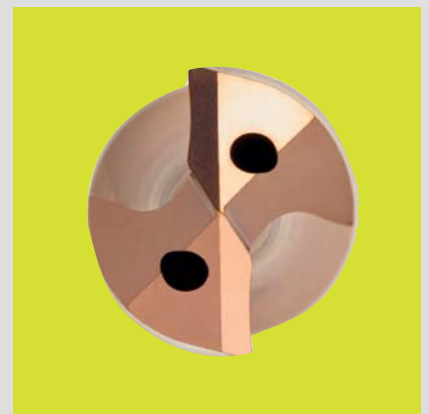
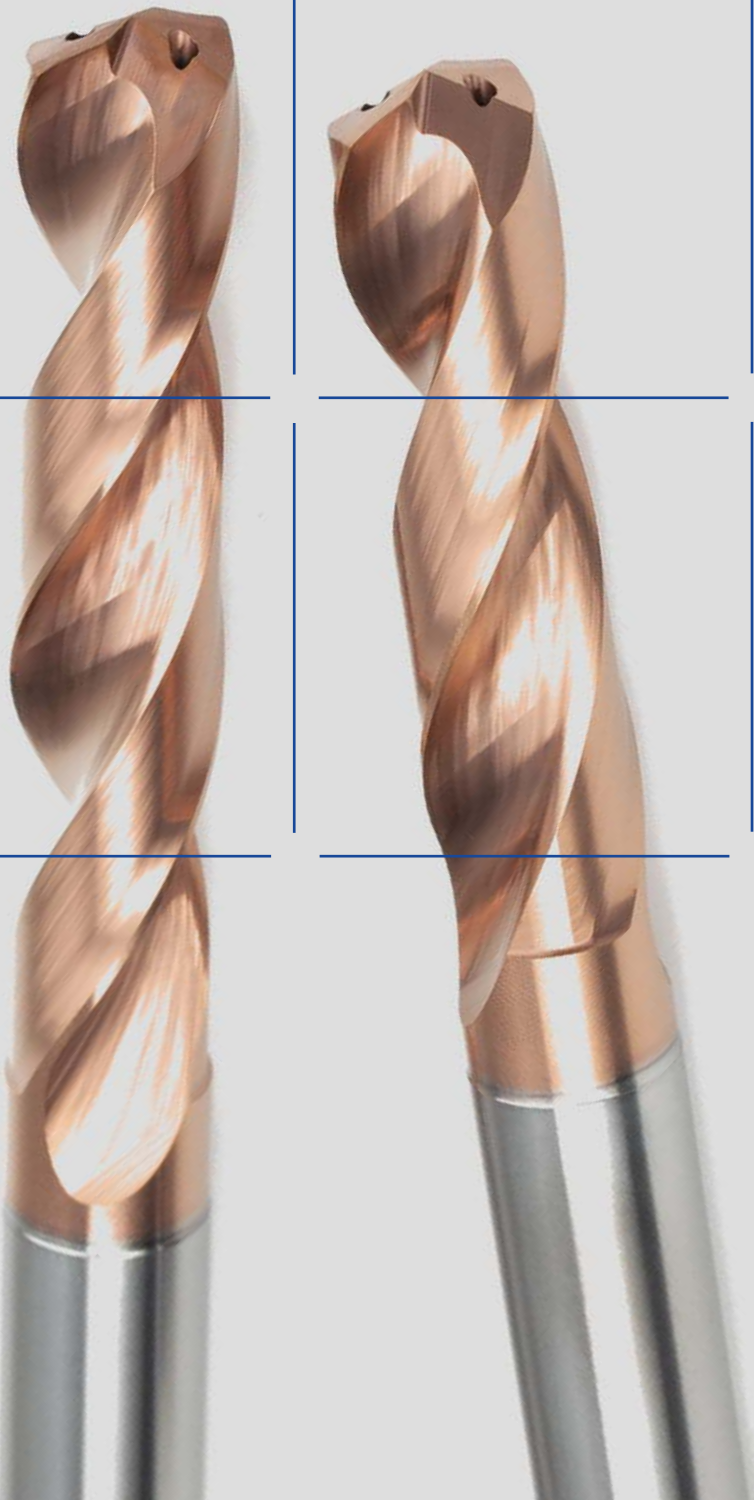


