




## MEF600

	Material Group ISO 513	P1 P2 P3			P4 M1 M2			P5 M3 M4 S1 S2 S4			M5 S3 S5		
	Hardness/Rm	< 700 N/mm <sup>2</sup>			700-1000 N/mm <sup>2</sup>			< 35 HRC			< 45 HRC		
	ap x ae	<b>1.5D x 0.1D</b>			<b>1.5D x 0.1D</b>			<b>1.5D x 0.1D</b>			<b>1.5D x 0.05D</b>		
	Vc (m/min)	<b>100-140</b>			<b>70-110</b>			<b>50-90</b>			<b>50-70</b>		
D (mm)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	n (rpm)	fz (mm/z)	Vf (mm/min)	
<b>6</b>	6370	0.015	570	4780	0.013	370	3720	0.012	270	3180	0.012	230	
<b>8</b>	4780	0.020	570	3580	0.017	370	2790	0.016	270	2390	0.016	230	
<b>10</b>	3820	0.025	570	2870	0.021	370	2230	0.020	270	1910	0.020	230	
<b>12</b>	3180	0.030	570	2390	0.026	370	1860	0.024	270	1590	0.024	230	
<b>14</b>	2730	0.035	570	2050	0.030	370	1590	0.028	270	1360	0.028	230	
<b>16</b>	2390	0.040	570	1790	0.034	370	1390	0.032	270	1190	0.032	230	
<b>20</b>	1910	0.050	760	1430	0.043	490	1110	0.040	360	960	0.040	310	

INFO

TYPHOON  
TA-HTA-4HTATYPHOON  
PU-HPUTYPHOON  
SUHTYPHOON  
ALHTYPHOON  
HRCTYPHOON  
SUH MINITYPHOON  
HL

C-SD-TA

LFTA

SUTA

HSS-HSS/CO  
DRILLS

G2

MDTA

HF VH/UP

MEF

ALU

MEX

UH

HSS/CO-HSSP  
END MILLSCARBIDE  
BURRS