

353SUH

stainless steel, polished flutes



3XD

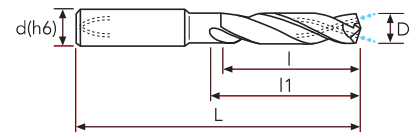
DIN
6537K

MG
PV300

INFO

P	M	K	N	S	H
☆	★	☆	☆	☆	

★ 1st choice ☆ suitable



CARBIDE DRILLS

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

D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
3.00	+0.012/+0.002	6	14	20	62	353SUH0300	●
3.10	+0.016/+0.004	6	14	20	62	353SUH0310	●
3.20	+0.016/+0.004	6	14	20	62	353SUH0320	●
3.30	+0.016/+0.004	6	14	20	62	353SUH0330	●
3.40	+0.016/+0.004	6	14	20	62	353SUH0340	●
3.50	+0.016/+0.004	6	14	20	62	353SUH0350	●
3.60	+0.016/+0.004	6	14	20	62	353SUH0360	●
3.70	+0.016/+0.004	6	14	20	62	353SUH0370	●
3.80	+0.016/+0.004	6	17	24	66	353SUH0380	●
3.90	+0.016/+0.004	6	17	24	66	353SUH0390	●
4.00	+0.016/+0.004	6	17	24	66	353SUH0400	●
4.10	+0.016/+0.004	6	17	24	66	353SUH0410	●
4.20	+0.016/+0.004	6	17	24	66	353SUH0420	●
4.30	+0.016/+0.004	6	17	24	66	353SUH0430	●
4.40	+0.016/+0.004	6	17	24	66	353SUH0440	●
4.50	+0.016/+0.004	6	17	24	66	353SUH0450	●
4.60	+0.016/+0.004	6	17	24	66	353SUH0460	●
4.70	+0.016/+0.004	6	17	24	66	353SUH0470	●
4.80	+0.016/+0.004	6	20	28	66	353SUH0480	●
4.90	+0.016/+0.004	6	20	28	66	353SUH0490	●
5.00	+0.016/+0.004	6	20	28	66	353SUH0500	●
5.10	+0.016/+0.004	6	20	28	66	353SUH0510	●
5.20	+0.016/+0.004	6	20	28	66	353SUH0520	●
5.30	+0.016/+0.004	6	20	28	66	353SUH0530	●
5.40	+0.016/+0.004	6	20	28	66	353SUH0540	●
5.50	+0.016/+0.004	6	20	28	66	353SUH0550	●
5.60	+0.016/+0.004	6	20	28	66	353SUH0560	●
5.70	+0.016/+0.004	6	20	28	66	353SUH0570	●
5.80	+0.016/+0.004	6	20	28	66	353SUH0580	●
5.90	+0.016/+0.004	6	20	28	66	353SUH0590	●
6.00	+0.016/+0.004	6	20	28	66	353SUH0600	●
6.10	+0.021/+0.006	8	24	34	79	353SUH0610	●
6.20	+0.021/+0.006	8	24	34	79	353SUH0620	●
6.30	+0.021/+0.006	8	24	34	79	353SUH0630	●
6.40	+0.021/+0.006	8	24	34	79	353SUH0640	●
6.50	+0.021/+0.006	8	24	34	79	353SUH0650	●
6.60	+0.021/+0.006	8	24	34	79	353SUH0660	●
6.70	+0.021/+0.006	8	24	34	79	353SUH0670	●
6.80	+0.021/+0.006	8	24	34	79	353SUH0680	●

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

● stock standard ○ non-standard stock ▽ stock exhaustion

INFO

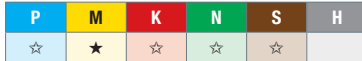
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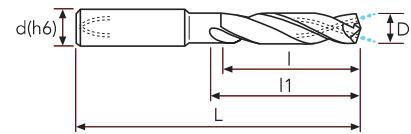