TYPHOON HVA

EN

High performance carbide
drills for stainless steel

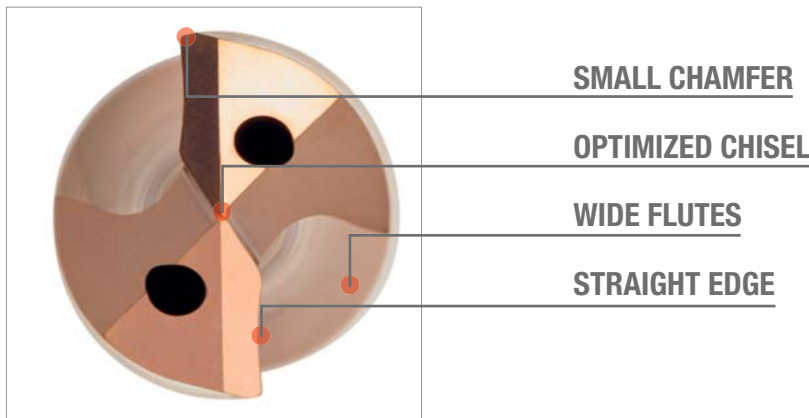
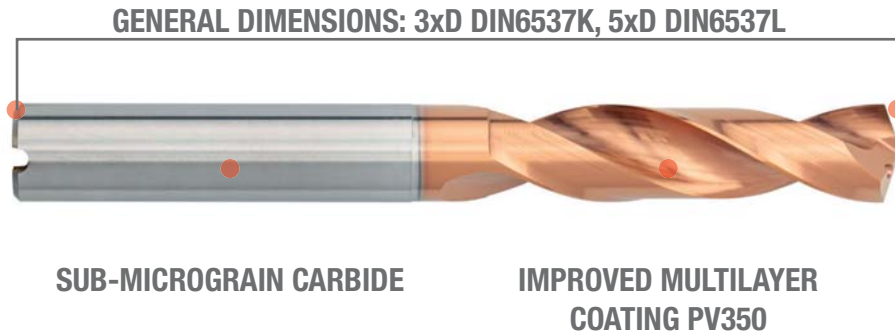


SORMA | ST
SOLID TOOLS - OSAWA

HVA

High performance - stainless steel

Features of HVA drills

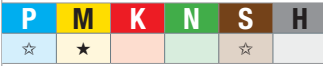
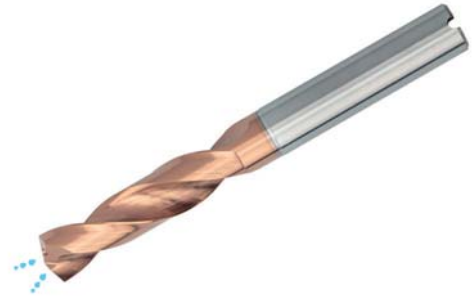
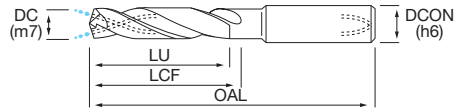


Features and Benefits

- Self-centering geometry: large chisel edge for highly accurate holes
- Straight cutting edge: short chips for easy evacuation and high reliability
- Large back taper geometry: reduces the torque and improves the cutting efficiency
- Chip pocket design: smooth surface to reduce welding and wide space to improve chip ejection
- Substrate: specifically selected sub-micrograin for high wear resistance, long and reliable tool life
- Coating: improved new coating technology for high wear resistance

