


4HTA

4HTA 8xD

- Self-centering geometry for accurate holes
- 4 margin lands: reliable machining for highly accurate and straight holes even in deep drilling
- Straight cutting edge: short chips for easy evacuation and high reliability
- Special edge design: high performance and edge protection
- Back taper geometry: improves the cutting performance
- Chip pocket finishing: highly polished to reduce welding and improves chip ejection
- Large oil holes: improves coolant feed
- Substrate and coating: specifically selected for high wear resistance, long and reliable life


4HTA 8xD

- Affilatura autocentrante per fori precisi
- Geometria con "4 Margini": fori rettilinei e precisi, anche nel caso di profondità elevate.
- Profilo del tagliente diritto e rinforzato: genera trucioli corti e garantisce grande affidabilità
- Geometria del tagliente con affilatura specifica a protezione del tagliente e degli spigoli
- Geometria del corpo con conicità posteriore per agevolare l'azione di taglio
- Finitura gole: lappate per ridurre il problema dell'incollaggio e facilitare l'evacuazione dei trucioli
- Fori di refrigerazione con geometria modificata per un maggior apporto di refrigerante
- Substrato e rivestimento specifici per garantire durata e affidabilità


4HTA 8xD

- Selbstzentrierender Schliff für präzise Bohrungen
- Geometrie mit „4 Fasen“: gerade und präzise Bohrungen, auch bei großen Tiefen.
- Gerades und verstärktes Schneidkantenprofil: zur Erzeugung kurzer Späne und zur Gewährleistung hoher Zuverlässigkeit
- Geometrie der Schneidkante mit speziellem Schliff zum Schutz von Schneidkante und Kanten
- Geometrie des Körpers mit konischem hinteren Bereich zur Erleichterung des Schnittvorgangs
- Schlichtbearbeitung der Nuten: geläpft, um Probleme durch Verkleben zu reduzieren und um die Späneabführung zu erleichtern
- Kühlöffnungen mit abgeänderter Geometrie für einen verbesserten Kühlmittelzufluss
- Spezielles Trägermaterial und spezielle Beschichtung zur Gewährleistung von Standzeit und Zuverlässigkeit


4HTA 8xD

- Affûtage autocentré pour un perçage plus précis.
- Géométrie avec « 4 listels » : trous droits et précis, même en présence de trous profonds.
- Profil de l'arête droit et renforcé : il génère des copeaux courts et garantit une grande fiabilité
- Géométrie de l'arête avec affûtage spécifique pour protéger l'arête et les angles
- Géométrie du corps avec conicité arrière pour faciliter l'action de coupe
- Finition des goujures : polie pour réduire le problème du collage et faciliter l'évacuation des copeaux
- Trous de lubrification avec géométrie modifiée pour un apport de lubrifiant plus important
- Substrat et revêtement spécifiques pour garantir durée et fiabilité


4HTA 8xD

- Afilado autocentrante para agujeros precisos
- Geometría con «4 Márgenes»: agujeros rectilíneos y precisos, incluso en caso de profundidades elevadas.
- Perfil del filo recto y reforzado: genera virutas cortas y garantiza una gran fiabilidad
- Geometría del filo con afilado específico para proteger el filo y los ángulos
- Geometría del cuerpo con conicidad posterior para facilitar la acción de corte
- Acabado ranuras: lapeadas para reducir el problema del encolado y facilitar la evacuación de las virutas
- Agujeros de refrigeración con geometría modificada para una mayor aportación de refrigerante
- Sustrato y revestimiento específicos para garantizar duración y fiabilidad


4HTA 8xD

- Самоцентрирующаяся заточка для сверления отверстий высокой точности
- Геометрия с 4 режущими кромками: надежная обработка и высокая точность отверстия, даже, при глубоком сверлении
- Прямые режущие кромки: легкий вывод короткой стружки и высокая эффективность
- Геометрия режущих кромок со специальной заточкой: высокая производительность и защита кромок
- Геометрия с обратным конусом: повышение производительности
- Отполированные стружечные канавки: уменьшают вероятность приваривания стружки и облегчают ее вывод
- Большие отверстия: увеличена эффективность подвода СОЖ
- Специальное покрытие для повышения стойкости инструмента