CARBIDE DRILLS

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D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
6.90	+0.021/+0.006	8	24	34	79	353SUH0690	●
7.00	+0.021/+0.006	8	24	34	79	353SUH0700	●
7.10	+0.021/+0.006	8	29	41	79	353SUH0710	●
7.20	+0.021/+0.006	8	29	41	79	353SUH0720	●
7.30	+0.021/+0.006	8	29	41	79	353SUH0730	●
7.40	+0.021/+0.006	8	29	41	79	353SUH0740	●
7.50	+0.021/+0.006	8	29	41	79	353SUH0750	●
7.60	+0.021/+0.006	8	29	41	79	353SUH0760	●
7.70	+0.021/+0.006	8	29	41	79	353SUH0770	●
7.80	+0.021/+0.006	8	29	41	79	353SUH0780	●
7.90	+0.021/+0.006	8	29	41	79	353SUH0790	●
8.00	+0.021/+0.006	8	29	41	79	353SUH0800	●
8.10	+0.021/+0.006	10	35	47	89	353SUH0810	●
8.20	+0.021/+0.006	10	35	47	89	353SUH0820	●
8.30	+0.021/+0.006	10	35	47	89	353SUH0830	●
8.40	+0.021/+0.006	10	35	47	89	353SUH0840	●
8.50	+0.021/+0.006	10	35	47	89	353SUH0850	●
8.60	+0.021/+0.006	10	35	47	89	353SUH0860	●
8.70	+0.021/+0.006	10	35	47	89	353SUH0870	●
8.80	+0.021/+0.006	10	35	47	89	353SUH0880	●
8.90	+0.021/+0.006	10	35	47	89	353SUH0890	●
9.00	+0.021/+0.006	10	35	47	89	353SUH0900	●
9.10	+0.021/+0.006	10	35	47	89	353SUH0910	●
9.20	+0.021/+0.006	10	35	47	89	353SUH0920	●
9.30	+0.021/+0.006	10	35	47	89	353SUH0930	●
9.40	+0.021/+0.006	10	35	47	89	353SUH0940	●
9.50	+0.021/+0.006	10	35	47	89	353SUH0950	●
9.60	+0.021/+0.006	10	35	47	89	353SUH0960	●
9.70	+0.021/+0.006	10	35	47	89	353SUH0970	●
9.80	+0.021/+0.006	10	35	47	89	353SUH0980	●
9.90	+0.021/+0.006	10	35	47	89	353SUH0990	●
10.00	+0.021/+0.006	10	35	47	89	353SUH1000	●
10.20	+0.025/+0.007	12	40	55	102	353SUH1020	●
10.50	+0.025/+0.007	12	40	55	102	353SUH1050	●
10.80	+0.025/+0.007	12	40	55	102	353SUH1080	●
11.00	+0.025/+0.007	12	40	55	102	353SUH1100	●
11.20	+0.025/+0.007	12	40	55	102	353SUH1120	○
11.30	+0.025/+0.007	12	40	55	102	353SUH1130	○
11.50	+0.025/+0.007	12	40	55	102	353SUH1150	●

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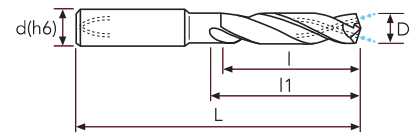


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D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
11.80	+0.025/+0.007	12	40	55	102	353SUH1180	●
12.00	+0.025/+0.007	12	40	55	102	353SUH1200	●
12.20	+0.025/+0.007	14	43	60	107	353SUH1220	●
12.50	+0.025/+0.007	14	43	60	107	353SUH1250	●
12.80	+0.025/+0.007	14	43	60	107	353SUH1280	●
13.00	+0.025/+0.007	14	43	60	107	353SUH1300	●
13.30	+0.025/+0.007	14	43	60	107	353SUH1330	●
13.50	+0.025/+0.007	14	43	60	107	353SUH1350	●
13.80	+0.025/+0.007	14	43	60	107	353SUH1380	●
14.00	+0.025/+0.007	14	43	60	107	353SUH1400	●
14.50	+0.025/+0.007	16	45	65	115	353SUH1450	●
15.00	+0.025/+0.007	16	65	65	115	353SUH1500	●
15.30	+0.025/+0.007	16	65	65	115	353SUH1530	●
15.50	+0.025/+0.007	16	65	65	115	353SUH1550	●
15.80	+0.025/+0.007	16	65	65	115	353SUH1580	●
16.00	+0.025/+0.007	16	65	65	115	353SUH1600	●
16.50	+0.025/+0.007	18	73	73	123	353SUH1650	●
17.00	+0.025/+0.007	18	73	73	123	353SUH1700	●
17.50	+0.025/+0.007	18	73	73	123	353SUH1750	●
18.00	+0.025/+0.007	18	73	73	123	353SUH1800	●
18.50	+0.029/+0.008	20	79	79	131	353SUH1850	●
19.00	+0.029/+0.008	20	79	79	131	353SUH1900	●
19.50	+0.029/+0.008	20	79	79	131	353SUH1950	●
20.00	+0.029/+0.008	20	79	79	131	353SUH2000	●

