)	180-220			160-200								
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)						
3	21230	0.128	2710	19110	0.128	2440							
4	15920	0.151	2400	14330	0.151	2160							
5	12740	0.174	2220	11460	0.174	2000							
6	10620	0.197	2100	9550	0.197	1880							
7	9100	0.221	2010	8190	0.221	1810							
8	7960	0.244	1940	7170	0.244	1750							
9	7080	0.267	1890	6370	0.267	1700							
10	6370	0.290	1850	5730	0.290	1660							
11	5790	0.302	1750	5210	0.302	1570							
12	5310	0.325	1730	4780	0.325	1550							
13	4900	0.348	1710	4410	0.348	1540							
14	4550	0.372	1690	4090	0.372	1520							
15	4250	0.395	1680	3820	0.395	1510							
16	3980	0.418	1660	3580	0.418	1500							
17	3750	0.430	1610	3370	0.430	1450							
18	3540	0.441	1560	3180	0.441	1400							
19	3350	0.453	1520	3020	0.453	1370							
20	3180	0.464	1480	2870	0.464	1330							

- 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

### 353SUH

Material Group ISO 513	S1 S2			S3			S4			S5				
	< 35 HRC			35-45 HRC										
	Vc (m/min)			30-50			20-40			45-65			35-55	
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)		
3	4250	0.053	230	3180	0.037	120	5840	0.051	300	4780	0.043	200		
4	3180	0.063	200	2390	0.044	110	4380	0.060	260	3580	0.050	180		
5	2550	0.073	190	1910	0.051	100	3500	0.069	240	2870	0.058	170		
6	2120	0.082	170	1590	0.058	90	2920	0.078	230	2390	0.066	160		
7	1820	0.092	170	1360	0.064	90	2500	0.087	220	2050	0.074	150		
8	1590	0.102	160	1190	0.071	80	2190	0.097	210	1790	0.081	150		
9	1420	0.111	160	1060	0.078	80	1950	0.106	210	1590	0.089	140		
10	1270	0.121	150	960	0.085	80	1750	0.115	200	1430	0.097	140		
11	1160	0.126	150	870	0.088	80	1590	0.119	190	1300	0.101	130		
12	1060	0.135	140	800	0.095	80	1460	0.129	190	1190	0.108	130		
13	980	0.145	140	730	0.102	70	1350	0.138	190	1100	0.116	130		
14	910	0.155	140	680	0.108	70	1250	0.147	180	1020	0.124	130		
15	850	0.164	140	640	0.115	70	1170	0.156	180	960	0.132	130		
16	800	0.174	140	600	0.122	70	1090	0.165	180	900	0.139	130		
17	750	0.179	130	560	0.125	70	1030	0.170	180	840	0.143	120		
18	710	0.184	130	530	0.129	70	970	0.175	170	800	0.147	120		
19	670	0.189	130	500	0.132	70	920	0.179	160	750	0.151	110		
20	640	0.194	120	480	0.135	70	880	0.155	140	720	0.155	110		



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- HSS/CO-HSSP END MILLS
- CARBIDE BURRS



# 355SUH

stainless steel, polished flutes, SUH (through coolant)