 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

INFO

343TA-318N

general purpose, coated (343TA) and uncoated (318N)

3XD

DIN
6539

MG
PV200

MG
BR

343TA
318N



CARBIDE DRILLS

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

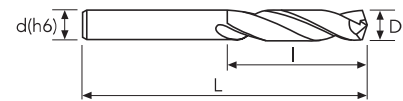
P	M	K	N	S	H	
★	☆	☆	☆	☆	☆	
						343TA
★	☆	☆	☆	☆	☆	318N

★ 1st choice ☆ suitable

< ø2 mm



≥ ø2 mm



D(h7)	D Tol.	d(h6)	l	l1	L	343TA		318N	
						EDP No.	Stock	EDP No.	Stock
1.00	0/-0.010	2	6		40	343TA0100	●	P318N0100	●
1.10	0/-0.010	2	7		40	343TA0110	●	P318N0110	●
1.20	0/-0.010	2	8		40	343TA0120	●	P318N0120	●
1.30	0/-0.010	2	8		40	343TA0130	●	P318N0130	●
1.40	0/-0.010	2	9		40	343TA0140	●	P318N0140	●
1.50	0/-0.010	2	9		40	343TA0150	●	P318N0150	●
1.60	0/-0.010	2	10		40	343TA0160	●	P318N0160	●
1.70	0/-0.010	2	10		40	343TA0170	●	P318N0170	●
1.80	0/-0.010	2	11		40	343TA0180	●	P318N0180	●
1.90	0/-0.010	2	11		40	343TA0190	●	P318N0190	●
2.00	0/-0.010	2	12		40	343TA0200	●	P318N0200	●
2.10	0/-0.010	2.1	12		40	343TA0210	●	P318N0210	●
2.20	0/-0.010	2.2	13		40	343TA0220	●	P318N0220	●
2.30	0/-0.010	2.3	13		46	343TA0230	●	P318N0230	●
2.40	0/-0.010	2.4	14		46	343TA0240	●	P318N0240	●
2.50	0/-0.010	2.5	14		46	343TA0250	●	P318N0250	●
2.60	0/-0.010	2.6	14		46	343TA0260	●	P318N0260	●
2.70	0/-0.010	2.7	16		46	343TA0270	●	P318N0270	●
2.80	0/-0.010	2.8	16		49	343TA0280	●	P318N0280	●
2.90	0/-0.010	2.9	16		49	343TA0290	●	P318N0290	●
3.00	0/-0.010	3	16		49	343TA0300	●	P318N0300	●
3.10	0/-0.012	3.1	18		49	343TA0310	●	P318N0310	●
3.20	0/-0.012	3.2	18		49	343TA0320	●	P318N0320	●
3.30	0/-0.012	3.3	18		52	343TA0330	●	P318N0330	●
3.40	0/-0.012	3.4	20		52	343TA0340	●	P318N0340	●
3.50	0/-0.012	3.5	20		52	343TA0350	●	P318N0350	●
3.60	0/-0.012	3.6	20		52	343TA0360	●	P318N0360	●
3.70	0/-0.012	3.7	20		52	343TA0370	●	P318N0370	●
3.80	0/-0.012	3.8	22		55	343TA0380	●	P318N0380	●
3.90	0/-0.012	3.9	22		55	343TA0390	●	P318N0390	●
4.00	0/-0.012	4	22		55	343TA0400	●	P318N0400	●
4.10	0/-0.012	4.1	22		55	343TA0410	●	P318N0410	●
4.20	0/-0.012	4.2	22		55	343TA0420	●	P318N0420	●
4.30	0/-0.012	4.3	24		58	343TA0430	●	P318N0430	●
4.40	0/-0.012	4.4	24		58	343TA0440	●	P318N0440	●
4.50	0/-0.012	4.5	24		58	343TA0450	●	P318N0450	●
4.60	0/-0.012	4.6	24		58	343TA0460	●	P318N0460	●
4.70	0/-0.012	4.7	24		58	343TA0470	●	P318N0470	●
4.80	0/-0.012	4.8	26		62	343TA0480	●	P318N0480	●

