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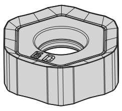
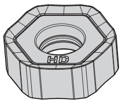
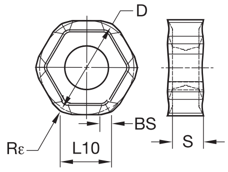

HNPJ-GD


HNPJ-HD



● first choice
○ alternate choice

	TN6510	TN6520	TN6525	TN6540	TN7535	WK15CM	WP25PM	WP35CM	WS30PM	WP40PM
P			●	●	●		●	●		●
M			○	●	○		●	●	○	●
K	●	●	○	○	○	●	○			
N										
S				●			●	●	●	○
H							○			

■ HNPJ-GD

catalogue number	cutting edges	D	L10	S	BS	Rε	hm	TN6510	TN6520	TN6525	TN6540	TN7535	WK15CM	WP25PM	WP35CM	WS30PM	WP40PM
HNPJ0704ANSNGD	12	13	6,80	4,45	1,27	1,20	0,10	3954432	3954473	-	3954474	3954475	5427374	5895293	5895294	5528976	5550906

■ HNPJ-HD

catalogue number	cutting edges	D	L10	S	BS	Rε	hm	TN6510	TN6520	TN6525	TN6540	TN7535	WK15CM	WP25PM	WP35CM	WS30PM	WP40PM
HNPJ0704ANSNHD	12	13	6,80	4,41	1,25	1,20	0,14	3954477	3954478	-	3954479	3954480	5427375	5895295	5895296	-	5550907
HNPJ070432ANSNHD	12	13	6,80	4,42	—	3,20	0,14	3954481	3954482	-	3954483	3954484	-	-	-	-	5895297

Recommended Starting Speeds

■ Recommended Starting Speeds [m/min]

Material Group		TN6510			TN6520			TN6525			TN6540			TN7535			WK15CM		
P	1	–	**–**	–	–	**–**	–	410	**320**	280	360	**280**	240	545	**475**	445	–	**–**	–
	2	–	**–**	–	–	**–**	–	320	**250**	215	250	**190**	170	335	**305**	275	–	**–**	–
	3	–	**–**	–	–	**–**	–	280	**215**	185	215	**170**	140	305	**275**	245	–	**–**	–
	4	–	**–**	–	–	**–**	–	235	**170**	145	180	**130**	110	230	**210**	190	–	**–**	–
	5	–	**–**	–	–	**–**	–	310	**235**	200	240	**180**	150	310	**275**	250	–	**–**	–
	6	–	**–**	–	–	**–**	–	205	**160**	130	160	**120**	100	190	**160**	130	–	**–**	–
M	1	–	**–**	–	–	**–**	–	190	**120**	80	130	**80**	60	245	**220**	185	–	**–**	–
	2	–	**–**	–	–	**–**	–	120	**80**	50	80	**50**	40	220	**190**	170	–	**–**	–
	3	–	**–**	–	–	**–**	–	125	**80**	55	85	**50**	40	175	**155**	140	–	**–**	–
K	1	480	**350**	260	450	**320**	230	275	**245**	220	220	**205**	180	355	**320**	290	505	**460**	410
	2	420	**280**	205	390	**250**	190	215	**190**	180	175	**155**	140	280	**250**	230	400	**355**	330
	3	335	**260**	200	300	**230**	160	180	**160**	145	155	**145**	125	235	**210**	190	335	**300**	275
N	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
S	1	–	**–**	–	–	**–**	–	–	**–**	–	50	**35**	30	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	25	**20**	10	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	70	**40**	30	–	**–**	–	–	**–**	–
	4	–	**–**	–	–	**–**	–	–	**–**	–	60	**30**	25	–	**–**	–	–	**–**	–
H	1	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

(continued)

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