5XD

DIN  
6537L

SUH

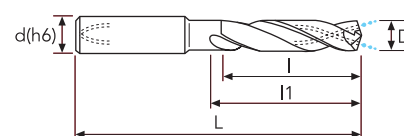
MG  
PV300

140°

30°

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	355SUH0300	●
3.10	+0.016/+0.004	6	23	28	66	355SUH0310	●
3.20	+0.016/+0.004	6	23	28	66	355SUH0320	●
3.30	+0.016/+0.004	6	23	28	66	355SUH0330	●
3.40	+0.016/+0.004	6	23	28	66	355SUH0340	●
3.50	+0.016/+0.004	6	23	28	66	355SUH0350	●
3.60	+0.016/+0.004	6	23	28	66	355SUH0360	●
3.70	+0.016/+0.004	6	23	28	66	355SUH0370	●
3.80	+0.016/+0.004	6	29	36	74	355SUH0380	●
3.90	+0.016/+0.004	6	29	36	74	355SUH0390	●
4.00	+0.016/+0.004	6	29	36	74	355SUH0400	●
4.10	+0.016/+0.004	6	29	36	74	355SUH0410	●
4.20	+0.016/+0.004	6	29	36	74	355SUH0420	●
4.30	+0.016/+0.004	6	29	36	74	355SUH0430	●
4.40	+0.016/+0.004	6	29	36	74	355SUH0440	●
4.50	+0.016/+0.004	6	29	36	74	355SUH0450	●
4.60	+0.016/+0.004	6	29	36	74	355SUH0460	●
4.70	+0.016/+0.004	6	29	36	74	355SUH0470	●
4.80	+0.016/+0.004	6	35	44	82	355SUH0480	●
4.90	+0.016/+0.004	6	35	44	82	355SUH0490	●
5.00	+0.016/+0.004	6	35	44	82	355SUH0500	●
5.10	+0.016/+0.004	6	35	44	82	355SUH0510	●
5.20	+0.016/+0.004	6	35	44	82	355SUH0520	●
5.30	+0.016/+0.004	6	35	44	82	355SUH0530	●
5.40	+0.016/+0.004	6	35	44	82	355SUH0540	●
5.50	+0.016/+0.004	6	35	44	82	355SUH0550	●
5.60	+0.016/+0.004	6	35	44	82	355SUH0560	●
5.70	+0.016/+0.004	6	35	44	82	355SUH0570	●
5.80	+0.016/+0.004	6	35	44	82	355SUH0580	●
5.90	+0.016/+0.004	6	35	44	82	355SUH0590	●
6.00	+0.016/+0.004	6	35	44	82	355SUH0600	●
6.10	+0.021/+0.006	8	43	53	91	355SUH0610	●
6.20	+0.021/+0.006	8	43	53	91	355SUH0620	●
6.30	+0.021/+0.006	8	43	53	91	355SUH0630	●
6.40	+0.021/+0.006	8	43	53	91	355SUH0640	●
6.50	+0.021/+0.006	8	43	53	91	355SUH0650	●
6.60	+0.021/+0.006	8	43	53	91	355SUH0660	●
6.70	+0.021/+0.006	8	43	53	91	355SUH0670	●
6.80	+0.021/+0.006	8	43	53	91	355SUH0680	●

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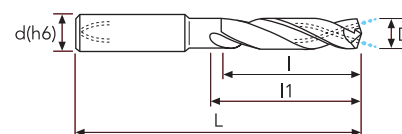
# 355SUH

stainless steel, polished flutes, SUH (through coolant)



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	355SUH0690	●
7.00	+0.021/+0.006	8	43	53	91	355SUH0700	●
7.10	+0.021/+0.006	8	43	53	91	355SUH0710	●
7.20	+0.021/+0.006	8	43	53	91	355SUH0720	●
7.30	+0.021/+0.006	8	43	53	91	355SUH0730	●
7.40	+0.021/+0.006	8	43	53	91	355SUH0740	●
7.50	+0.021/+0.006	8	43	53	91	355SUH0750	●
7.60	+0.021/+0.006	8	43	53	91	355SUH0760	●
7.70	+0.021/+0.006	8	43	53	91	355SUH0770	●
7.80	+0.021/+0.006	8	43	53	91	355SUH0780	●
7.90	+0.021/+0.006	8	43	53	91	355SUH0790	●
8.00	+0.021/+0.006	8	43	53	91	355SUH0800	●
8.10	+0.021/+0.006	10	49	61	103	355SUH0810	●
8.20	+0.021/+0.006	10	49	61	103	355SUH0820	●
8.30	+0.021/+0.006	10	49	61	103	355SUH0830	●
8.40	+0.021/+0.006	10	49	61	103	355SUH0840	●
8.50	+0.021/+0.006	10	49	61	103	355SUH0850	●
8.60	+0.021/+0.006	10	49	61	103	355SUH0860	●
8.70	+0.021/+0.006	10	49	61	103	355SUH0870	●
8.80	+0.021/+0.006	10	49	61	103	355SUH0880	●
8.90	+0.021/+0.006	10	49	61	103	355SUH0890	●
9.00	+0.021/+0.006	10	49	61	103	355SUH0900	●
9.10	+0.021/+0.006	10	49	61	103	355SUH0910	●
9.20	+0.021/+0.006	10	49	61	103	355SUH0920	●
9.30	+0.021/+0.006	10	49	61	103	355SUH0930	●
9.40	+0.021/+0.006	10	49	61	103	355SUH0940	●
9.50	+0.021/+0.006	10	61	61	103	355SUH0950	●
9.60	+0.021/+0.006	10	61	61	103	355SUH0960	●
9.70	+0.021/+0.006	10	61	61	103	355SUH0970	●
9.80	+0.021/+0.006	10	61	61	103	355SUH0980	●
9.90	+0.021/+0.006	10	61	61	103	355SUH0990	●
10.00	+0.021/+0.006	10	61	61	103	355SUH1000	●
10.20	+0.025/+0.007	12	71	71	118	355SUH1020	●
10.30	+0.025/+0.007	12	71	71	118	355SUH1030	●
10.50	+0.025/+0.007	12	71	71	118	355SUH1050	●
10.80	+0.025/+0.007	12	71	71	118	355SUH1080	●
11.00	+0.025/+0.007	12	71	71	118	355SUH1100	●
11.20	+0.025/+0.007	12	71	71	118	355SUH1120	●
11.30	+0.025/+0.007	12	71	71	118	355SUH1130	●