HSS DRILLS

- LFTA
- SUTA
- HSS-HSS/CO

CARBIDE END-MILLS

- G2
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- MEF
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HSS END-MILLS

CARBIDE BURRS

● stock standard ○ non-standard stock ▽ stock exhaustion

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353SUH

CARBIDE DRILLS

PU-HPU
TA-4HTA
SUH
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Material Group ISO 513	P1 P2	P3 P4	P5	P6	P7	P8
Hardness/Rm	500÷700 N/mm ²	600÷1000 N/mm ²	900÷1200 N/mm ²	1200÷1400 N/mm ²		
Vc (m/min)	130÷150	100÷140	80÷100	55÷75	50÷70	20÷30
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)
3	0.118	0.106	0.095	0.083	0.077	0.046
4	0.140	0.126	0.112	0.098	0.091	0.055
5	0.161	0.145	0.129	0.113	0.105	0.063
6	0.183	0.164	0.146	0.128	0.119	0.071
7	0.204	0.184	0.163	0.143	0.133	0.080
8	0.226	0.203	0.181	0.158	0.147	0.088
9	0.247	0.223	0.198	0.173	0.161	0.096
10	0.269	0.242	0.215	0.188	0.175	0.105
11	0.280	0.252	0.224	0.196	0.182	0.109
12	0.301	0.271	0.241	0.211	0.196	0.117
13	0.323	0.290	0.258	0.226	0.210	0.126
14	0.344	0.310	0.275	0.241	0.224	0.134
15	0.366	0.329	0.292	0.256	0.238	0.143
16	0.387	0.348	0.310	0.271	0.252	0.151
17	0.398	0.358	0.318	0.278	0.259	0.155
18	0.409	0.368	0.327	0.286	0.266	0.159
19	0.419	0.377	0.335	0.293	0.273	0.164
20	0.430	0.387	0.344	0.301	0.280	0.168

HSS DRILLS

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HSS-HSS/CO

CARBIDE END-MILLS

G2
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HFVH/UP
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ALU
MEX/MH
UHM/MH



Material Group ISO 513	M1	M2	M3			
Hardness/Rm						
Vc (m/min)	50÷70	40÷60	30÷40			
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)			
3	0.077	0.061	0.054			
4	0.091	0.073	0.064			
5	0.105	0.084	0.073			
6	0.119	0.095	0.083			
7	0.133	0.106	0.093			
8	0.147	0.117	0.103			
9	0.161	0.129	0.112			
10	0.175	0.140	0.122			
11	0.182	0.145	0.127			
12	0.196	0.157	0.137			
13	0.210	0.168	0.147			
14	0.224	0.179	0.157			
15	0.238	0.190	0.166			
16	0.252	0.201	0.176			
17	0.259	0.207	0.181			
18	0.266	0.212	0.186			
19	0.273	0.218	0.191			
20	0.280	0.224	0.196			

HSS END-MILLS

CARBIDE BURRS

CUTTING PARAMETERS

353SUH

	Material Group ISO 513	K1	K2	K3	K4		
	Hardness/Rm	150÷250 HB	150÷350 HB	120÷260 HB	250÷500 HB		
	Vc (m/min)	110÷130	90÷110	70÷90	55÷75		
	D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
	3	0.118	0.106	0.095	0.083		
4	0.140	0.126	0.112	0.098			
5	0.161	0.145	0.129	0.113			
6	0.183	0.164	0.146	0.128			
7	0.204	0.184	0.163	0.143			
8	0.226	0.203	0.181	0.158			
9	0.247	0.223	0.198	0.173			
10	0.269	0.242	0.215	0.188			
11	0.280	0.252	0.224	0.196			
12	0.301	0.271	0.241	0.211			
13	0.323	0.290	0.258	0.226			
14	0.344	0.310	0.275	0.241			
15	0.366	0.329	0.292	0.256			
16	0.387	0.348	0.310	0.271			
17	0.398	0.358	0.318	0.278			
18	0.409	0.368	0.327	0.286			
19	0.419	0.377	0.335	0.293			
20	0.430	0.387	0.344	0.301			