353HVA

• Stainless steel

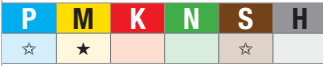
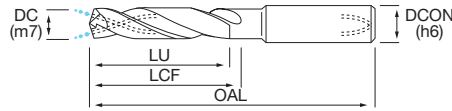


DC	DC tol.	DCON	TCDCON	LU	LCF	OAL	EDP no.	Stock
3	+0.012/+0.002	6	h6	14	20	62	353HVA0300	●
3.1	+0.016/+0.004	6	h6	14	20	62	353HVA0310	●
3.2	+0.016/+0.004	6	h6	14	20	62	353HVA0320	●
3.3	+0.016/+0.004	6	h6	14	20	62	353HVA0330	●
3.4	+0.016/+0.004	6	h6	14	20	62	353HVA0340	●
3.5	+0.016/+0.004	6	h6	14	20	62	353HVA0350	●
3.6	+0.016/+0.004	6	h6	14	20	62	353HVA0360	●
3.7	+0.016/+0.004	6	h6	14	20	62	353HVA0370	●
3.8	+0.016/+0.004	6	h6	17	24	66	353HVA0380	●
3.9	+0.016/+0.004	6	h6	17	24	66	353HVA0390	●
4	+0.016/+0.004	6	h6	17	24	66	353HVA0400	●
4.1	+0.016/+0.004	6	h6	17	24	66	353HVA0410	●
4.2	+0.016/+0.004	6	h6	17	24	66	353HVA0420	●
4.3	+0.016/+0.004	6	h6	17	24	66	353HVA0430	●
4.4	+0.016/+0.004	6	h6	17	24	66	353HVA0440	●
4.5	+0.016/+0.004	6	h6	17	24	66	353HVA0450	●
4.6	+0.016/+0.004	6	h6	17	24	66	353HVA0460	●
4.7	+0.016/+0.004	6	h6	17	24	66	353HVA0470	●
4.8	+0.016/+0.004	6	h6	20	28	66	353HVA0480	●
4.9	+0.016/+0.004	6	h6	20	28	66	353HVA0490	●
5	+0.016/+0.004	6	h6	20	28	66	353HVA0500	●
5.1	+0.016/+0.004	6	h6	20	28	66	353HVA0510	●
5.2	+0.016/+0.004	6	h6	20	28	66	353HVA0520	●
5.3	+0.016/+0.004	6	h6	20	28	66	353HVA0530	●
5.4	+0.016/+0.004	6	h6	20	28	66	353HVA0540	●
5.5	+0.016/+0.004	6	h6	20	28	66	353HVA0550	●
5.6	+0.016/+0.004	6	h6	20	28	66	353HVA0560	●
5.7	+0.016/+0.004	6	h6	20	28	66	353HVA0570	●
5.8	+0.016/+0.004	6	h6	20	28	66	353HVA0580	●
5.9	+0.016/+0.004	6	h6	20	28	66	353HVA0590	●
6	+0.016/+0.004	6	h6	20	28	66	353HVA0600	●
6.1	+0.021/+0.006	8	h6	24	34	79	353HVA0610	●
6.2	+0.021/+0.006	8	h6	24	34	79	353HVA0620	●
6.3	+0.021/+0.006	8	h6	24	34	79	353HVA0630	●
6.4	+0.021/+0.006	8	h6	24	34	79	353HVA0640	●
6.5	+0.021/+0.006	8	h6	24	34	79	353HVA0650	●
6.6	+0.021/+0.006	8	h6	24	34	79	353HVA0660	●
6.7	+0.021/+0.006	8	h6	24	34	79	353HVA0670	●
6.8	+0.021/+0.006	8	h6	24	34	79	353HVA0680	●
6.9	+0.021/+0.006	8	h6	24	34	79	353HVA0690	●
7	+0.021/+0.006	8	h6	24	34	79	353HVA0700	●
7.1	+0.021/+0.006	8	h6	29	41	79	353HVA0710	●
7.2	+0.021/+0.006	8	h6	29	41	79	353HVA0720	●
7.3	+0.021/+0.006	8	h6	29	41	79	353HVA0730	●
7.4	+0.021/+0.006	8	h6	29	41	79	353HVA0740	●