● stock standard ○ non-standard stock ▽ stock exhaustion

343TA-318N

general purpose, coated (343TA) and uncoated (318N)

3XD

DIN
6539

TA

MG
PV200
343TA

MG
BR
318N

140°

30°

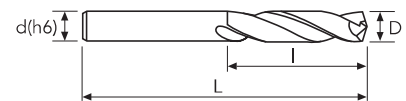
INFO



P	M	K	N	S	H
★	☆	☆	☆		
★	☆	☆	☆		

343TA
318N

★ 1st choice ☆ suitable



D(h7)	D Tol.	d(h6)	l	l1	L	343TA		318N	
						EDP No.	Stock	EDP No.	Stock
4.90	0/-0.012	4.9	26		62	343TA0490	●	P318N0490	●
5.00	0/-0.012	5	26		62	343TA0500	●	P318N0500	●
5.10	0/-0.012	5.1	26		62	343TA0510	●	P318N0510	●
5.20	0/-0.012	5.2	26		62	343TA0520	●	P318N0520	●
5.30	0/-0.012	5.3	26		66	343TA0530	●	P318N0530	●
5.40	0/-0.012	5.4	28		66	343TA0540	●	P318N0540	●
5.50	0/-0.012	5.5	28		66	343TA0550	●	P318N0550	●
5.60	0/-0.012	5.6	28		66	343TA0560	●	P318N0560	●
5.70	0/-0.012	5.7	28		66	343TA0570	●	P318N0570	●
5.80	0/-0.012	5.8	28		70	343TA0580	●	P318N0580	●
5.90	0/-0.012	5.9	28		70	343TA0590	●	P318N0590	●
6.00	0/-0.012	6	28		70	343TA0600	●	P318N0600	●
6.10	0/-0.015	6.1	31		70	343TA0610	●	P318N0610	●
6.20	0/-0.015	6.2	31		70	343TA0620	●	P318N0620	●
6.30	0/-0.015	6.3	31		70	343TA0630	●	P318N0630	●
6.40	0/-0.015	6.4	31		70	343TA0640	●	P318N0640	●
6.50	0/-0.015	6.5	31		70	343TA0650	●	P318N0650	●
6.60	0/-0.015	6.6	31		70	343TA0660	●	P318N0660	●
6.70	0/-0.015	6.7	31		70	343TA0670	●	P318N0670	●
6.80	0/-0.015	6.8	34		74	343TA0680	●	P318N0680	●
6.90	0/-0.015	6.9	34		74	343TA0690	●	P318N0690	●
7.00	0/-0.015	7	34		74	343TA0700	●	P318N0700	●
7.10	0/-0.015	7.1	34		74	343TA0710	●	P318N0710	●
7.20	0/-0.015	7.2	34		74	343TA0720	●	P318N0720	●
7.30	0/-0.015	7.3	34		79	343TA0730	●	P318N0730	●
7.40	0/-0.015	7.4	34		79	343TA0740	●	P318N0740	●
7.50	0/-0.015	7.5	34		79	343TA0750	●	P318N0750	●
7.60	0/-0.015	7.6	37		79	343TA0760	●	P318N0760	○
7.70	0/-0.015	7.7	37		79	343TA0770	●	P318N0770	○
7.80	0/-0.015	7.8	37		79	343TA0780	●	P318N0780	●
7.90	0/-0.015	7.9	37		79	343TA0790	●	P318N0790	○
8.00	0/-0.015	8	37		79	343TA0800	●	P318N0800	●
8.10	0/-0.015	8.1	37		79	343TA0810	●	P318N0810	●
8.20	0/-0.015	8.2	37		79	343TA0820	●	P318N0820	●
8.30	0/-0.015	8.3	37		84	343TA0830	●	P318N0830	●
8.40	0/-0.015	8.4	37		84	343TA0840	●	P318N0840	○
8.50	0/-0.015	8.5	37		84	343TA0850	●	P318N0850	●
8.60	0/-0.015	8.6	40		84	343TA0860	●	P318N0860	●
8.70	0/-0.015	8.7	40		84	343TA0870	●	P318N0870	●