	Material Group ISO 513	N2	N4				
	Hardness/Rm						
	Vc (m/min)	180÷220	160÷200				
	D (mm)	fn (mm/rev)	fn (mm/rev)				
	3	0.128	0.128				
4	0.151	0.151					
5	0.174	0.174					
6	0.197	0.197					
7	0.221	0.221					
8	0.244	0.244					
9	0.267	0.267					
10	0.290	0.290					
11	0.302	0.302					
12	0.325	0.325					
13	0.348	0.348					
14	0.372	0.372					
15	0.395	0.395					
16	0.418	0.418					
17	0.430	0.430					
18	0.441	0.441					
19	0.453	0.453					
20	0.464	0.464					

INFO

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TA-4HTA
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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

INFO

353SUH

CARBIDE
DRILLS

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



Material Group ISO 513	S1 S2	S3	S4	S5		
Hardness/Rm	<35 HRC	35+45 HRC				
Vc (m/min)	30+50	20+40	45+65	35+55		
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
3	0.053	0.037	0.051	0.043		
4	0.063	0.044	0.060	0.050		
5	0.073	0.051	0.069	0.058		
6	0.082	0.058	0.078	0.066		
7	0.092	0.064	0.087	0.074		
8	0.102	0.071	0.097	0.081		
9	0.111	0.078	0.106	0.089		
10	0.121	0.085	0.115	0.097		
11	0.126	0.088	0.119	0.101		
12	0.135	0.095	0.129	0.108		
13	0.145	0.102	0.138	0.116		
14	0.155	0.108	0.147	0.124		
15	0.164	0.115	0.156	0.132		
16	0.174	0.122	0.165	0.139		
17	0.179	0.125	0.170	0.143		
18	0.184	0.129	0.175	0.147		
19	0.189	0.132	0.179	0.151		
20	0.194	0.135	0.184	0.155		

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DRILLS

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CARBIDE
BURRS

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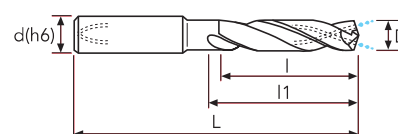
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D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
3.00	+0.012/+0.002	6	23	28	66	355SUH0300	●
3.10	+0.016/+0.004	6	23	28	66	355SUH0310	●
3.20	+0.016/+0.004	6	23	28	66	355SUH0320	●
3.30	+0.016/+0.004	6	23	28	66	355SUH0330	●
3.40	+0.016/+0.004	6	23	28	66	355SUH0340	●
3.50	+0.016/+0.004	6	23	28	66	355SUH0350	●
3.60	+0.016/+0.004	6	23	28	66	355SUH0360	●
3.70	+0.016/+0.004	6	23	28	66	355SUH0370	●
3.80	+0.016/+0.004	6	29	36	74	355SUH0380	●
3.90	+0.016/+0.004	6	29	36	74	355SUH0390	●
4.00	+0.016/+0.004	6	29	36	74	355SUH0400	●
4.10	+0.016/+0.004	6	29	36	74	355SUH0410	●
4.20	+0.016/+0.004	6	29	36	74	355SUH0420	●
4.30	+0.016/+0.004	6	29	36	74	355SUH0430	●
4.40	+0.016/+0.004	6	29	36	74	355SUH0440	●
4.50	+0.016/+0.004	6	29	36	74	355SUH0450	●
4.60	+0.016/+0.004	6	29	36	74	355SUH0460	●
4.70	+0.016/+0.004	6	29	36	74	355SUH0470	●
4.80	+0.016/+0.004	6	35	44	82	355SUH0480	●
4.90	+0.016/+0.004	6	35	44	82	355SUH0490	●
5.00	+0.016/+0.004	6	35	44	82	355SUH0500	●
5.10	+0.016/+0.004	6	35	44	82	355SUH0510	●
5.20	+0.016/+0.004	6	35	44	82	355SUH0520	●
5.30	+0.016/+0.004	6	35	44	82	355SUH0530	●
5.40	+0.016/+0.004	6	35	44	82	355SUH0540	●
5.50	+0.016/+0.004	6	35	44	82	355SUH0550	●
5.60	+0.016/+0.004	6	35	44	82	355SUH0560	●
5.70	+0.016/+0.004	6	35	44	82	355SUH0570	●
5.80	+0.016/+0.004	6	35	44	82	355SUH0580	●
5.90	+0.016/+0.004	6	35	44	82	355SUH0590	●
6.00	+0.016/+0.004	6	35	44	82	355SUH0600	●
6.10	+0.021/+0.006	8	43	53	91	355SUH0610	●
6.20	+0.021/+0.006	8	43	53	91	355SUH0620	●
6.30	+0.021/+0.006	8	43	53	91	355SUH0630	●
6.40	+0.021/+0.006	8	43	53	91	355SUH0640	●
6.50	+0.021/+0.006	8	43	53	91	355SUH0650	●
6.60	+0.021/+0.006	8	43	53	91	355SUH0660	●
6.70	+0.021/+0.006	8	43	53	91	355SUH0670	●
6.80	+0.021/+0.006	8	43	53	91	355SUH0680	●