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

353HVA

• Stainless steel

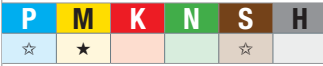
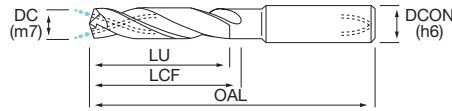


DC	DC tol.	DCON	TCDCON	LU	LCF	OAL	EDP no.	Stock
7.5	+0.021/+0.006	8	h6	29	41	79	353HVA0750	●
7.6	+0.021/+0.006	8	h6	29	41	79	353HVA0760	●
7.7	+0.021/+0.006	8	h6	29	41	79	353HVA0770	●
7.8	+0.021/+0.006	8	h6	29	41	79	353HVA0780	●
7.9	+0.021/+0.006	8	h6	29	41	79	353HVA0790	●
8	+0.021/+0.006	8	h6	29	41	79	353HVA0800	●
8.1	+0.021/+0.006	10	h6	35	47	89	353HVA0810	●
8.2	+0.021/+0.006	10	h6	35	47	89	353HVA0820	●
8.3	+0.021/+0.006	10	h6	35	47	89	353HVA0830	●
8.4	+0.021/+0.006	10	h6	35	47	89	353HVA0840	●
8.5	+0.021/+0.006	10	h6	35	47	89	353HVA0850	●
8.6	+0.021/+0.006	10	h6	35	47	89	353HVA0860	●
8.7	+0.021/+0.006	10	h6	35	47	89	353HVA0870	●
8.8	+0.021/+0.006	10	h6	35	47	89	353HVA0880	●
8.9	+0.021/+0.006	10	h6	35	47	89	353HVA0890	●
9	+0.021/+0.006	10	h6	35	47	89	353HVA0900	●
9.1	+0.021/+0.006	10	h6	35	47	89	353HVA0910	●
9.2	+0.021/+0.006	10	h6	35	47	89	353HVA0920	●
9.3	+0.021/+0.006	10	h6	35	47	89	353HVA0930	●
9.4	+0.021/+0.006	10	h6	35	47	89	353HVA0940	●
9.5	+0.021/+0.006	10	h6	35	47	89	353HVA0950	●
9.6	+0.021/+0.006	10	h6	35	47	89	353HVA0960	●
9.7	+0.021/+0.006	10	h6	35	47	89	353HVA0970	●
9.8	+0.021/+0.006	10	h6	35	47	89	353HVA0980	●
9.9	+0.021/+0.006	10	h6	35	47	89	353HVA0990	●
10	+0.021/+0.006	10	h6	35	47	89	353HVA1000	●
10.1	+0.025/+0.007	12	h6	40	55	102	353HVA1010	●
10.2	+0.025/+0.007	12	h6	40	55	102	353HVA1020	●
10.3	+0.025/+0.007	12	h6	40	55	102	353HVA1030	●
10.4	+0.025/+0.007	12	h6	40	55	102	353HVA1040	●
10.5	+0.025/+0.007	12	h6	40	55	102	353HVA1050	●
10.6	+0.025/+0.007	12	h6	40	55	102	353HVA1060	●
10.7	+0.025/+0.007	12	h6	40	55	102	353HVA1070	●
10.8	+0.025/+0.007	12	h6	40	55	102	353HVA1080	●
10.9	+0.025/+0.007	12	h6	40	55	102	353HVA1090	●
11	+0.025/+0.007	12	h6	40	55	102	353HVA1100	●
11.1	+0.025/+0.007	12	h6	40	55	102	353HVA1110	●
11.2	+0.025/+0.007	12	h6	40	55	102	353HVA1120	●
11.3	+0.025/+0.007	12	h6	40	55	102	353HVA1130	●
11.4	+0.025/+0.007	12	h6	40	55	102	353HVA1140	●
11.5	+0.025/+0.007	12	h6	40	55	102	353HVA1150	●
11.6	+0.025/+0.007	12	h6	40	55	102	353HVA1160	●
11.7	+0.025/+0.007	12	h6	40	55	102	353HVA1170	●
11.8	+0.025/+0.007	12	h6	40	55	102	353HVA1180	●
11.9	+0.025/+0.007	12	h6	40	55	102	353HVA1190	●