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

● stock standard ○ non-standard stock ▽ stock exhaustion

INFO

343TA-318N

general purpose, coated (343TA) and uncoated (318N)

3XD	DIN 6539		MG PV200	MG BR		
			343TA	318N		

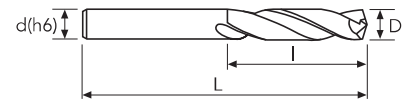


CARBIDE DRILLS

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

P	M	K	N	S	H	
★	☆	☆	☆			343TA
★	☆	☆	☆			318N

★ 1st choice ☆ suitable



D(h7)	D Tol.	d(h6)	l	l1	L	343TA		318N	
						EDP No.	Stock	EDP No.	Stock
8.80	0/-0.015	8.8	40		84	343TA0880	●	P318N0880	●
8.90	0/-0.015	8.9	40		84	343TA0890	●	P318N0890	○
9.00	0/-0.015	9	40		84	343TA0900	●	P318N0900	●
9.10	0/-0.015	9.1	40		84	343TA0910	●	P318N0910	○
9.20	0/-0.015	9.2	40		84	343TA0920	●	P318N0920	●
9.30	0/-0.015	9.3	40		89	343TA0930	●	P318N0930	●
9.40	0/-0.015	9.4	40		89	343TA0940	●	P318N0940	○
9.50	0/-0.015	9.5	40		89	343TA0950	●	P318N0950	●
9.60	0/-0.015	9.6	43		89	343TA0960	●	P318N0960	○
9.70	0/-0.015	9.7	43		89	343TA0970	●	P318N0970	○
9.80	0/-0.015	9.8	43		89	343TA0980	●	P318N0980	●
9.90	0/-0.015	9.9	43		89	343TA0990	●	P318N0990	○
10.00	0/-0.015	10	43		89	343TA1000	●	P318N1000	●
10.20	0/-0.018	10.2	43		89	343TA1020	●	P318N1020	●
10.50	0/-0.018	10.5	43		95	343TA1050	●	P318N1050	●
11.00	0/-0.018	11	47		95	343TA1100	●	P318N1100	●
11.50	0/-0.018	11.5	47		102	343TA1150	●	P318N1150	●
12.00	0/-0.018	12	51		102	343TA1200	●	P318N1200	●
12.50	0/-0.018	12.5	51		103	343TA1250	●	P318N1250	●
13.00	0/-0.018	13	51		103	343TA1300	●	P318N1300	●
13.50	0/-0.018	13.5	54		107	343TA1350	●		
14.00	0/-0.018	14	54		107	343TA1400	●		
14.50	0/-0.018	14.5	56		111	343TA1450	●		
15.00	0/-0.018	15	56		111	343TA1500	●		
15.50	0/-0.018	15.5	58		115	343TA1550	●		
16.00	0/-0.018	16	58		115	343TA1600	●		

● stock standard ○ non-standard stock ▽ stock exhaustion

CUTTING PARAMETERS

INFO

343TA

Material Group ISO 513	P1 P2 P3	P7	M1	K1	N1 N2		
	Hardness/Rm	<800 N/mm ²	<700 N/mm ²	<750 N/mm ²	150÷250 HB		
Vc (m/min)	80÷100	35÷45	35÷45	80÷100	140÷180		
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)			
1	0.050	0.035	0.035	0.050	0.065		
2	0.070	0.049	0.049	0.070	0.091		
3	0.086	0.060	0.060	0.086	0.112		
4	0.126	0.088	0.088	0.126	0.164		
5	0.131	0.092	0.092	0.131	0.170		
6	0.145	0.102	0.102	0.145	0.189		
7	0.165	0.116	0.116	0.165	0.215		
8	0.185	0.130	0.130	0.185	0.241		
9	0.205	0.144	0.144	0.205	0.267		
10	0.224	0.157	0.157	0.224	0.291		
11	0.244	0.171	0.171	0.244	0.317		
12	0.263	0.184	0.184	0.263	0.342		
13	0.282	0.197	0.197	0.282	0.367		
14	0.302	0.211	0.211	0.302	0.393		
15	0.315	0.221	0.221	0.315	0.410		
16	0.336	0.235	0.235	0.336	0.437		



