

CUTTING PARAMETERS

**MEXLN2R**

Material Group ISO 513			P2 P3 P4 K1 K2			P4 P5 K3			P6 K4			H1 H4 H5		
Hardness/Rm			< 1000 N/mm <sup>2</sup>			< 35 HRC			35 - 45 HRC			45 - 55 HRC		
ap x ae			ap x D			ap x D			ap x D			ap x D		
Vc (m/min)			70-110			50-90			30-70			20-40		
D (mm)	l1 (mm)	ap (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)
0.3	≤ 6D	0.02	40000	0.004	320	40000	0.004	290	40000	0.003	255	31800	0.003	180
	≤ 8D	0.01	40000	0.004	290	40000	0.003	260	40000	0.003	230	28700	0.003	145
	≤ 10D	0.01	40000	0.003	260	40000	0.003	230	40000	0.003	205	25500	0.002	115
	≤ 12D	0.01	40000	0.003	220	40000	0.003	200	37200	0.002	165	22300	0.002	85
0.4	≤ 6D	0.02	40000	0.006	480	40000	0.005	430	39800	0.005	380	23900	0.004	200
	≤ 8D	0.02	40000	0.005	430	40000	0.005	390	35800	0.004	310	21500	0.004	165
	≤ 10D	0.01	40000	0.005	380	40000	0.004	350	31800	0.004	245	19100	0.003	130
	≤ 12D	0.01	40000	0.004	340	39000	0.004	290	27900	0.003	185	16700	0.003	100
0.5	≤ 6D	0.03	40000	0.007	560	40000	0.006	500	31800	0.006	355	19100	0.005	185
	≤ 8D	0.02	40000	0.006	500	40000	0.006	450	28700	0.005	290	17200	0.004	150
	≤ 10D	0.02	40000	0.006	450	35700	0.005	360	25500	0.004	230	15300	0.004	120
	≤ 12D	0.01	40000	0.005	390	31200	0.004	280	22300	0.004	175	13400	0.003	90
0.6	≤ 6D	0.03	40000	0.008	640	37200	0.007	540	26500	0.006	340	15900	0.006	180
	≤ 8D	0.03	40000	0.007	580	33400	0.006	430	23900	0.006	275	14300	0.005	145
	≤ 10D	0.02	38200	0.006	490	29700	0.006	340	21200	0.005	215	12700	0.004	115
	≤ 12D	0.02	33400	0.006	370	26000	0.005	260	18600	0.004	165	11100	0.004	85
0.8	≤ 6D	0.04	35800	0.010	720	27900	0.009	500	19900	0.008	320	11900	0.007	165
	≤ 8D	0.03	32200	0.009	580	25100	0.008	410	17900	0.007	260	10700	0.006	135
	≤ 10D	0.03	28700	0.008	460	22300	0.007	320	15900	0.006	205	9600	0.006	110
	≤ 12D	0.02	25100	0.007	350	19500	0.006	250	13900	0.006	155	8400	0.005	80
1	≤ 6D	0.05	28700	0.012	690	22300	0.011	480	15900	0.010	305	9600	0.008	160
	≤ 8D	0.04	25800	0.011	560	20100	0.010	390	14300	0.009	245	8600	0.008	130
	≤ 10D	0.04	22900	0.010	440	17800	0.009	310	12700	0.008	195	7600	0.007	100
	≤ 12D	0.03	20100	0.008	340	15600	0.008	240	11100	0.007	150	6700	0.006	80
1.2	≤ 6D	0.06	23900	0.022	1050	18600	0.020	740	13300	0.018	470	8000	0.015	245
	≤ 8D	0.05	21500	0.020	850	16700	0.018	600	11900	0.016	375	7200	0.014	200
	≤ 10D	0.04	19100	0.018	670	14900	0.016	470	10600	0.014	300	6400	0.012	160
	≤ 12D	0.03	16700	0.015	510	13000	0.014	360	9300	0.012	230	5600	0.011	120
1.4	≤ 6D	0.07	20500	0.024	980	15900	0.022	690	11400	0.019	440	6800	0.017	230
	≤ 8D	0.06	18400	0.022	790	14300	0.019	560	10200	0.017	355	6100	0.015	185
	≤ 10D	0.05	16400	0.019	630	12700	0.017	440	9100	0.015	280	5500	0.013	150
	≤ 12D	0.04	14300	0.017	480	11100	0.015	340	8000	0.013	215	4800	0.012	115
1.5	≤ 15D	0.03	12300	0.014	350	9600	0.013	250	6800	0.012	155	4100	0.010	85
	> 15D	0.02	10200	0.012	240	8000	0.011	170	5700	0.010	110	3400	0.008	55
	≤ 6D	0.08	19100	0.025	960	14900	0.023	670	10600	0.020	425	6400	0.018	225
	≤ 8D	0.06	17200	0.023	770	13400	0.020	540	9600	0.018	345	5700	0.016	180
1.6	≤ 10D	0.05	15300	0.020	610	11900	0.018	430	8500	0.016	270	5100	0.014	145
	≤ 12D	0.04	13400	0.018	470	10400	0.016	330	7400	0.014	205	4500	0.012	110
	≤ 15D	0.03	11500	0.015	350	8900	0.014	240	6400	0.012	155	3800	0.011	80
	> 15D	0.02	9600	0.013	240	7400	0.011	170	5300	0.010	105	3200	0.009	55
1.6	≤ 6D	0.08	17900	0.026	930	13900	0.023	650	10000	0.021	415	6000	0.018	220
	≤ 8D	0.07	16100	0.023	750	12500	0.021	530	9000	0.019	335	5400	0.016	175
	≤ 10D	0.06	14300	0.021	590	11100	0.019	420	8000	0.017	265	4800	0.015	140
	≤ 12D	0.04	12500	0.018	450	9800	0.016	320	7000	0.015	205	4200	0.013	105
> 15D	0.04	10700	0.016	330	8400	0.014	240	6000	0.012	150	3600	0.011	80	
> 15D	0.02	9000	0.013	230	7000	0.012	160	5000	0.010	105	3000	0.009	55	



