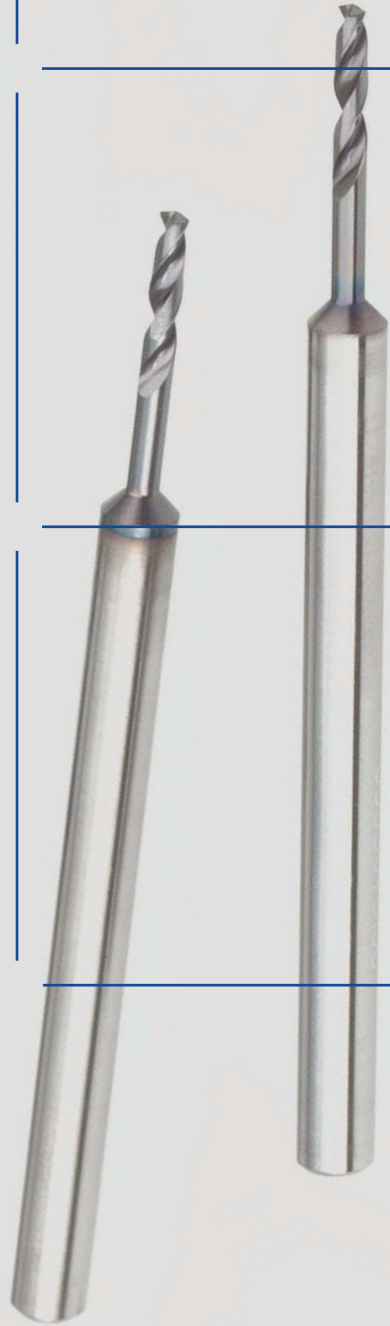


TYPHOON CV

EN

3xD solid carbide drills for general purpose

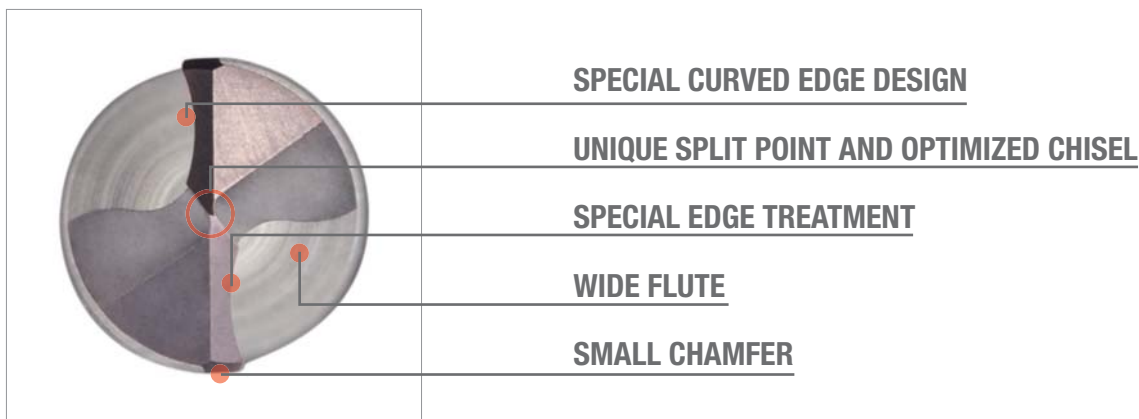
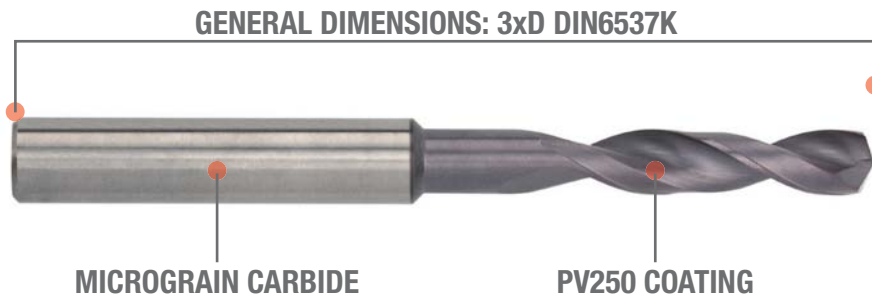


SORMA | ST
SOLID TOOLS - OSAWA

CV

High performance - general purpose

Features of CV drills

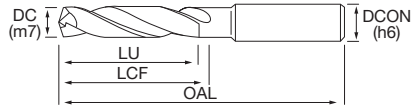


Features and Benefits

- Unique split point: reduces thrust, provides better self centering
- Split gash design: low cutting force and short chips for easier ejection
- Optimized Chisel: long and stable tool life
- Wide flutes by new grinding technology: smooth chips ejection
- Special curved edge design: reduces cutting force
- Small chamfer: reduces corner chipping problem
- Special edge treatment: extends tool life

