TYPHOON DRILLS - CUTTING SPEED TABLE																
MATERIAL GROUPS	ISO	N/mm²	3XD						5XD					8XD	8XD MINI	12XD MINI
			343TA*	353TA	353HTA	353SUH	353ALH	353HRC	355TA	355HTA	355SUH**	355ALH	355HRC	3584HTA	358SUH	3512SUH
			Vc (m/min)													
1 2 3 4	P	~700	80~100	90~110	80~120	90~130			70~100	80~110	80~120			70~90	70~90	50~70
3 4 5	P	700~1000		75~95	85~105	75~115			75~95	75~105	75~105			65~105	65~105	45~65
6	P	1000~1300		70~90	80~100	70~110			70~90	70~100	70~100			60~80	60~80	40~60
7	P	40~45HRC		15~25	15~25	15~25			10~20	10~20	10~20			10~15	10~20	10~15
8	H	45~50HRC						15~25					10~20			
8	H	50~55HRC						10~16					8~13			
8	H	55~62HRC						8~14					7~12			
9 10	M			25~50		30~60			20~40		25~55			20~40	20~40	15~35
11	M			20~45		25~55			15~35		20~50			20~40	20~40	15~35
12	M			20~45		25~55			15~35		20~50			20~40	20~40	15~35
13	K			70~110	80~120	90~130			60~100	70~110	80~120			40~90	40~90	30~70
14	K			60~100	70~110	80~120			50~90	60~100	70~110			30~80	30~80	20~60
15	N		200~270				220~290		180~250			200~250		150~220	150~220	120~180
16	N		180~250				200~270		160~230			180~230		130~200	130~200	100~160
22	S	<35HRC		20~40	25~45	30~50			20~35	20~40	25~45			15~30	15~30	10~25
23	S	>35HRC		10~30	15~35	20~40			10~25	10~30	15~35			10~25	10~25	10~20
26	S			20~40	25~45	30~50			20~35	20~40	25~45			15~30	15~30	15~25

*318N: Vc -30%
**355SU: Vc -10%

TYPHOON DRILLS - FEED TABLE MINI 355SUH* - 358SUH - 3512SUH							
MATERIAL GROUPS	ISO	N/mm²	Ø	1~1.5	1.6~2	2.1~2.5	2.6~2.9
				fn (mm/rev)			
1 2 3 4	P	~700	355SUH*	0.062~0.070	0.072~0.079	0.080~0.088	0.090~0.094
			358SUH	0.036~0.043	0.045~0.050	0.052~0.058	0.059~0.064
			3512SUH	0.027~0.032	0.034~0.038	0.039~0.044	0.044~0.048
3 4 5	P	700~1000	355SUH*	0.048~0.058	0.060~0.067	0.069~0.077	0.079~0.084
			358SUH	0.036~0.043	0.045~0.050	0.052~0.058	0.059~0.064
			3512SUH	0.027~0.032	0.034~0.038	0.039~0.044	0.044~0.048
6	P	1000~1300	355SUH*	0.037~0.044	0.045~0.051	0.052~0.058	0.059~0.064
			358SUH	0.030~0.035	0.036~0.039	0.040~0.044	0.045~0.047
			3512SUH	0.023~0.026	0.027~0.029	0.030~0.033	0.034~0.035
7	P	40~45HRC	355SUH*	0.013~0.015	0.015~0.017	0.017~0.019	0.019~0.020
			358SUH	0.012~0.014	0.014~0.016	0.016~0.017	0.017~0.019
			3512SUH	0.009~0.011	0.011~0.012	0.012~0.013	0.013~0.014
9 10	M		355SUH*	0.043~0.048	0.050~0.054	0.055~0.061	0.062~0.065
			358SUH	0.038~0.043	0.045~0.049	0.050~0.054	0.055~0.058
			3512SUH	0.029~0.032	0.034~0.037	0.037~0.041	0.041~0.044
11	M		355SUH*	0.043~0.048	0.050~0.054	0.055~0.061	0.062~0.065
			358SUH	0.038~0.043	0.045~0.049	0.050~0.054	0.055~0.058
			3512SUH	0.029~0.032	0.034~0.037	0.037~0.041	0.041~0.044
12	M		355SUH*	0.029~0.035	0.036~0.039	0.041~0.045	0.046~0.049
			358SUH	0.026~0.031	0.032~0.035	0.037~0.040	0.041~0.044
			3512SUH	0.020~0.023	0.024~0.026	0.028~0.030	0.031~0.033
13	K		355SUH*	0.048~0.059	0.062~0.070	0.071~0.080	0.082~0.088
			358SUH	0.030~0.038	0.039~0.046	0.047~0.054	0.054~0.059
			3512SUH	0.023~0.028	0.029~0.034	0.035~0.040	0.041~0.044
14	K		355SUH*	0.046~0.056	0.058~0.066	0.068~0.076	0.078~0.084
			358SUH	0.029~0.036	0.038~0.043	0.045~0.050	0.052~0.056
			3512SUH	0.022~0.027	0.028~0.032	0.034~0.038	0.039~0.042
15	N		355SUH*	0.074~0.087	0.089~0.099	0.101~0.111	0.113~0.121
			358SUH	0.062~0.073	0.074~0.082	0.085~0.093	0.095~0.102
			3512SUH	0.047~0.055	0.056~0.062	0.064~0.070	0.071~0.076
16	N		355SUH*	0.071~0.084	0.087~0.098	0.100~0.111	0.115~0.122
			358SUH	0.057~0.069	0.071~0.081	0.083~0.094	0.096~0.103
			3512SUH	0.043~0.052	0.053~0.061	0.062~0.070	0.072~0.077
22	S	<35HRC	355SUH*	0.025~0.029	0.029~0.033	0.034~0.037	0.038~0.040
			358SUH	0.017~0.021	0.021~0.024	0.025~0.027	0.028~0.030
			3512SUH	0.013~0.016	0.016~0.018	0.019~0.020	0.021~0.022
23	S	>35HRC	355SUH*	0.019~0.023	0.024~0.028	0.029~0.032	0.032~0.035
			358SUH	0.014~0.017	0.018~0.020	0.021~0.023	0.024~0.026
			3512SUH	0.010~0.013	0.013~0.015	0.016~0.017	0.018~0.020
26	S		355SUH*	0.031~0.036	0.037~0.041	0.042~0.046	0.047~0.050
			358SUH	0.026~0.030	0.031~0.034	0.035~0.039	0.040~0.042
			3512SUH	0.020~0.023	0.023~0.026	0.026~0.029	0.030~0.032

*355SU: fn -10% ~ -20%