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

● stock standard ○ non-standard stock ▽ stock exhaustion

INFO

355SUH

stainless steel, polished flutes



CARBIDE DRILLS

PU-HPU

TA-4HTA

SUH

ALH

HRC

SUH MINI

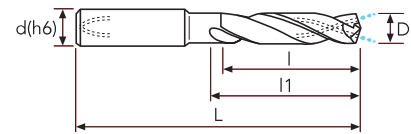
HL

HSD

C-SD-TA

P	M	K	N	S	H
☆	★	☆	☆	☆	☆

★ 1st choice ☆ suitable



D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
6.90	+0.021/+0.006	8	43	53	91	355SUH0690	●
7.00	+0.021/+0.006	8	43	53	91	355SUH0700	●
7.10	+0.021/+0.006	8	43	53	91	355SUH0710	●
7.20	+0.021/+0.006	8	43	53	91	355SUH0720	●
7.30	+0.021/+0.006	8	43	53	91	355SUH0730	●
7.40	+0.021/+0.006	8	43	53	91	355SUH0740	●
7.50	+0.021/+0.006	8	43	53	91	355SUH0750	●
7.60	+0.021/+0.006	8	43	53	91	355SUH0760	●
7.70	+0.021/+0.006	8	43	53	91	355SUH0770	●
7.80	+0.021/+0.006	8	43	53	91	355SUH0780	●
7.90	+0.021/+0.006	8	43	53	91	355SUH0790	●
8.00	+0.021/+0.006	8	43	53	91	355SUH0800	●
8.10	+0.021/+0.006	10	49	61	103	355SUH0810	●
8.20	+0.021/+0.006	10	49	61	103	355SUH0820	●
8.30	+0.021/+0.006	10	49	61	103	355SUH0830	●
8.40	+0.021/+0.006	10	49	61	103	355SUH0840	●
8.50	+0.021/+0.006	10	49	61	103	355SUH0850	●
8.60	+0.021/+0.006	10	49	61	103	355SUH0860	●
8.70	+0.021/+0.006	10	49	61	103	355SUH0870	●
8.80	+0.021/+0.006	10	49	61	103	355SUH0880	●
8.90	+0.021/+0.006	10	49	61	103	355SUH0890	●
9.00	+0.021/+0.006	10	49	61	103	355SUH0900	●
9.10	+0.021/+0.006	10	49	61	103	355SUH0910	●
9.20	+0.021/+0.006	10	49	61	103	355SUH0920	●
9.30	+0.021/+0.006	10	49	61	103	355SUH0930	●
9.40	+0.021/+0.006	10	49	61	103	355SUH0940	●
9.50	+0.021/+0.006	10	61	61	103	355SUH0950	●
9.60	+0.021/+0.006	10	61	61	103	355SUH0960	●
9.70	+0.021/+0.006	10	61	61	103	355SUH0970	●
9.80	+0.021/+0.006	10	61	61	103	355SUH0980	●
9.90	+0.021/+0.006	10	61	61	103	355SUH0990	●
10.00	+0.021/+0.006	10	61	61	103	355SUH1000	●
10.20	+0.025/+0.007	12	71	71	118	355SUH1020	●
10.30	+0.025/+0.007	12	71	71	118	355SUH1030	●
10.50	+0.025/+0.007	12	71	71	118	355SUH1050	●
10.80	+0.025/+0.007	12	71	71	118	355SUH1080	●
11.00	+0.025/+0.007	12	71	71	118	355SUH1100	●
11.20	+0.025/+0.007	12	71	71	118	355SUH1120	●
11.30	+0.025/+0.007	12	71	71	118	355SUH1130	●