353CV

• General purpose

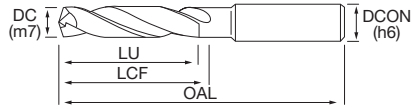


DC	DC tol.	DCON	TCDCON	LU	LCF	OAL	EDP no.	Stock
1	+0.012/+0.002	3	h6	5	7	45	353CV0100	●
1.1	+0.012/+0.002	3	h6	5	7	45	353CV0110	●
1.2	+0.012/+0.002	3	h6	5	7	45	353CV0120	●
1.3	+0.012/+0.002	3	h6	5	7	45	353CV0130	●
1.4	+0.012/+0.002	3	h6	5	7	45	353CV0140	●
1.5	+0.012/+0.002	3	h6	10	13	50	353CV0150	●
1.6	+0.012/+0.002	3	h6	10	13	50	353CV0160	●
1.7	+0.012/+0.002	3	h6	10	13	50	353CV0170	●
1.8	+0.012/+0.002	3	h6	10	13	50	353CV0180	●
1.9	+0.012/+0.002	3	h6	10	13	50	353CV0190	●
2	+0.012/+0.002	4	h6	12	17	55	353CV0200	●
2.1	+0.012/+0.002	4	h6	12	17	55	353CV0210	●
2.2	+0.012/+0.002	4	h6	12	17	55	353CV0220	●
2.3	+0.012/+0.002	4	h6	12	17	55	353CV0230	●
2.4	+0.012/+0.002	4	h6	12	17	55	353CV0240	●
2.5	+0.012/+0.002	4	h6	12	17	55	353CV0250	●
2.6	+0.012/+0.002	4	h6	12	17	55	353CV0260	●
2.7	+0.012/+0.002	4	h6	12	17	55	353CV0270	●
2.8	+0.012/+0.002	4	h6	12	17	55	353CV0280	●
2.9	+0.012/+0.002	4	h6	12	17	55	353CV0290	●
3	+0.012/+0.002	6	h6	14	20	62	353CV0300	●
3.1	+0.016/+0.004	6	h6	14	20	62	353CV0310	●
3.2	+0.016/+0.004	6	h6	14	20	62	353CV0320	●
3.3	+0.016/+0.004	6	h6	14	20	62	353CV0330	●
3.4	+0.016/+0.004	6	h6	14	20	62	353CV0340	●
3.5	+0.016/+0.004	6	h6	14	20	62	353CV0350	●
3.6	+0.016/+0.004	6	h6	14	20	62	353CV0360	●
3.7	+0.016/+0.004	6	h6	14	20	62	353CV0370	●
3.8	+0.016/+0.004	6	h6	17	24	66	353CV0380	●
3.9	+0.016/+0.004	6	h6	17	24	66	353CV0390	●
4	+0.016/+0.004	6	h6	17	24	66	353CV0400	●
4.1	+0.016/+0.004	6	h6	17	24	66	353CV0410	●
4.2	+0.016/+0.004	6	h6	17	24	66	353CV0420	●
4.3	+0.016/+0.004	6	h6	17	24	66	353CV0430	●
4.4	+0.016/+0.004	6	h6	17	24	66	353CV0440	●
4.5	+0.016/+0.004	6	h6	17	24	66	353CV0450	●
4.6	+0.016/+0.004	6	h6	17	24	66	353CV0460	●
4.7	+0.016/+0.004	6	h6	17	24	66	353CV0470	●
4.8	+0.016/+0.004	6	h6	20	28	66	353CV0480	●
4.9	+0.016/+0.004	6	h6	20	28	66	353CV0490	●
5	+0.016/+0.004	6	h6	20	28	66	353CV0500	●
5.1	+0.016/+0.004	6	h6	20	28	66	353CV0510	●
5.2	+0.016/+0.004	6	h6	20	28	66	353CV0520	●
5.3	+0.016/+0.004	6	h6	20	28	66	353CV0530	●
5.4	+0.016/+0.004	6	h6	20	28	66	353CV0540	●

★ 1st choice, ☆ suitable, ● stock standard, ◎ non-stock standard (no MOQ), ○ non-stock standard (MOQ), ▲ upcoming product, ▽ stock exhaustion

353CV

• General purpose



P	M	K	N	S	H
★	☆	☆	☆		

3xD	DIN 6537K		MG PV250		
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DC	DC tol.	DCON	TCDCON	LU	LCF	OAL	EDP no.	Stock
5.5	+0.016/+0.004	6	h6	20	28	66	353CV0550	●
5.6	+0.016/+0.004	6	h6	20	28	66	353CV0560	●
5.7	+0.016/+0.004	6	h6	20	28	66	353CV0570	●
5.8	+0.016/+0.004	6	h6	20	28	66	353CV0580	●
5.9	+0.016/+0.004	6	h6	20	28	66	353CV0590	●
6	+0.016/+0.004	6	h6	20	28	66	353CV0600	●

★ 1st choice, ☆ suitable, ● stock standard, ◎ non-stock standard (no MOQ), ○ non-stock standard (MOQ), ▲ upcoming product, ▽ stock exhaustion

Cutting Parameters

353CV

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÷200 HB	
Vc (m/min)	80÷100	35÷45	35÷45	80÷100	140÷180	
DC (mm)	fn (mm/rev)	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	



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