CARBIDE DRILLS

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

318N

Material Group ISO 513	P1 P2 P3	P7	M1	K1	N1 N2	
	Hardness/Rm	<800 N/mm ²	<700 N/mm ²	<750 N/mm ²	150÷250 HB	
Vc (m/min)	60÷80	20÷30	20÷30	50÷70	100÷140	
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
1	0.035	0.025	0.025	0.032	0.046	
2	0.050	0.035	0.035	0.045	0.065	
3	0.065	0.046	0.046	0.059	0.085	
4	0.080	0.056	0.056	0.072	0.104	
5	0.095	0.067	0.067	0.086	0.124	
6	0.110	0.077	0.077	0.099	0.143	
7	0.125	0.088	0.088	0.113	0.163	
8	0.140	0.098	0.098	0.126	0.182	
9	0.155	0.109	0.109	0.140	0.202	
10	0.170	0.119	0.119	0.153	0.221	
11	0.185	0.130	0.130	0.167	0.241	
12	0.200	0.140	0.140	0.180	0.260	
13	0.215	0.151	0.151	0.194	0.280	



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

3584HTA

4-margin lands, long (8xD)

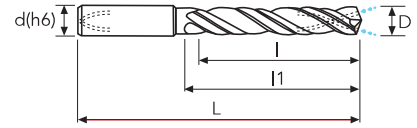


CARBIDE DRILLS

- 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
3.00	+0.012/+0.002	6	32	40	85	358HTA0300	●
3.10	+0.016/+0.004	6	32	40	85	358HTA0310	●
3.20	+0.016/+0.004	6	32	40	85	358HTA0320	●
3.30	+0.016/+0.004	6	32	40	85	358HTA0330	●
3.40	+0.016/+0.004	6	32	40	85	358HTA0340	●
3.50	+0.016/+0.004	6	32	40	85	358HTA0350	●
3.60	+0.016/+0.004	6	36	40	85	358HTA0360	●
3.70	+0.016/+0.004	6	36	40	85	358HTA0370	●
3.80	+0.016/+0.004	6	36	40	85	358HTA0380	●
3.90	+0.016/+0.004	6	36	40	85	358HTA0390	○
4.00	+0.016/+0.004	6	38	46	85	358HTA0400	●
4.10	+0.016/+0.004	6	38	46	85	358HTA0410	●
4.20	+0.016/+0.004	6	38	46	85	358HTA0420	●
4.30	+0.016/+0.004	6	40	46	97	358HTA0430	●
4.40	+0.016/+0.004	6	40	46	97	358HTA0440	○
4.50	+0.016/+0.004	6	44	46	97	358HTA0450	●
4.60	+0.016/+0.004	6	44	46	97	358HTA0460	●
4.70	+0.016/+0.004	6	44	46	97	358HTA0470	●
4.80	+0.016/+0.004	6	44	46	97	358HTA0480	●
4.90	+0.016/+0.004	6	44	46	97	358HTA0490	○
5.00	+0.016/+0.004	6	48	57	97	358HTA0500	●
5.10	+0.016/+0.004	6	48	57	97	358HTA0510	●
5.20	+0.016/+0.004	6	48	57	97	358HTA0520	●
5.30	+0.016/+0.004	6	48	57	97	358HTA0530	●
5.40	+0.016/+0.004	6	48	57	97	358HTA0540	○
5.50	+0.016/+0.004	6	48	57	97	358HTA0550	●
5.60	+0.016/+0.004	6	48	57	97	358HTA0560	●
5.70	+0.016/+0.004	6	48	57	97	358HTA0570	○
5.80	+0.016/+0.004	6	48	57	97	358HTA0580	●
5.90	+0.016/+0.004	6	48	57	97	358HTA0590	●
6.00	+0.016/+0.004	6	48	57	97	358HTA0600	●
6.10	+0.021/+0.006	8	64	76	116	358HTA0610	●
6.20	+0.021/+0.006	8	64	76	116	358HTA0620	●
6.30	+0.021/+0.006	8	64	76	116	358HTA0630	●
6.40	+0.021/+0.006	8	64	76	116	358HTA0640	○
6.50	+0.021/+0.006	8	64	76	116	358HTA0650	●
6.60	+0.021/+0.006	8	64	76	116	358HTA0660	○
6.70	+0.021/+0.006	8	64	76	116	358HTA0670	●
6.80	+0.021/+0.006	8	64	76	116	358HTA0680	●