● stock standard ○ non-standard stock ▽ stock exhaustion

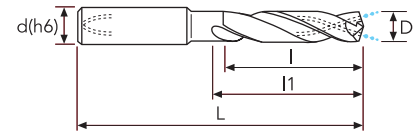
# 355SUH

stainless steel, polished flutes, SUH (through coolant)



P	M	K	N	S	H
☆	★	☆	☆	☆	

★ 1st choice ☆ suitable



D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
11.50	+0.025/+0.007	12	71	71	118	355SUH1150	●
11.80	+0.025/+0.007	12	71	71	118	355SUH1180	●
12.00	+0.025/+0.007	12	71	71	118	355SUH1200	●
12.20	+0.025/+0.007	14	77	77	124	355SUH1220	●
12.50	+0.025/+0.007	14	77	77	124	355SUH1250	●
12.80	+0.025/+0.007	14	77	77	124	355SUH1280	●
13.00	+0.025/+0.007	14	77	77	124	355SUH1300	●
13.30	+0.025/+0.007	14	77	77	124	355SUH1330	●
13.50	+0.025/+0.007	14	77	77	124	355SUH1350	●
13.80	+0.025/+0.007	14	77	77	124	355SUH1380	●
14.00	+0.025/+0.007	14	77	77	124	355SUH1400	●
14.50	+0.025/+0.007	16	83	83	133	355SUH1450	●
15.00	+0.025/+0.007	16	83	83	133	355SUH1500	●
15.30	+0.025/+0.007	16	83	83	133	355SUH1530	●
15.50	+0.025/+0.007	16	83	83	133	355SUH1550	●
15.80	+0.025/+0.007	16	83	83	133	355SUH1580	●
16.00	+0.025/+0.007	16	83	83	133	355SUH1600	●
16.50	+0.025/+0.007	18	93	93	143	355SUH1650	●
17.00	+0.025/+0.007	18	93	93	143	355SUH1700	●
17.50	+0.025/+0.007	18	93	93	143	355SUH1750	●
18.00	+0.025/+0.007	18	93	93	143	355SUH1800	●
18.50	+0.029/+0.008	20	101	101	153	355SUH1850	●
19.00	+0.029/+0.008	20	101	101	153	355SUH1900	●
19.50	+0.029/+0.008	20	101	101	153	355SUH1950	●
20.00	+0.029/+0.008	20	101	101	153	355SUH2000	●

- INFO
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- TYPHOON PU-HPU
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- TYPHOON HRC
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- MEF
- ALU
- MEX
- UH
- HSS/CO-HSSP END MILLS
- CARBIDE BURRS