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

353HVA

• Stainless steel



DC	DC tol.	DCON	TCDCON	LU	LCF	OAL	EDP no.	Stock
12	+0.025/+0.007	12	h6	40	55	102	353HVA1200	●
12.1	+0.025/+0.007	14	h6	43	60	107	353HVA1210	●
12.2	+0.025/+0.007	14	h6	43	60	107	353HVA1220	●
12.5	+0.025/+0.007	14	h6	43	60	107	353HVA1250	●
12.8	+0.025/+0.007	14	h6	43	60	107	353HVA1280	●
13	+0.025/+0.007	14	h6	43	60	107	353HVA1300	●
13.3	+0.025/+0.007	14	h6	43	60	107	353HVA1330	●
13.5	+0.025/+0.007	14	h6	43	60	107	353HVA1350	●
13.8	+0.025/+0.007	14	h6	43	60	107	353HVA1380	●
14	+0.025/+0.007	14	h6	43	60	107	353HVA1400	●
14.1	+0.025/+0.007	16	h6	45	65	115	353HVA1410	●
14.2	+0.025/+0.007	16	h6	45	65	115	353HVA1420	●
14.5	+0.025/+0.007	16	h6	45	65	115	353HVA1450	●
15	+0.025/+0.007	16	h6	49	65	115	353HVA1500	●
15.3	+0.025/+0.007	16	h6	49	65	115	353HVA1530	●
15.5	+0.025/+0.007	16	h6	49	65	115	353HVA1550	●
15.8	+0.025/+0.007	16	h6	49	65	115	353HVA1580	●
16	+0.025/+0.007	16	h6	49	65	115	353HVA1600	●
16.5	+0.025/+0.007	18	h6	52	73	123	353HVA1650	●
17	+0.025/+0.007	18	h6	52	73	123	353HVA1700	●
17.5	+0.025/+0.007	18	h6	52	73	123	353HVA1750	●
18	+0.025/+0.007	18	h6	52	73	123	353HVA1800	●
18.5	+0.029/+0.008	20	h6	55	79	131	353HVA1850	●
19	+0.029/+0.008	20	h6	55	79	131	353HVA1900	●
19.5	+0.029/+0.008	20	h6	55	79	131	353HVA1950	●
20	+0.029/+0.008	20	h6	55	79	131	353HVA2000	●

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

353HVA

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	<700 N/mm ²
Vc (m/min)	100÷140	80÷120	70÷90	50÷70	50÷70	20÷30
DC (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



Material Group ISO 513	M1	M2	M3			
	Hardness/Rm	<750 N/mm ²	550÷850 N/mm ²	650÷950 N/mm ²		
Vc (m/min)	50÷70	45÷65	35÷50			
DC (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			



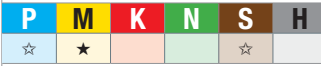
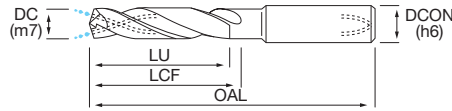
353HVA

Material Group ISO 513	S1 S2		S3	S4	S5		
	<35 N/mm ²		35÷45 N/mm ²				
Vc (m/min)	30÷50		25÷45	30÷45	25÷35		
DC (mm)	fn (mm/rev)	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	0.185	0.155			



