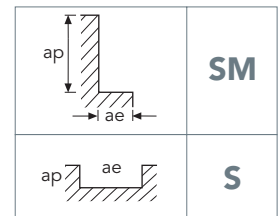


UHCS2													
MATERIAL GROUPS	6 7		7 8		8		8		8		8		
HRC	30~40		40~50		50~55		55~60		60~65		65~70		
N/mm <sup>2</sup>	1000~1250		1250~										
Vc [m/min]	40~250		40~200		30~130		20~100		20~75		18~70		
Ø mm.	n	Vf	n	Vf	n	Vf	n	Vf	n	Vf	n	Vf	
0.2	50000	130	50000	120	42000	90	35000	60	35000	45	28000	30	
0.3	50000	190	50000	140	42000	110	35000	70	27000	50	22000	35	
0.4	50000	240	50000	180	42000	140	35000	90	27000	55	22000	40	
0.5	50000	370	50000	280	42000	220	35000	140	27000	96	22000	60	
0.6	50000	470	50000	360	42000	280	32000	160	27000	110	22000	75	
0.8	50000	600	45000	440	32000	290	27000	180	21000	110	17000	80	
0.9	50000	660	42000	520	30000	330	24000	200	19000	125	15000	85	
1	50000	750	40000	570	27000	360	22000	210	18000	135	13500	85	
2	35000	850	28000	680	19000	420	16000	260	12000	160	10400	110	
3	23000	850	19000	680	13000	420	10600	260	8000	160	7000	110	
4	18000	880	14500	700	9500	440	8000	270	6000	170	5000	120	
5	15900	1000	12800	810	8300	500	6400	280	4800	180	4500	130	
6	13300	950	10600	770	6900	480	5300	280	4000	180	3700	130	
8	10000	930	8000	720	5200	450	4000	250	3000	165	2800	120	
10	8000	850	6400	680	4200	420	3200	240	2400	155	2200	110	
12	6700	850	5300	680	3500	420	2700	240	2000	155	1900	110	
<b>S ap x ae</b>	0.05DxD		0.05DxD		0.05DxD		0.05DxD		0.05DxD		0.02DxD		

↓ Z axis : Vf = -50%

UHCS2													
MATERIAL GROUPS	6 7		7 8		8		8		8		8		
HRC	30~40		40~50		50~55		55~60		60~65		65~70		
N/mm <sup>2</sup>	1000~1250		1250~										
Vc [m/min]	160~250		125~200		85~130		70~100		55~75		45~70		
Ø mm.	n	fn	n	fn	n	fn	n	fn	n	fn	n	fn	
1	50000	1050	40000	820	27000	510	22000	310	18000	190	13500	120	
2	35000	1200	28000	970	19000	600	16000	370	12000	230	10400	170	
3	23000	1200	19000	970	13000	600	10600	370	8000	230	7000	170	
4	18000	1250	14500	1000	9500	625	8000	390	6000	240	5000	170	
5	15900	1450	12800	1150	8300	710	6400	410	4800	260	4500	190	
6	13300	1350	10600	1100	6900	690	5300	400	4000	260	3700	180	
8	10000	1320	8000	1030	5200	640	4000	370	3000	240	2800	170	
10	8000	1200	6400	970	4200	590	3200	340	2400	220	2200	160	
12	6700	1200	5300	970	3500	590	2700	340	2000	220	1900	160	
<b>SM ap x ae</b>	Dx0.03D		Dx0.03D		Dx0.03D		Dx0.03D		Dx0.03D		Dx0.03D		



- TYPHOON
- C-SD-TA
- LFTA
- SUTA
- HSS-HSS/CO DRILLS
- UH RED
- MEX ORANGE
- HF EVO
- MEF ENDLESS
- ALU
- MDC
- G2
- MDTA
- ULTRA MILLS
- HSS/CO
- CARBIDE BURRS
- PARAMETERS