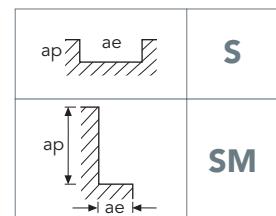


MEF901 - MEF902									
MATERIAL GROUPS	1 4	2 5	3 6	6 7	9 10 26	22 23			
HRC	~30		30~45						
N/mm ²	~1000		1000~1500						
Vc [m/min]	290~330		230~250		155~175				
Ø mm.	n	Vf	n	Vf	n	Vf	n	Vf	
4	23400	1260	18700	450	12700	300	3600	110	
5	18700	1870	15000	660	10000	440	2900	170	
6	15600	2300	12400	840	8400	570	2400	190	
8	11600	2300	9200	840	6300	570	1800	180	
10	9200	2300	7600	840	5100	570	1300	190	
12	8000	2400	6000	800	4200	570	1200	190	
14	6800	2400	5200	840	3600	570	900	130	
16	6000	2400	4800	760	3300	510	800	110	
18	5200	2300	4400	720	2700	420	700	100	
20	4800	2160	3600	560	2400	360	650	100	
25	4300	2150	3200	620	2160	410	600	110	
S ap x ae	0.5DxD		0.5DxD		ap*xD		0.05DxD		
SM ap x ae	1.5DxD		1.5DxD		1.5Dxae**		Dx0.05D		

* Ø4~Ø10 ap=0.15D
 Ø12~Ø16 ap=0.10D
 Ø18~Ø25 ap=0.05D
 **Ø4~Ø10 ae=0.25D
 Ø12~Ø16 ae=0.15D
 Ø18~Ø25 ae=0.10D

MDCSA1											
MATERIAL GROUPS	15	16	17	18	THERMOPLASTICS						
HRC											
N/mm ²											
Vc [m/min]	300~480		300~330		270~290		190~210		300~800		
Ø mm.	n	fn	n	fn	n	fn	n	fn	n	fn	
2	50000	0.035	50000	0.026	44500	0.035	31800	0.035	50000	0.035	
3	50000	0.055	34000	0.045	29800	0.055	21200	0.055	50000	0.055	
4	38200	0.065	25500	0.050	22400	0.065	16000	0.065	50000	0.065	
5	30500	0.080	20500	0.065	17800	0.080	12800	0.080	50000	0.080	
6	25500	0.095	17000	0.076	15000	0.095	10500	0.095	42500	0.095	
8	19000	0.120	12800	0.095	11000	0.120	8000	0.120	32000	0.120	
10	15400	0.148	10300	0.118	9000	0.148	6500	0.148	25500	0.148	
12	12800	0.185	8500	0.146	7500	0.185	5300	0.185	21000	0.185	
S ap x ae	D*xD		D*xD		D*xD		D*xD		D*xD		

*~Ø3 ap=0.75D



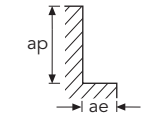
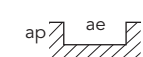
MDCSA1											
MATERIAL GROUPS	15	16	17	18	THERMOPLASTICS						
HRC											
N/mm²											
Vc [m/min]	300~600		300~400		300~350		230~270		300~1000		
Ø mm.	n	fn	n	fn	n	fn	n	fn	n	fn	
2	50000	0.042	50000	0.035	50000	0.035	40000	0.042	50000	0.042	
3	50000	0.070	42500	0.055	37000	0.055	26500	0.070	50000	0.070	
4	48000	0.080	32000	0.065	28000	0.065	20000	0.080	50000	0.080	
5	38500	0.100	25500	0.080	22400	0.080	16000	0.100	50000	0.100	
6	32000	0.120	21000	0.095	18500	0.095	13200	0.120	50000	0.120	
8	24000	0.150	16000	0.120	14000	0.120	10000	0.150	40000	0.150	
10	19000	0.185	12800	0.148	11000	0.148	8000	0.185	32000	0.185	
12	16000	0.230	10500	0.185	9200	0.185	6500	0.230	26500	0.230	
SM ap x ae	Dx0.5D*		Dx0.5D*		Dx0.5D*		Dx0.5D*		Dx0.5D*		

*~Ø3 ap=0.25D

MDCSA2											
MATERIAL GROUPS	15	16									
HRC											
N/mm²											
Vc [m/min]	100~250										
Ø mm.	n	Vf									
3	10000	700									
4	10000	900									
5	10000	1000									
6	10000	1200									
8	8000	1400									
10	8000	1700									
12	8000	2100									
14	6000	1800									
16	6000	1900									
18	4000	1400									
20	4000	1600									
S ap x ae	0.5DxD										
SM ap x ae	Dx0.5*D										

*≤Ø10 ae=0.25D

↓ Z axis : Vf = -50%

	SM
	S

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