355HVA

• Stainless steel

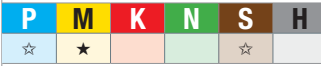
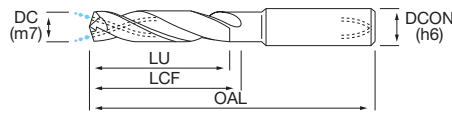


DC	DC tol.	DCON	TCDCON	LU	LCF	OAL	EDP no.	Stock
3	+0.012/+0.002	6	h6	23	28	66	355HVA0300	●
3.1	+0.016/+0.004	6	h6	23	28	66	355HVA0310	●
3.2	+0.016/+0.004	6	h6	23	28	66	355HVA0320	●
3.3	+0.016/+0.004	6	h6	23	28	66	355HVA0330	●
3.4	+0.016/+0.004	6	h6	23	28	66	355HVA0340	●
3.5	+0.016/+0.004	6	h6	23	28	66	355HVA0350	●
3.6	+0.016/+0.004	6	h6	23	28	66	355HVA0360	●
3.7	+0.016/+0.004	6	h6	23	28	66	355HVA0370	●
3.8	+0.016/+0.004	6	h6	29	36	74	355HVA0380	●
3.9	+0.016/+0.004	6	h6	29	36	74	355HVA0390	●
4	+0.016/+0.004	6	h6	29	36	74	355HVA0400	●
4.1	+0.016/+0.004	6	h6	29	36	74	355HVA0410	●
4.2	+0.016/+0.004	6	h6	29	36	74	355HVA0420	●
4.3	+0.016/+0.004	6	h6	29	36	74	355HVA0430	●
4.4	+0.016/+0.004	6	h6	29	36	74	355HVA0440	●
4.5	+0.016/+0.004	6	h6	29	36	74	355HVA0450	●
4.6	+0.016/+0.004	6	h6	29	36	74	355HVA0460	●
4.7	+0.016/+0.004	6	h6	29	36	74	355HVA0470	●
4.8	+0.016/+0.004	6	h6	35	44	82	355HVA0480	●
4.9	+0.016/+0.004	6	h6	35	44	82	355HVA0490	●
5	+0.016/+0.004	6	h6	35	44	82	355HVA0500	●
5.1	+0.016/+0.004	6	h6	35	44	82	355HVA0510	●
5.2	+0.016/+0.004	6	h6	35	44	82	355HVA0520	●
5.3	+0.016/+0.004	6	h6	35	44	82	355HVA0530	●
5.4	+0.016/+0.004	6	h6	35	44	82	355HVA0540	●
5.5	+0.016/+0.004	6	h6	35	44	82	355HVA0550	●
5.6	+0.016/+0.004	6	h6	35	44	82	355HVA0560	●
5.7	+0.016/+0.004	6	h6	35	44	82	355HVA0570	●
5.8	+0.016/+0.004	6	h6	35	44	82	355HVA0580	●
5.9	+0.016/+0.004	6	h6	35	44	82	355HVA0590	●
6	+0.016/+0.004	6	h6	35	44	82	355HVA0600	●
6.1	+0.021/+0.006	8	h6	43	53	91	355HVA0610	●
6.2	+0.021/+0.006	8	h6	43	53	91	355HVA0620	●
6.3	+0.021/+0.006	8	h6	43	53	91	355HVA0630	●
6.4	+0.021/+0.006	8	h6	43	53	91	355HVA0640	●
6.5	+0.021/+0.006	8	h6	43	53	91	355HVA0650	●
6.6	+0.021/+0.006	8	h6	43	53	91	355HVA0660	●
6.7	+0.021/+0.006	8	h6	43	53	91	355HVA0670	●
6.8	+0.021/+0.006	8	h6	43	53	91	355HVA0680	●
6.9	+0.021/+0.006	8	h6	43	53	91	355HVA0690	●
7	+0.021/+0.006	8	h6	43	53	91	355HVA0700	●
7.1	+0.021/+0.006	8	h6	43	53	91	355HVA0710	●
7.2	+0.021/+0.006	8	h6	43	53	91	355HVA0720	●
7.3	+0.021/+0.006	8	h6	43	53	91	355HVA0730	●
7.4	+0.021/+0.006	8	h6	43	53	91	355HVA0740	●

