


CUTTING CONDITIONS

Milling | Indexables | Cutting conditions


PXDR-P

Corner radius type L/D≤5

	Mild steel - Carbon steel Cast iron SS400 · S55C · FC250 ~750 N/mm2		Alloy steel Tool steel SCM · SKT · SKS · SKD ~30 HRC		Stainless steel Hardened steel SUS304S · SKD ~45 HRC		Hardened steel 45~55 HRC										
	Ø	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)								
	10	4.770	3.580	4.770	2.860	4.770	2.150	4.770	1.430								
	12	3.980	2.980	3.980	2.390	3.980	1.790	3.980	1.190								
	16	2.980	2.240	2.980	1.790	2.980	1.340	2.980	900								
	20	2.390	1.790	2.390	1.430	2.390	1.070	2.390	720								
Max cutting depth	<table><tr><td>ap</td><td>ae</td></tr><tr><td>0,05 D</td><td>0,25 D</td></tr></table>							ap	ae	0,05 D	0,25 D	<table><tr><td>ap</td><td>ae</td></tr><tr><td>0,03 D</td><td>0,25 D</td></tr></table>		ap	ae	0,03 D	0,25 D
								ap	ae								
								0,05 D	0,25 D								
ap	ae																
0,03 D	0,25 D																

PXDR-N

Corner radius type L/D≤5

	Alloy steel Tool steel SCM · SKT · SKS · SKD ~30 HRC		Stainless steel Hardened steel SUS304S · SKD ~45 HRC		Hardened steel SUS304S · SKD 45~55 HRC		Hardened steel 55~60 HRC										
	Ø	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)	S (min ⁻¹)	F (mm/min)								
	10	4.770	3.580	3.820	2.290	3.180	1.150	3.180	950								
	12	3.980	2.980	3.180	1.910	2.650	950	2.650	800								
	16	2.980	2.240	2.390	1.430	1.990	720	1.990	600								
	20	2.390	1.790	1.910	1.150	1.590	570	1.590	480								
Max cutting depth																	
	<table><tr><td>ap</td><td>ae</td></tr><tr><td>0,03 D</td><td>0,25 D</td></tr></table>							ap	ae	0,03 D	0,25 D	<table><tr><td>ap</td><td>ae</td></tr><tr><td>0,02 D</td><td>0,2 D</td></tr></table>		ap	ae	0,02 D	0,2 D
	ap	ae															
0,03 D	0,25 D																
ap	ae																
0,02 D	0,2 D																