● stock standard ○ non-standard stock ▽ stock exhaustion

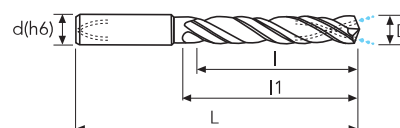
3584HTA

4-margin lands, long (8xD)



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
6.90	+0.021/+0.006	8	64	76	116	358HTA0690	●
7.00	+0.021/+0.006	8	64	76	116	358HTA0700	●
7.10	+0.021/+0.006	8	64	76	116	358HTA0710	●
7.20	+0.021/+0.006	8	64	76	116	358HTA0720	●
7.30	+0.021/+0.006	8	64	76	116	358HTA0730	●
7.40	+0.021/+0.006	8	64	76	116	358HTA0740	●
7.50	+0.021/+0.006	8	64	76	116	358HTA0750	●
7.60	+0.021/+0.006	8	64	76	116	358HTA0760	●
7.70	+0.021/+0.006	8	64	76	116	358HTA0770	○
7.80	+0.021/+0.006	8	64	76	116	358HTA0780	●
7.90	+0.021/+0.006	8	64	76	116	358HTA0790	○
8.00	+0.021/+0.006	8	64	76	116	358HTA0800	●
8.10	+0.021/+0.006	10	80	95	142	358HTA0810	●
8.20	+0.021/+0.006	10	80	95	142	358HTA0820	●
8.30	+0.021/+0.006	10	80	95	142	358HTA0830	●
8.40	+0.021/+0.006	10	80	95	142	358HTA0840	○
8.50	+0.021/+0.006	10	80	95	142	358HTA0850	●
8.60	+0.021/+0.006	10	80	95	142	358HTA0860	●
8.70	+0.021/+0.006	10	80	95	142	358HTA0870	●
8.80	+0.021/+0.006	10	80	95	142	358HTA0880	●
8.90	+0.021/+0.006	10	80	95	142	358HTA0890	○
9.00	+0.021/+0.006	10	80	95	142	358HTA0900	●
9.10	+0.021/+0.006	10	80	95	142	358HTA0910	●
9.20	+0.021/+0.006	10	80	95	142	358HTA0920	●
9.30	+0.021/+0.006	10	80	95	142	358HTA0930	●
9.40	+0.021/+0.006	10	80	95	142	358HTA0940	○
9.50	+0.021/+0.006	10	80	95	142	358HTA0950	●
9.60	+0.021/+0.006	10	80	95	142	358HTA0960	○
9.70	+0.021/+0.006	10	80	95	142	358HTA0970	○
9.80	+0.021/+0.006	10	80	95	142	358HTA0980	●
9.90	+0.021/+0.006	10	80	95	142	358HTA0990	○
10.00	+0.021/+0.006	10	80	95	142	358HTA1000	●
10.20	+0.025/+0.007	12	96	114	163	358HTA1020	●
10.50	+0.025/+0.007	12	96	114	163	358HTA1050	●
10.80	+0.025/+0.007	12	96	114	163	358HTA1080	●
11.00	+0.025/+0.007	12	96	114	163	358HTA1100	●
11.20	+0.025/+0.007	12	96	114	163	358HTA1120	●
11.30	+0.025/+0.007	12	96	114	163	358HTA1130	○
11.50	+0.025/+0.007	12	96	114	163	358HTA1150	●