- 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

### MEXLN2R

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ap x ae		ap x D			ap x D			ap x D			ap x D			
Vc (m/min)		70-110			50-90			30-70			20-40			
D (mm)	l1 (mm)	ap (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)
1.8	≤ 6D	<b>0.09</b>	15900	0.028	890	12400	0.025	620	8800	0.022	395	5300	0.020	210
	≤ 8D	<b>0.08</b>	14300	0.025	720	11100	0.023	500	8000	0.020	325	4800	0.018	170
	≤ 10D	<b>0.06</b>	12700	0.022	570	9900	0.020	400	7100	0.018	255	4200	0.016	130
	≤ 12D	<b>0.05</b>	11100	0.020	440	8700	0.018	310	6200	0.016	195	3700	0.014	100
	≤ 15D	<b>0.04</b>	9600	0.017	320	7400	0.015	220	5300	0.013	140	3200	0.012	75
> 15D	<b>0.03</b>	8000	0.014	220	6200	0.013	160	4400	0.011	100	2700	0.010	55	
2	≤ 6D	<b>0.10</b>	14300	0.030	860	11100	0.027	600	8000	0.024	385	4800	0.021	200
	≤ 8D	<b>0.09</b>	12900	0.027	700	10000	0.024	490	7200	0.022	310	4300	0.019	165
	≤ 10D	<b>0.07</b>	11500	0.024	550	8900	0.022	380	6400	0.019	245	3800	0.017	130
	≤ 12D	<b>0.06</b>	10000	0.021	420	7800	0.019	290	5600	0.017	190	3300	0.015	95
	≤ 15D	<b>0.05</b>	8600	0.018	310	6700	0.016	220	4800	0.014	140	2900	0.013	75
> 15D	<b>0.03</b>	8600	0.018	310	6700	0.016	220	4800	0.014	140	2900	0.013	75	
2.5	≤ 6D	<b>0.13</b>	11500	0.035	810	8900	0.032	560	6400	0.028	360	3800	0.025	185
	≤ 8D	<b>0.11</b>	10300	0.032	650	8000	0.028	450	5700	0.025	285	3400	0.022	150
	≤ 10D	<b>0.09</b>	9200	0.028	520	7100	0.025	360	5100	0.022	230	3100	0.020	120
	≤ 12D	<b>0.07</b>	8000	0.025	390	6200	0.022	270	4500	0.020	175	2700	0.017	95
	≤ 15D	<b>0.06</b>	6900	0.021	290	5400	0.019	200	3800	0.017	130	2300	0.015	70
> 15D	<b>0.04</b>	6900	0.021	290	5400	0.019	200	3800	0.017	130	2300	0.015	70	
3	≤ 6D	<b>0.15</b>	9600	0.040	770	7400	0.036	530	5300	0.032	340	3200	0.028	180
	≤ 8D	<b>0.13</b>	8600	0.036	620	6700	0.032	430	4800	0.029	275	2900	0.025	145
	≤ 10D	<b>0.11</b>	7600	0.032	490	5900	0.029	340	4200	0.026	215	2500	0.022	110
	≤ 12D	<b>0.08</b>	6700	0.028	380	5200	0.025	260	3700	0.022	165	2200	0.020	85
	≤ 15D	<b>0.07</b>	5700	0.024	270	4500	0.022	190	3200	0.019	125	1900	0.017	65
> 15D	<b>0.05</b>	5700	0.024	270	4500	0.022	190	3200	0.019	125	1900	0.017	65	
4	≤ 6D	<b>0.20</b>	7200	0.050	720	5600	0.045	500	4000	0.040	320	2400	0.035	170
	≤ 8D	<b>0.17</b>	6400	0.045	580	5000	0.041	410	3600	0.036	260	2100	0.032	130
	≤ 10D	<b>0.14</b>	5700	0.040	460	4500	0.036	320	3200	0.032	205	1900	0.028	105
	≤ 12D	<b>0.11</b>	5000	0.035	350	3900	0.032	250	2800	0.028	155	1700	0.025	85
	≤ 15D	<b>0.09</b>	4300	0.030	260	3300	0.027	180	2400	0.024	115	1400	0.021	60
> 15D	<b>0.06</b>	4300	0.030	260	3300	0.027	180	2400	0.024	115	1400	0.021	60	



- INFO
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- 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