● stock standard ○ non-standard stock ▽ stock exhaustion

355SUH

stainless steel, polished flutes

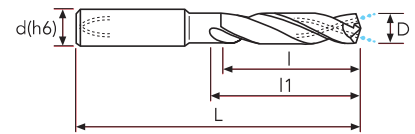


INFO



P	M	K	N	S	H
☆	★	☆	☆	☆	

★ 1st choice ☆ suitable



CARBIDE DRILLS

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

D(m7)	D Tol.	d(h6)	l	l1	L	EDP No.	Stock
11.50	+0.025/+0.007	12	71	71	118	355SUH1150	●
11.80	+0.025/+0.007	12	71	71	118	355SUH1180	●
12.00	+0.025/+0.007	12	71	71	118	355SUH1200	●
12.20	+0.025/+0.007	14	77	77	124	355SUH1220	●
12.50	+0.025/+0.007	14	77	77	124	355SUH1250	●
12.80	+0.025/+0.007	14	77	77	124	355SUH1280	●
13.00	+0.025/+0.007	14	77	77	124	355SUH1300	●
13.30	+0.025/+0.007	14	77	77	124	355SUH1330	●
13.50	+0.025/+0.007	14	77	77	124	355SUH1350	●
13.80	+0.025/+0.007	14	77	77	124	355SUH1380	●
14.00	+0.025/+0.007	14	77	77	124	355SUH1400	●
14.50	+0.025/+0.007	16	83	83	133	355SUH1450	●
15.00	+0.025/+0.007	16	83	83	133	355SUH1500	●
15.30	+0.025/+0.007	16	83	83	133	355SUH1530	●
15.50	+0.025/+0.007	16	83	83	133	355SUH1550	●
15.80	+0.025/+0.007	16	83	83	133	355SUH1580	●
16.00	+0.025/+0.007	16	83	83	133	355SUH1600	●
16.50	+0.025/+0.007	18	93	93	143	355SUH1650	●
17.00	+0.025/+0.007	18	93	93	143	355SUH1700	●
17.50	+0.025/+0.007	18	93	93	143	355SUH1750	●
18.00	+0.025/+0.007	18	93	93	143	355SUH1800	●
18.50	+0.029/+0.008	20	101	101	153	355SUH1850	●
19.00	+0.029/+0.008	20	101	101	153	355SUH1900	●
19.50	+0.029/+0.008	20	101	101	153	355SUH1950	●
20.00	+0.029/+0.008	20	101	101	153	355SUH2000	●

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

● stock standard ○ non-standard stock ▽ stock exhaustion

INFO

355SUH

CARBIDE DRILLS

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



Material Group ISO 513	P1 P2	P3 P4	P5	P6	P7	P8
Hardness/Rm	500÷700 N/mm ²	600÷1000 N/mm ²	900÷1200 N/mm ²	1200÷1400 N/mm ²		
Vc (m/min)	120+140	100+120	70+90	45+65	40+60	15+25
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)
3	0.101	0.075	0.060	0.050	0.065	0.039
4	0.119	0.089	0.071	0.059	0.077	0.046
5	0.137	0.103	0.082	0.069	0.089	0.053
6	0.155	0.117	0.093	0.078	0.101	0.061
7	0.174	0.130	0.104	0.087	0.113	0.068
8	0.192	0.144	0.115	0.096	0.125	0.075
9	0.210	0.158	0.126	0.105	0.137	0.082
10	0.228	0.171	0.137	0.114	0.148	0.089
11	0.238	0.178	0.143	0.119	0.154	0.093
12	0.256	0.192	0.154	0.128	0.166	0.100
13	0.274	0.206	0.164	0.137	0.178	0.107
14	0.292	0.219	0.175	0.146	0.190	0.114
15	0.311	0.233	0.186	0.155	0.202	0.121
16	0.329	0.247	0.197	0.164	0.214	0.128
17	0.338	0.254	0.203	0.169	0.220	0.132
18	0.347	0.260	0.208	0.174	0.226	0.135
19	0.356	0.267	0.214	0.178	0.232	0.139
20	0.366	0.274	0.219	0.183	0.238	0.143