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

355HVA

• Stainless steel

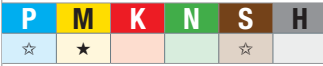
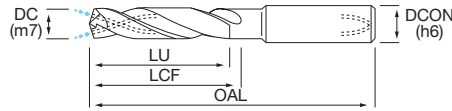


DC	DC tol.	DCON	TCDCON	LU	LCF	OAL	EDP no.	Stock
7.5	+0.021/+0.006	8	h6	43	53	91	355HVA0750	●
7.6	+0.021/+0.006	8	h6	43	53	91	355HVA0760	●
7.7	+0.021/+0.006	8	h6	43	53	91	355HVA0770	●
7.8	+0.021/+0.006	8	h6	43	53	91	355HVA0780	●
7.9	+0.021/+0.006	8	h6	43	53	91	355HVA0790	●
8	+0.021/+0.006	8	h6	43	53	91	355HVA0800	●
8.1	+0.021/+0.006	10	h6	49	61	103	355HVA0810	●
8.2	+0.021/+0.006	10	h6	49	61	103	355HVA0820	●
8.3	+0.021/+0.006	10	h6	49	61	103	355HVA0830	●
8.4	+0.021/+0.006	10	h6	49	61	103	355HVA0840	●
8.5	+0.021/+0.006	10	h6	49	61	103	355HVA0850	●
8.6	+0.021/+0.006	10	h6	49	61	103	355HVA0860	●
8.7	+0.021/+0.006	10	h6	49	61	103	355HVA0870	●
8.8	+0.021/+0.006	10	h6	49	61	103	355HVA0880	●
8.9	+0.021/+0.006	10	h6	49	61	103	355HVA0890	●
9	+0.021/+0.006	10	h6	49	61	103	355HVA0900	●
9.1	+0.021/+0.006	10	h6	49	61	103	355HVA0910	●
9.2	+0.021/+0.006	10	h6	49	61	103	355HVA0920	●
9.3	+0.021/+0.006	10	h6	49	61	103	355HVA0930	●
9.4	+0.021/+0.006	10	h6	49	61	103	355HVA0940	●
9.5	+0.021/+0.006	10	h6	49	61	103	355HVA0950	●
9.6	+0.021/+0.006	10	h6	49	61	103	355HVA0960	●
9.7	+0.021/+0.006	10	h6	49	61	103	355HVA0970	●
9.8	+0.021/+0.006	10	h6	49	61	103	355HVA0980	●
9.9	+0.021/+0.006	10	h6	49	61	103	355HVA0990	●
10	+0.021/+0.006	10	h6	49	61	103	355HVA1000	●
10.1	+0.025/+0.007	12	h6	57	71	118	355HVA1010	●
10.2	+0.025/+0.007	12	h6	57	71	118	355HVA1020	●
10.3	+0.025/+0.007	12	h6	57	71	118	355HVA1030	●
10.4	+0.025/+0.007	12	h6	57	71	118	355HVA1040	●
10.5	+0.025/+0.007	12	h6	57	71	118	355HVA1050	●
10.6	+0.025/+0.007	12	h6	57	71	118	355HVA1060	●
10.7	+0.025/+0.007	12	h6	57	71	118	355HVA1070	●
10.8	+0.025/+0.007	12	h6	57	71	118	355HVA1080	●
10.9	+0.025/+0.007	12	h6	57	71	118	355HVA1090	●
11	+0.025/+0.007	12	h6	57	71	118	355HVA1100	●
11.1	+0.025/+0.007	12	h6	57	71	118	355HVA1110	●
11.2	+0.025/+0.007	12	h6	57	71	118	355HVA1120	●
11.3	+0.025/+0.007	12	h6	57	71	118	355HVA1130	●
11.4	+0.025/+0.007	12	h6	57	71	118	355HVA1140	●
11.5	+0.025/+0.007	12	h6	57	71	118	355HVA1150	●
11.6	+0.025/+0.007	12	h6	57	71	118	355HVA1160	●
11.7	+0.025/+0.007	12	h6	57	71	118	355HVA1170	◎
11.8	+0.025/+0.007	12	h6	57	71	118	355HVA1180	●
11.9	+0.025/+0.007	12	h6	57	71	118	355HVA1190	●