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

CUTTING PARAMETERS

INFO

3584HTA

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)	100÷120	80÷100	50÷70	40÷60	40÷50	15÷25
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)
3	0.072	0.065	0.058	0.050	0.070	0.042
4	0.089	0.080	0.071	0.062	0.090	0.054
5	0.106	0.095	0.085	0.074	0.100	0.060
6	0.122	0.110	0.098	0.085	0.110	0.066
7	0.139	0.125	0.111	0.097	0.130	0.078
8	0.155	0.140	0.124	0.109	0.150	0.090
9	0.172	0.155	0.138	0.120	0.160	0.096
10	0.188	0.169	0.150	0.132	0.175	0.105
11	0.205	0.185	0.164	0.144	0.180	0.108
12	0.221	0.199	0.177	0.155	0.200	0.120
13	0.238	0.214	0.190	0.167	0.215	0.129
14	0.254	0.229	0.203	0.178	0.230	0.138
15	0.270	0.243	0.216	0.189	0.245	0.147
16	0.286	0.257	0.229	0.200	0.260	0.156

CARBIDE DRILLS

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

Material Group ISO 513	M1	M2	M3		
Hardness/Rm					
Vc (m/min)	40÷50	30÷40	20÷30		
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
3	0.070	0.056	0.049		
4	0.090	0.072	0.063		
5	0.100	0.080	0.070		
6	0.110	0.088	0.077		
7	0.130	0.104	0.091		
8	0.150	0.120	0.105		
9	0.160	0.128	0.112		
10	0.175	0.140	0.123		
11	0.180	0.144	0.126		
12	0.200	0.160	0.140		
13	0.215	0.172	0.151		
14	0.230	0.184	0.161		
15	0.245	0.196	0.172		
16	0.260	0.208	0.182		

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

3584HTA

CARBIDE DRILLS

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

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	50÷70	40÷60		
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
3	0.072	0.065	0.058	0.050		
4	0.089	0.080	0.071	0.062		
5	0.106	0.095	0.085	0.074		
6	0.122	0.110	0.098	0.085		
7	0.139	0.125	0.111	0.097		
8	0.155	0.140	0.124	0.109		
9	0.172	0.155	0.138	0.120		
10	0.188	0.169	0.150	0.132		
11	0.205	0.185	0.164	0.144		
12	0.221	0.199	0.177	0.155		
13	0.238	0.214	0.190	0.167		
14	0.254	0.229	0.203	0.178		
15	0.270	0.243	0.216	0.189		
16	0.286	0.257	0.229	0.200		

HSS DRILLS

- LFTA
- SUTA
- HSS-HSS/CO

Material Group ISO 513	N1 N2	N3	N4			
Hardness/Rm	>5% Si					
Vc (m/min)	160÷200	140÷180	130÷170			
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)			
3	0.086	0.078	0.078			
4	0.107	0.096	0.096			
5	0.127	0.114	0.114			
6	0.146	0.132	0.132			
7	0.167	0.150	0.150			
8	0.186	0.167	0.167			
9	0.206	0.186	0.186			
10	0.226	0.203	0.203			
11	0.246	0.221	0.221			
12	0.265	0.239	0.239			
13	0.286	0.257	0.257			
14	0.305	0.274	0.274			
15	0.324	0.292	0.292			
16	0.343	0.309	0.309			

CARBIDE END-MILLS

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

HSS END-MILLS

CARBIDE BURRS



CUTTING PARAMETERS

3584HTA

Material Group ISO 513	S1 S2	S3	S4	S5		
	<35 HRC		35+45 HRC			
Hardness/Rm						
Vc (m/min)	25+35		15+25		35+45	
D (mm)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)	fn (mm/rev)		
3	0.046	0.032	0.044	0.037		
4	0.055	0.039	0.052	0.044		
5	0.063	0.044	0.060	0.050		
6	0.073	0.051	0.069	0.058		
7	0.080	0.056	0.076	0.064		
8	0.090	0.063	0.086	0.072		
9	0.100	0.070	0.095	0.080		
10	0.110	0.077	0.105	0.088		
11	0.120	0.084	0.114	0.096		
12	0.130	0.091	0.124	0.104		
13	0.137	0.096	0.130	0.110		
14	0.145	0.102	0.138	0.116		
15	0.153	0.107	0.145	0.122		
16	0.160	0.112	0.152	0.128		

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-MILLS

CARBIDE
BURRS