

CUTTING PARAMETERS

INFO

MEFCS2

	Material Group ISO 513	P1 P2 P3	P4 P7 M1	P5 M2 M3 S1 S2 S4	P8 S3 S5
	Hardness/Rm	≤700 N/mm ²	700÷1000 N/mm ²	≤35 HRC	≤45 HRC
	ap x ae	0.5D x D	0.5D x D	0.3D x D	0.2D x D
	Vc (m/min)	90÷110	50÷70	30÷50	20÷40
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	1	0.005	0.004	0.004	0.004
	2	0.009	0.008	0.007	0.007
	3	0.012	0.010	0.009	0.009
	4	0.017	0.015	0.014	0.014
	5	0.023	0.020	0.018	0.018
	6	0.029	0.024	0.023	0.023
	8	0.035	0.029	0.028	0.028
	10	0.040	0.034	0.032	0.032
	12	0.046	0.039	0.037	0.037
14	0.052	0.044	0.041	0.041	
16	0.058	0.049	0.046	0.046	

< D3 mm: ap = 0.1D ÷ 0.2D

	Material Group ISO 513	P1 P2 P3	P4 P7 M1	P5 M2 M3 S1 S2 S4	P8 S3 S5
	Hardness/Rm	≤700 N/mm ²	700÷1000 N/mm ²	≤35 HRC	≤45 HRC
	ap x ae	1.5D x 0.5D	1.5D x 0.5D	D x 0.3D	D x 0.1D
	Vc (m/min)	90÷110	60÷80	40÷60	30÷50
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	1	0.006	0.005	0.004	0.004
	2	0.011	0.009	0.009	0.009
	3	0.014	0.012	0.011	0.011
	4	0.021	0.018	0.017	0.017
	5	0.028	0.023	0.022	0.022
	6	0.035	0.029	0.028	0.028
	8	0.041	0.035	0.033	0.033
	10	0.048	0.041	0.039	0.039
	12	0.055	0.047	0.044	0.044
14	0.062	0.053	0.050	0.050	
16	0.069	0.059	0.055	0.055	

< D3 mm: ap = 0.1D ÷ 0.2D

	Material Group ISO 513	P1 P2 P3	P4 P7 M1	P5 M2 M3 S1 S2 S4	P8 S3 S5
	Hardness/Rm	≤700 N/mm ²	700÷1000 N/mm ²	≤35 HRC	≤45 HRC
	ap x ae	D x D	D x D	0.5D x D	0.2D x D
	Vc (m/min)	90÷110	50÷70	30÷50	20÷40
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	1	0.003	0.002	0.002	0.002
	2	0.006	0.005	0.004	0.004
	3	0.007	0.006	0.006	0.006
	4	0.010	0.009	0.008	0.008
	5	0.014	0.012	0.011	0.011
	6	0.017	0.015	0.014	0.014
	8	0.021	0.018	0.017	0.017
	10	0.024	0.021	0.019	0.019
	12	0.028	0.023	0.022	0.022
14	0.031	0.026	0.025	0.025	
16	0.035	0.029	0.028	0.028	

< D3 mm: ap = 0.1D ÷ 0.2D

CARBIDE DRILLS

PU-HPU
TA-4HTA
SUH
ALH
HRC
SUH MINI
HL
HSD
C-SD-TA

HSS DRILLS

LFTA
SUTA
HSS-HSS/CO

CARBIDE END-MILLS

G2
MDTA
HF-VH/UP
MEF
ALU
MEX/MH
UH/MH


HSS END-MILLS

CARBIDE BURRS

CUTTING PARAMETERS


INFO

MEFCSH3

 SLOTTING	Material Group ISO 513	P1 P2 P3	P4 P7 M1	P5 M2 M3 S1 S2 S4	P8 S3 S5
	Hardness/Rm	≤700 N/mm ²	700÷1000 N/mm ²	≤35 HRC	≤45 HRC
	ap x ae	0.5D x D	0.5D x D	0.3D x D	0.2D x D
	Vc (m/min)	80÷100	60÷80	40÷60	30÷50
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.022	0.013	0.012	0.012
	8	0.029	0.017	0.015	0.016
	10	0.036	0.021	0.019	0.020
	12	0.046	0.027	0.024	0.026
	14	0.053	0.031	0.028	0.030
16	0.065	0.038	0.034	0.036	
18	0.075	0.044	0.039	0.042	
20	0.086	0.051	0.045	0.048	

CARBIDE DRILLS

 PU-HPU
 TA-4HTA
 SUH
 ALH
 HRC
 SUH MINI
 HL
 HSD
 C-SD-TA

 SIDE MILLING	Material Group ISO 513	P1 P2 P3	P4 P7 M1	P5 M2 M3 S1 S2 S4	P8 S3 S5
	Hardness/Rm	≤700 N/mm ²	700÷1000 N/mm ²	≤35 HRC	≤45 HRC
	ap x ae	0.5D x D	0.5D x D	0.3D x D	0.2D x D
	Vc (m/min)	80÷100	60÷80	40÷60	30÷50
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.026	0.015	0.014	0.014
	8	0.035	0.020	0.019	0.019
	10	0.043	0.026	0.024	0.024
	12	0.055	0.033	0.031	0.031
	14	0.064	0.038	0.036	0.036
16	0.078	0.046	0.043	0.043	
18	0.090	0.053	0.050	0.050	
20	0.104	0.061	0.058	0.058	