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

355HVA

• Stainless steel



DC	DC tol.	DCON	TCDCON	LU	LCF	OAL	EDP no.	Stock
12	+0.025/+0.007	12	h6	57	71	118	355HVA1200	●
12.1	+0.025/+0.007	14	h6	63	77	124	355HVA1210	●
12.2	+0.025/+0.007	14	h6	63	77	124	355HVA1220	●
12.5	+0.025/+0.007	14	h6	63	77	124	355HVA1250	●
12.8	+0.025/+0.007	14	h6	63	77	124	355HVA1280	●
13	+0.025/+0.007	14	h6	63	77	124	355HVA1300	●
13.3	+0.025/+0.007	14	h6	63	77	124	355HVA1330	●
13.5	+0.025/+0.007	14	h6	63	77	124	355HVA1350	●
13.8	+0.025/+0.007	14	h6	63	77	124	355HVA1380	●
14	+0.025/+0.007	14	h6	63	77	124	355HVA1400	●
14.1	+0.025/+0.007	16	h6	67	83	133	355HVA1410	●
14.2	+0.025/+0.007	16	h6	67	83	133	355HVA1420	●
14.5	+0.025/+0.007	16	h6	67	83	133	355HVA1450	●
15	+0.025/+0.007	16	h6	67	83	133	355HVA1500	●
15.3	+0.025/+0.007	16	h6	67	83	133	355HVA1530	●
15.5	+0.025/+0.007	16	h6	67	83	133	355HVA1550	●
15.8	+0.025/+0.007	16	h6	67	83	133	355HVA1580	●
16	+0.025/+0.007	16	h6	67	83	133	355HVA1600	●
16.5	+0.025/+0.007	18	h6	75	93	143	355HVA1650	●
17	+0.025/+0.007	18	h6	75	93	143	355HVA1700	●
17.5	+0.025/+0.007	18	h6	75	93	143	355HVA1750	●
18	+0.025/+0.007	18	h6	75	93	143	355HVA1800	●
18.5	+0.029/+0.008	20	h6	81	101	153	355HVA1850	●
19	+0.029/+0.008	20	h6	81	101	153	355HVA1900	●
19.5	+0.029/+0.008	20	h6	81	101	153	355HVA1950	●
20	+0.029/+0.008	20	h6	81	101	153	355HVA2000	●

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

355HVA

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	<700 N/mm ²
Vc (m/min)	100÷140	80÷120	70÷90	50÷70	50÷70	20÷30
DC (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



Material Group ISO 513	M1	M2	M3			
	Hardness/Rm	<750 N/mm ²	550÷850 N/mm ²	650÷950 N/mm ²		
Vc (m/min)	50÷70	45÷65	35÷50			
DC (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			



355HVA

Material Group ISO 513	S1 S2		S3	S4	S5		
	<35 N/mm ²		35÷45 N/mm ²				
Vc (m/min)	30÷50		25÷45	30÷45	25÷35		
DC (mm)	fn (mm/rev)	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			





Sorma S.p.A. Socio Unico / Via Don F. Tosatto, 8 / 30174 Mestre - Venezia
+39 041.959179 / cuttingsolutions@sorma.net

www.sorma.net