

TYPHOON DRILLS - CUTTING SPEED TABLE																
MATERIAL GROUPS	ISO	N/mm ²	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		700~1000		75~95	85~105	75~115		75~95	75~105	75~105			65~105	65~105	45~65	
6		1000~1300		70~90	80~100	70~110		70~90	70~100	70~100			60~80	60~80	40~60	
7	H	40~45HRC		15~25	15~25	15~25		10~20	10~20	10~20			10~15	10~20	10~15	
8		45~50HRC					15~25					10~20				
8		50~55HRC					10~16					8~13				
8		55~62HRC					8~14					7~12				
9 10	M			25~50		30~60		20~40		25~55			20~40	20~40	15~35	
11				20~45		25~55		15~35		20~50			20~40	20~40	15~35	
12				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				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		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		>35HRC		10~30	15~35	20~40		10~25	10~30	15~35			10~25	10~25	10~20	
26				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/mm ²	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	>35HRC	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%

3XD			TYPHOON DRILLS - FEED TABLE 343TA - 353TA - 353HTA - 353SUH - 353ALH - 353HRC								
MATERIAL GROUPS	ISO	N/mm ²	Ø	3-4	4-6	6-8	8-10	10-12	12-14	14-17	17-20
				fn (mm/rev)							
1 2 3 4	P	~700	343TA	0.082~0.101	0.101~0.138	0.138~0.176	0.176~0.213	0.213~0.250	0.250~0.288	0.288~0.344	0.344~0.400
			353TA	0.086~0.106	0.106~0.145	0.145~0.185	0.185~0.224	0.224~0.263	0.263~0.302	0.302~0.361	0.361~0.420
			353HTA	0.108~0.128	0.128~0.167	0.167~0.206	0.206~0.246	0.246~0.285	0.285~0.323	0.323~0.382	0.382~0.441
			353SUH	0.113~0.134	0.134~0.175	0.175~0.216	0.216~0.257	0.257~0.298	0.298~0.339	0.339~0.400	0.400~0.462
3 4 5	P	700~1000	353TA	0.082~0.101	0.101~0.138	0.145~0.185	0.185~0.224	0.224~0.263	0.263~0.302	0.302~0.361	0.361~0.420
			353HTA	0.096~0.117	0.117~0.159	0.167~0.206	0.206~0.246	0.246~0.285	0.285~0.323	0.323~0.382	0.382~0.441
6	P	1000~1300	353SUH	0.101~0.123	0.123~0.167	0.175~0.216	0.216~0.257	0.257~0.298	0.298~0.339	0.339~0.400	0.400~0.462
			353TA	0.069~0.083	0.083~0.110	0.110~0.137	0.137~0.164	0.164~0.191	0.191~0.219	0.219~0.259	0.259~0.300
7	P	40~45HRC	353HTA	0.073~0.087	0.087~0.116	0.116~0.144	0.144~0.173	0.173~0.201	0.201~0.230	0.230~0.272	0.272~0.315
			353SUH	0.077~0.091	0.091~0.122	0.122~0.151	0.151~0.182	0.182~0.211	0.211~0.242	0.242~0.286	0.286~0.331
			353TA	0.024~0.029	0.029~0.038	0.038~0.047	0.047~0.055	0.055~0.064	0.064~0.073	0.073~0.087	0.087~0.100
8	H	45~50HRC	353HTA	0.026~0.032	0.032~0.042	0.042~0.052	0.052~0.061	0.061~0.070	0.070~0.080	0.080~0.096	0.096~0.110
		50~55HRC	353SUH	0.024~0.029	0.029~0.038	0.038~0.047	0.047~0.055	0.055~0.064	0.064~0.073	0.073~0.087	0.087~0.100
		55~62HRC	353HRC	0.024~0.050	0.030~0.080	0.050~0.100	0.060~0.120	0.080~0.140	0.100~0.150	0.120~0.160	0.140~0.180
9 10	M		353HRC	0.022~0.025	0.025~0.032	0.032~0.039	0.039~0.046	0.046~0.053	0.053~0.059	0.059~0.070	0.070~0.080
			353HRC	0.018~0.021	0.021~0.027	0.027~0.033	0.033~0.039	0.039~0.045	0.045~0.052	0.052~0.061	0.061~0.070
11	M		353TA	0.074~0.088	0.088~0.114	0.114~0.141	0.141~0.167	0.167~0.194	0.194~0.220	0.220~0.260	0.260~0.300
