

MEXMB2					
MATERIAL GROUPS	6 7		7 8		
HRC	30~45		45~55		
N/mm <sup>2</sup>	1000~1480		1480~		
Vc [m/min]	70~80		70~80		
Ø mm.	n	Vf	n	Vf	
0.2	40000	240	40000	160	
0.3	40000	240	40000	160	
0.4	40000	320	40000	160	
0.5	39100	433	39100	315	
0.6	35920	448	35920	336	
0.7	30000	430	30000	316	
0.8	25150	406	25150	295	
0.9	23750	400	23750	288	
1	22300	395	22300	280	
1.5	14850	327	14850	234	
2	11150	315	11150	211	
<b>C ap x p</b>	0.1Dx0.05D		0.05Dx0.05D		

MEXCSB2 - MEXCLSB2 - MEX253**						
MATERIAL GROUPS	3 4 5		6		7	
HRC	~30		30~40		40~65	
N/mm <sup>2</sup>	~1000		1000~1250		1250~	
Vc [m/min]	50~250		40~200 (HSC 80~500)		20~70 (HSC 80~200)	
Ø mm.	n	Vf	n	Vf	n	Vf
1	15800	250	12750	200	5800	90
1 HSC			<b>30000</b>	<b>1300</b>	<b>25000</b>	<b>800</b>
1.5	15800	350	12150	270	5350	120
1.5 HSC			<b>23000</b>	<b>1400</b>	<b>23000</b>	<b>850</b>
2	14400	750	10700	490	4850	110
2 HSC			<b>21000</b>	<b>1500</b>	<b>21000</b>	<b>950</b>
2.5	14400	750	10700	490	4700	150
2.5 HSC			<b>21000</b>	<b>1800</b>	<b>19000</b>	<b>980</b>
3	13100	680	10000	460	4550	150
3 HSC			<b>21000</b>	<b>2000</b>	<b>17000</b>	<b>1050</b>
4	10500	740	8400	530	4200	180
4 HSC			<b>21000</b>	<b>2950</b>	<b>13700</b>	<b>1150</b>
5	9150	820	7300	580	3700	180
5 HSC			<b>21000</b>	<b>3600</b>	<b>12000</b>	<b>1200</b>
6	8500	1050	6900	830	3200	190
6 HSC			<b>21000</b>	<b>4000</b>	<b>10500</b>	<b>1250</b>
8	7200	1300	5800	1050	2500	220
8 HSC			<b>16700</b>	<b>4000</b>	<b>7900</b>	<b>1250</b>
10	6400	1550	5100	1050	2050	230
10 HSC			<b>14000</b>	<b>3900</b>	<b>6300</b>	<b>1200</b>
12	5900	1750	4650	1100	1750	250
12 HSC			<b>12200</b>	<b>3900</b>	<b>5300</b>	<b>1150</b>
16	4800	1700	3800	1050	1350	250
16 HSC			<b>9600</b>	<b>3500</b>	<b>3800</b>	<b>1000</b>
20	4150	1650	3300	1050	1100	250
20 HSC			<b>8000</b>	<b>3200</b>	<b>2950</b>	<b>950</b>
<b>C ap x p</b>	0.2Dx0.3mm*		0.2Dx0.3mm*		0.2Dx0.3mm*	
<b>C ap x p</b>			0.05Dx0.3mm*		0.05x0.03mm*	

HSC

HSC = high speed cutting / alta velocidad / hoch Geschwindigkeit / grande vitesse / alta velocidad / высокая скорость

\*~Ø6 ap=0.2mm

\*\*MEX253: n & Vf = -20%

- 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