HSS DRILLS

- LFTA
- SUTA
- HSS-HSS/CO



Material Group ISO 513	M1	M2	M3			
Hardness/Rm						
Vc (m/min)	40+60	30+50	25+35			
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)			
3	0.065	0.052	0.046			
4	0.077	0.062	0.054			
5	0.089	0.071	0.062			
6	0.101	0.081	0.071			
7	0.113	0.090	0.079			
8	0.125	0.100	0.087			
9	0.137	0.109	0.096			
10	0.148	0.119	0.104			
11	0.154	0.124	0.108			
12	0.166	0.133	0.116			
13	0.178	0.143	0.125			
14	0.190	0.152	0.133			
15	0.202	0.162	0.141			
16	0.214	0.171	0.150			
17	0.220	0.176	0.154			
18	0.226	0.181	0.158			
19	0.232	0.185	0.162			
20	0.238	0.190	0.166			

CARBIDE END-MILLS

- G2
- MDTA
- HFVH/UP
- MEF
- ALU
- MEX/MH
- UHMH

HSS END-MILLS

CARBIDE BURRS

CUTTING PARAMETERS

INFO

355SUH

	Material Group ISO 513	K1	K2	K3	K4		
	Hardness/Rm	150÷250 HB	150÷350 HB	120÷260 HB	250÷500 HB		
	Vc (m/min)	100÷120	80÷100	55÷75	40÷60		
	D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
	3	0.101	0.090	0.080	0.070		
4	0.119	0.107	0.095	0.083			
5	0.137	0.123	0.110	0.096			
6	0.155	0.140	0.124	0.109			
7	0.174	0.156	0.139	0.122			
8	0.192	0.173	0.154	0.134			
9	0.210	0.189	0.168	0.147			
10	0.228	0.206	0.183	0.160			
11	0.238	0.214	0.190	0.166			
12	0.256	0.230	0.205	0.179			
13	0.274	0.247	0.219	0.192			
14	0.292	0.263	0.234	0.205			
15	0.311	0.280	0.249	0.217			
16	0.329	0.296	0.263	0.230			
17	0.338	0.304	0.270	0.237			
18	0.347	0.313	0.278	0.243			
19	0.356	0.321	0.285	0.249			
20	0.366	0.329	0.292	0.256			

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

	Material Group ISO 513	N2	N4				
	Hardness/Rm						
	Vc (m/min)	180÷220	160÷200				
	D (mm)	fn (mm/rev)	fn (mm/rev)				
	3	0.109	0.096				
4	0.128	0.114					
5	0.148	0.132					
6	0.168	0.149					
7	0.188	0.167					
8	0.207	0.184					
9	0.227	0.202					
10	0.247	0.219					
11	0.257	0.228					
12	0.276	0.246					
13	0.296	0.263					
14	0.316	0.281					
15	0.336	0.298					
16	0.355	0.316					
17	0.365	0.325					
18	0.375	0.333					
19	0.385	0.342					
20	0.395	0.351					

INFO

355SUH

CARBIDE DRILLS

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



Material Group ISO 513	S1 S2	S3	S4	S5		
Hardness/Rm	<35 HRC	35+45 HRC				
Vc (m/min)	25+45	15+35	40+60	30+50		
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
3	0.045	0.032	0.043	0.036		
4	0.053	0.037	0.051	0.043		
5	0.062	0.043	0.059	0.049		
6	0.070	0.049	0.066	0.056		
7	0.078	0.055	0.074	0.063		
8	0.086	0.060	0.082	0.069		
9	0.095	0.066	0.090	0.076		
10	0.103	0.072	0.098	0.082		
11	0.107	0.075	0.102	0.086		
12	0.115	0.081	0.109	0.092		
13	0.123	0.086	0.117	0.099		
14	0.132	0.092	0.125	0.105		
15	0.140	0.098	0.133	0.112		
16	0.148	0.104	0.141	0.118		
17	0.152	0.106	0.145	0.122		
18	0.156	0.109	0.148	0.125		
19	0.160	0.112	0.152	0.128		
20	0.164	0.115	0.156	0.132		

HSS DRILLS

- LFTA
- SUTA
- HSS-HSS/CO

CARBIDE END-MILLS

- G2
- MDTA
- HFVH/UP
- MEF
- ALU
- MEX/MH
- UH/MH

HSS END-MILLS

CARBIDE BURRS