HSS DRILLS

 LFTA
 SUTA
 HSS-HSS/CO

CARBIDE END-MILLS


 G2
 MDTA
 HF-VH/UP
MEF
 ALU
 MEX/MH
 UH/MH

HSS END-MILLS

CARBIDE BURRS

CUTTING PARAMETERS

MEFCS4

	Material Group ISO 513	P1 P2 P3	P4 P7 M1	P5 M2 M3 S1 S2 S4	P8 S3 S5
	Hardness/Rm	≤700 N/mm ²	700÷1000 N/mm ²	≤35 HRC	≤45 HRC
	ap x ae	1.5D x 0.1D	1.5D x 0.1D	1.5D x 0.1D	1.5D x 0.1D
	Vc (m/min)	90±110	60±80	40±60	30±50
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	3	0.012	0.010	0.010	0.010
	4	0.015	0.013	0.012	0.012
	5	0.018	0.015	0.014	0.014
	6	0.023	0.020	0.018	0.018
	8	0.030	0.026	0.024	0.024
10	0.038	0.032	0.030	0.030	
12	0.045	0.038	0.036	0.036	
14	0.052	0.044	0.042	0.042	
16	0.058	0.049	0.046	0.046	
18	0.066	0.056	0.053	0.053	
20	0.075	0.064	0.060	0.060	


INFO

CARBIDE
DRILLS
 PU-HPU
 TA-4HTA
 SUH
 ALH
 HRC
 SUH MINI
 HL
 HSD
 C-SD-TA
HSS
DRILLS
 LFTA
 SUTA
 HSS-HSS/CO
CARBIDE
END-MILLS
 G2
 MDTA
 HF-VH/UP
MEF
 ALU
 MEX/MH
 UH/MH
HSS
END-MILLSCARBIDE
BURRS

CUTTING PARAMETERS

INFO


MEF600

	Material Group ISO 513	P1 P2 P3	P4 P7 M1	P5 M2 M3 S1 S2 S4	P8 S3 S5
	Hardness/Rm	≤700 N/mm ²	700÷1000 N/mm ²	≤35 HRC	≤45 HRC
	ap x ae	1.5D x 0.1D	1.5D x 0.1D	D x 0.1D	D x 0.05D
	Vc (m/min)	100÷140	70÷110	50÷80	40÷60
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.015	0.013	0.012	0.012
	8	0.020	0.017	0.016	0.016
	10	0.025	0.021	0.020	0.020
	12	0.030	0.026	0.024	0.024
	14	0.035	0.030	0.028	0.028
16	0.040	0.034	0.032	0.032	
20	0.050	0.043	0.040	0.040	

CARBIDE
DRILLS
 PU-HPU
 TA-4HTA
 SUH
 ALH
 HRC
 SUH MINI
 HL
 HSD
 C-SD-TA
HSS
DRILLS
 LFTA
 SUTA
 HSS-HSS/CO
CARBIDE
END-MILLS
 G2
 MDTA
 HF-VH/UP
MEF
 ALU
 MEX/MH
 UH/MH
HSS
END-MILLSCARBIDE
BURRS

CUTTING PARAMETERS

MEF901

	Material Group ISO 513	P1 P2 P3	P4 P7 M1	P5 M2 M3 S1 S2 S4	P8 S3 S5
	Hardness/Rm	≤700 N/mm ²	700÷1000 N/mm ²	≤35 HRC	≤45 HRC
	ap x ae	1.5D x 0.3D	1.5D x 0.3D	1.5D x 0.2D	D x 0.1D
	Vc (m/min)	100÷140	70÷90	50÷70	40÷60
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	4	0.018	0.015	0.014	0.014
	5	0.022	0.019	0.018	0.018
	6	0.028	0.024	0.022	0.022
	8	0.035	0.030	0.028	0.028
	10	0.040	0.034	0.032	0.032
12	0.045	0.038	0.036	0.036	
14	0.050	0.043	0.040	0.040	
16	0.057	0.048	0.046	0.046	
20	0.073	0.062	0.058	0.058	


INFO

CARBIDE
DRILLS
 PU-HPU
 TA-4HTA
 SUH
 ALH
 HRC
 SUH MINI
 HL
 HSD
 C-SD-TA
HSS
DRILLS
 LFTA
 SUTA
 HSS-HSS/CO
CARBIDE
END-MILLS
 G2
 MDTA
 HF-VH/UP
MEF
 ALU
 MEX/MH
 UH/MH
HSS
END-MILLSCARBIDE
BURRS

CUTTING PARAMETERS

INFO

MEF902

	Material Group ISO 513	P1 P2 P3	P4 P7 M1	P5 M2 M3 S1 S2 S4	P8 S3 S5
	Hardness/Rm	≤700 N/mm ²	700÷1000 N/mm ²	≤35 HRC	≤45 HRC
	ap x ae	1.5D x 0.3D	1.5D x 0.3D	1.5D x 0.2D	D x 0.1D
	Vc (m/min)	100÷120	60÷80	45÷65	35÷45
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.027	0.023	0.021	0.021
	8	0.033	0.028	0.027	0.027
	10	0.038	0.032	0.030	0.030
	12	0.043	0.036	0.034	0.034
	14	0.048	0.040	0.038	0.038
16	0.054	0.046	0.043	0.043	
20	0.069	0.059	0.055	0.055	

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DRILLS
 PU-HPU
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 HRC
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 HL
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HSS
DRILLS
 LFTA
 SUTA
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CARBIDE
END-MILLS
 G2
 MDTA
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MEF
 ALU
 MEX/MH
 UH/MH
HSS
END-MILLSCARBIDE
BURRS