● stock standard ○ non-standard stock ▽ stock exhaustion

### 355SUH

Material Group ISO 513	P1 P2			P3 P4			P5			P6					
	Hardness/Rm			500-700 N/mm <sup>2</sup>			600-1000 N/mm <sup>2</sup>			900-1200 N/mm <sup>2</sup>			1200-1400 N/mm <sup>2</sup>		
	Vc (m/min)			120-140			100-120			70-90			45-65		
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)			
3	13800	0.101	1390	11680	0.075	880	8490	0.060	510	5840	0.050	290			
4	10350	0.119	1230	8760	0.089	780	6370	0.071	450	4380	0.059	260			
5	8280	0.137	1130	7010	0.103	720	5100	0.082	420	3500	0.069	240			
6	6900	0.155	1070	5840	0.117	680	4250	0.093	400	2920	0.078	230			
7	5910	0.174	1030	5000	0.130	650	3640	0.104	380	2500	0.087	220			
8	5180	0.192	990	4380	0.144	630	3180	0.115	370	2190	0.096	210			
9	4600	0.210	970	3890	0.158	610	2830	0.126	360	1950	0.105	200			
10	4140	0.228	950	3500	0.171	600	2550	0.137	350	1750	0.114	200			
11	3760	0.238	890	3180	0.178	570	2320	0.143	330	1590	0.119	190			
12	3450	0.256	880	2920	0.192	560	2120	0.154	330	1460	0.128	190			
13	3180	0.274	870	2690	0.206	550	1960	0.164	320	1350	0.137	190			
14	2960	0.292	870	2500	0.219	550	1820	0.175	320	1250	0.146	180			
15	2760	0.311	860	2340	0.233	550	1700	0.186	320	1170	0.155	180			
16	2590	0.329	850	2190	0.247	540	1590	0.197	310	1090	0.164	180			
17	2440	0.338	820	2060	0.254	520	1500	0.203	300	1030	0.169	170			
18	2300	0.347	800	1950	0.260	510	1420	0.208	300	970	0.174	170			
19	2180	0.356	780	1840	0.267	490	1340	0.214	290	920	0.178	160			
20	2070	0.366	760	1750	0.274	480	1270	0.219	280	880	0.183	160			



Material Group ISO 513	M1			M3			M4			M5					
	Hardness/Rm			< 750 N/mm <sup>2</sup>			550-850 N/mm <sup>2</sup>			650-950 N/mm <sup>2</sup>			850-1200 N/mm <sup>2</sup>		
	Vc (m/min)			40-60			30-50			25-35			15-25		
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)			
3	5310	0.065	350	4250	0.052	220	3180	0.046	150	2120	0.039	80			
4	3980	0.077	310	3180	0.062	200	2390	0.054	130	1590	0.046	70			
5	3180	0.089	280	2550	0.071	180	1910	0.062	120	1270	0.053	70			
6	2650	0.101	270	2120	0.081	170	1590	0.071	110	1060	0.061	60			
7	2270	0.113	260	1820	0.090	160	1360	0.079	110	910	0.068	60			
8	1990	0.125	250	1590	0.100	160	1190	0.087	100	800	0.075	60			
9	1770	0.137	240	1420	0.109	160	1060	0.096	100	710	0.082	60			
10	1590	0.148	240	1270	0.119	150	960	0.104	100	640	0.089	60			
11	1450	0.154	220	1160	0.124	140	870	0.108	90	580	0.093	50			
12	1330	0.166	220	1060	0.133	140	800	0.116	90	530	0.100	50			
13	1220	0.178	220	980	0.143	140	730	0.125	90	490	0.107	50			
14	1140	0.190	220	910	0.152	140	680	0.133	90	450	0.114	50			
15	1060	0.202	210	850	0.162	140	640	0.141	90	420	0.121	50			
16	1000	0.214	210	800	0.171	140	600	0.150	90	400	0.128	50			
17	940	0.220	210	750	0.176	130	560	0.154	90	370	0.132	50			
18	880	0.226	200	710	0.181	130	530	0.158	80	350	0.135	50			
19	840	0.232	190	670	0.185	120	500	0.162	80	340	0.139	50			
20	800	0.238	190	640	0.190	120	480	0.166	80	320	0.143	50			