			353SUH	0.078~0.092	0.092~0.120	0.120~0.148	0.148~0.175	0.175~0.204	0.204~0.231	0.231~0.273	0.273~0.315
12	M		353TA	0.074~0.088	0.088~0.114	0.114~0.141	0.141~0.167	0.167~0.194	0.194~0.220	0.220~0.260	0.260~0.300
			353SUH	0.078~0.092	0.092~0.120	0.120~0.148	0.148~0.175	0.175~0.204	0.204~0.231	0.231~0.273	0.273~0.315
13	K		353TA	0.056~0.067	0.067~0.090	0.090~0.113	0.113~0.136	0.136~0.159	0.159~0.181	0.181~0.216	0.216~0.250
			353SUH	0.059~0.070	0.070~0.095	0.095~0.119	0.119~0.143	0.143~0.167	0.167~0.190	0.190~0.227	0.227~0.263
14	K		353TA	0.076~0.095	0.095~0.133	0.133~0.171	0.171~0.209	0.209~0.248	0.248~0.286	0.286~0.343	0.343~0.400
			353HTA	0.101~0.125	0.125~0.172	0.172~0.219	0.219~0.266	0.266~0.312	0.312~0.359	0.359~0.430	0.430~0.500
15	N		353SUH	0.106~0.131	0.131~0.181	0.181~0.230	0.230~0.279	0.279~0.328	0.328~0.377	0.377~0.452	0.452~0.525
			353TA	0.072~0.090	0.090~0.127	0.127~0.163	0.163~0.199	0.199~0.235	0.235~0.271	0.271~0.326	0.326~0.380
16	N		353HTA	0.096~0.119	0.119~0.163	0.163~0.208	0.208~0.252	0.252~0.297	0.297~0.341	0.341~0.408	0.408~0.475
			353SUH	0.101~0.125	0.125~0.171	0.171~0.218	0.218~0.265	0.265~0.312	0.312~0.358	0.358~0.428	0.428~0.499
22	S	<35HRC	343TA	0.129~0.155	0.155~0.207	0.207~0.259	0.259~0.311	0.311~0.363	0.363~0.414	0.414~0.492	0.492~0.570
			353ALH	0.152~0.182	0.182~0.242	0.242~0.301	0.301~0.361	0.361~0.422	0.422~0.482	0.482~0.571	0.571~0.662
23	S	>35HRC	343TA	0.132~0.162	0.162~0.223	0.223~0.284	0.284~0.345	0.345~0.406	0.406~0.467	0.467~0.559	0.559~0.650
			353ALH	0.155~0.189	0.189~0.257	0.257~0.326	0.326~0.394	0.394~0.462	0.462~0.530	0.530~0.633	0.633~0.735
26	S	>35HRC	353TA	0.038~0.046	0.046~0.063	0.063~0.080	0.080~0.097	0.097~0.113	0.113~0.130	0.130~0.155	0.155~0.180
			353HTA	0.046~0.055	0.055~0.073	0.073~0.091	0.091~0.110	0.110~0.128	0.128~0.146	0.146~0.173	0.173~0.200
			353SUH	0.048~0.058	0.058~0.077	0.077~0.096	0.096~0.116	0.116~0.134	0.134~0.153	0.153~0.182	0.182~0.210
26	S	>35HRC	353TA	0.034~0.042	0.042~0.060	0.060~0.077	0.077~0.094	0.094~0.111	0.111~0.128	0.128~0.154	0.154~0.180
			353HTA	0.040~0.050	0.050~0.068	0.068~0.087	0.087~0.106	0.106~0.125	0.125~0.144	0.144~0.172	0.172~0.200
			353SUH	0.042~0.053	0.053~0.071	0.071~0.091	0.091~0.111	0.111~0.131	0.131~0.151	0.151~0.181	0.181~0.210
26	S	>35HRC	353TA	0.054~0.064	0.064~0.085	0.085~0.106	0.106~0.126	0.126~0.147	0.147~0.168	0.168~0.199	0.199~0.230
			353HTA	0.057~0.069	0.069~0.091	0.091~0.114	0.114~0.137	0.137~0.159	0.159~0.182	0.182~0.216	0.216~0.250
			353SUH	0.060~0.072	0.072~0.096	0.096~0.120	0.120~0.144	0.144~0.167	0.167~0.191	0.191~0.227	0.227~0.263

	Ø	3-4	4-6	6-8	8-10	10-12	12-14	14-17	17-20
		fn (mm/rev)							
5XD	355TA	fn (mm/rev) = fn 353TA (3XD) x 0,85							
	355HTA	fn (mm/rev) = fn 353HTA (3XD) x 0,85							
	355SUH	fn (mm/rev) = fn 353SUH (3XD) x 0,85							
	355HRC	fn (mm/rev) = fn 353HRC (3XD) x 0,85							
8XD	3584HTA	fn (mm/rev) = fn 353HTA (3XD) x 0,8							

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