### 355SUH

	Material Group ISO 513	K1			K2			K3			K4		
	Hardness/Rm	150-250 HB			150-350 HB			120-260 HB			250-500 HB		
	Vc (m/min)	100-120			80-100			55-75			40-60		
	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)
3	11680	0.101	1170	9550	0.090	860	6900	0.080	550	5310	0.070	370	
4	8760	0.119	1040	7170	0.107	770	5180	0.095	490	3980	0.083	330	
5	7010	0.137	960	5730	0.123	710	4140	0.110	450	3180	0.096	310	
6	5840	0.155	910	4780	0.140	670	3450	0.124	430	2650	0.109	290	
7	5000	0.174	870	4090	0.156	640	2960	0.139	410	2270	0.122	280	
8	4380	0.192	840	3580	0.173	620	2590	0.154	400	1990	0.134	270	
9	3890	0.210	820	3180	0.189	600	2300	0.168	390	1770	0.147	260	
10	3500	0.228	800	2870	0.206	590	2070	0.183	380	1590	0.160	250	
11	3180	0.238	760	2610	0.214	560	1880	0.190	360	1450	0.166	240	
12	2920	0.256	750	2390	0.230	550	1730	0.205	350	1330	0.179	240	
13	2690	0.274	740	2200	0.247	540	1590	0.219	350	1220	0.192	230	
14	2500	0.292	730	2050	0.263	540	1480	0.234	350	1140	0.205	230	
15	2340	0.311	730	1910	0.280	530	1380	0.249	340	1060	0.217	230	
16	2190	0.329	720	1790	0.296	530	1290	0.263	340	1000	0.230	230	
17	2060	0.338	700	1690	0.304	510	1220	0.270	330	940	0.237	220	
18	1950	0.347	680	1590	0.313	500	1150	0.278	320	880	0.243	210	
19	1840	0.356	660	1510	0.321	480	1090	0.285	310	840	0.249	210	
20	1750	0.366	640	1430	0.329	470	1040	0.292	300	800	0.256	200	

	Material Group ISO 513	N2			N4								
	Hardness/Rm												
	Vc (m/min)	180-220			160-200								
	D (mm)	n (rpm)	fn (mm/rev)	Vf (mm/min)	n (rpm)	fn (mm/rev)	Vf (mm/min)						
3	21230	0.109	2300	19110	0.096	1840							
4	15920	0.128	2040	14330	0.114	1630							
5	12740	0.148	1890	11460	0.132	1510							
6	10620	0.168	1780	9550	0.149	1420							
7	9100	0.188	1710	8190	0.167	1370							
8	7960	0.207	1650	7170	0.184	1320							
9	7080	0.227	1610	6370	0.202	1290							
10	6370	0.247	1570	5730	0.219	1260							
11	5790	0.257	1490	5210	0.228	1190							
12	5310	0.276	1470	4780	0.246	1170							
13	4900	0.296	1450	4410	0.263	1160							
14	4550	0.316	1440	4090	0.281	1150							
15	4250	0.336	1430	3820	0.298	1140							
16	3980	0.355	1410	3580	0.316	1130							
17	3750	0.365	1370	3370	0.325	1090							
18	3540	0.375	1330	3180	0.333	1060							
19	3350	0.385	1290	3020	0.342	1030							
20	3180	0.395	1260	2870	0.351	1010							

- 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

### 355SUH

Material Group ISO 513	S1 S2			S3			S4			S5		
	< 35 HRC			35-45 HRC								
	25-45			15-35			40-60			30-50		
Vc (m/min)												
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)
3	3720	0.045	170	2650	0.032	80	5310	0.043	230	4250	0.036	150
4	2790	0.053	150	1990	0.037	70	3980	0.051	200	3180	0.043	140
5	2230	0.062	140	1590	0.043	70	3180	0.059	190	2550	0.049	130
6	1860	0.070	130	1330	0.049	70	2650	0.066	180	2120	0.056	120
7	1590	0.078	120	1140	0.055	60	2270	0.074	170	1820	0.063	110
8	1390	0.086	120	1000	0.060	60	1990	0.082	160	1590	0.069	110
9	1240	0.095	120	880	0.066	60	1770	0.090	160	1420	0.076	110
10	1110	0.103	110	800	0.072	60	1590	0.098	160	1270	0.082	100
11	1010	0.107	110	720	0.075	50	1450	0.102	150	1160	0.086	100
12	930	0.115	110	660	0.081	50	1330	0.109	150	1060	0.092	100
13	860	0.123	110	610	0.086	50	1220	0.117	140	980	0.099	100
14	800	0.132	110	570	0.092	50	1140	0.125	140	910	0.105	100
15	740	0.140	100	530	0.098	50	1060	0.133	140	850	0.112	100
16	700	0.148	100	500	0.104	50	1000	0.141	140	800	0.118	90
17	660	0.152	100	470	0.106	50	940	0.145	140	750	0.122	90
18	620	0.156	100	440	0.109	50	880	0.148	130	710	0.125	90
19	590	0.160	90	420	0.112	50	840	0.152	130	670	0.128	90
20	560	0.164	90	400	0.115	50	800	0.156	130	640	0.132	80



- INFO
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