



List 78PXRE: PXRE Exchangeable Heads

Contouring

Hardness		-		Up to 30 HRC		30-45 HRC		45-55 HRC		55-60 HRC	
Work Material		Mild Steels Carbon Steels Cast Iron		Alloy Steels Tool Steels		Hardened Steels Pre-hardened Steels		Hardened Steels		Hardened Steels	
Depth of Cut		$Aa=0.1r \cdot Ar=0.3Dc$									
Mill Dia.											
(in)	(mm)										
3/8	-	6695	529.65	5045	322.77	4100	248.33	3465	169.49	2940	111.61
-	10	6370	503.94	4800	307.10	3900	236.22	3300	161.42	2800	106.30
-	12	5800	417.32	4000	255.91	3200	192.91	2700	129.92	2300	86.61
1/2	-	5475	393.65	3780	241.92	3020	182.11	2535	121.93	2170	81.59
5/8	-	4035	472.50	3025	305.53	2415	233.77	2030	155.90	1735	108.44
-	16	4000	468.50	3000	303.15	2400	232.28	2000	153.54	1700	106.30
3/4	-	3360	394.80	2520	268.63	2010	204.02	1690	137.23	1445	89.45
-	20	3200	375.98	2400	255.91	1900	192.91	1600	129.92	1400	86.61
-	25	2560	294.40	1920	192.00	1535	145.80	1280	102.40	1100	68.75
1	-	2520	289.80	1890	189.00	1510	143.45	1260	100.80	1090	67.50

- Cutting conditions shown above are for contouring with $L/D \leq 3.5xD$.
- Adjust/reduce the cutting conditions when the overhang length is longer than $3.5xD$.

List 78PXDR: PXDR-P Exchangeable Heads

Contouring

Hardness		-		Up to 30 HRC		30-45 HRC		45-55 HRC		
Work Material		Mild Steels Carbon Steels Cast Iron		Alloy Steels Tool Steels		Stainless Steels Hardened Steels		Hardened Steels		
Depth of Cut		$Aa=0.05r \cdot Ar=0.25Dc$							$Aa=0.03r \cdot Ar=0.25Dc$	
Mill Dia.										
(in)	(mm)									
3/8	-	5010	148.00	5010	118.26	5010	88.90	5010	59.13	
-	10	4770	140.95	4770	112.60	4770	84.65	4770	56.30	
-	12	3980	117.32	3980	94.10	3980	70.47	3980	46.85	
1/2	-	3780	111.60	3780	89.30	3780	66.97	3780	44.65	
5/8	-	3025	89.32	3025	74.45	3025	53.59	3025	35.73	
-	16	2980	88.19	2980	70.47	2980	52.75	2980	35.43	
3/4	-	2520	74.40	2520	59.53	2520	44.65	2520	29.76	
-	20	2390	70.47	2390	56.30	2390	42.12	2390	28.35	
-	25	1920	56.64	1920	45.12	1920	33.98	1920	22.46	
1	-	1890	55.75	1890	44.41	1890	33.45	1890	22.11	


- Cutting conditions shown above are for contouring with $L/D \leq 5xD$.
- Adjust/reduce the cutting conditions when the overhang length is longer than $5xD$.





List 78PXDR: PXDR-N Exchangeable Heads

Contouring

Hardness	Up to 30 HRC		30-45 HRC		45-55 HRC		55-60 HRC		
Work Material	Alloy Steels Tool Steels		Stainless Steels Hardened Steels		Hardened Steels		Hardened Steels		
Depth of Cut 	Aa=0.03r • Ar=0.25Dc						Aa=0.02r • Ar=0.2Dc		
Mill Dia.		Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)
(in)	(mm)								
3/8	-	5010	148.00	4010	94.64	3340	47.56	3340	39.28
-	10	4770	140.95	3820	90.16	3180	45.28	3180	37.40
-	12	3980	117.32	3180	75.20	2650	37.40	2650	31.50
1/2	-	3780	111.60	3020	71.34	2520	34.72	2520	29.76
5/8	-	3025	89.32	2415	57.05	2015	28.56	2015	23.80
-	16	2980	88.19	2390	56.30	1990	28.35	1990	23.62
3/4	-	2520	74.40	2010	47.48	1680	23.15	1680	19.84
-	20	2390	70.47	1910	45.27	1590	22.44	1590	18.90
-	25	1920	56.64	1535	36.07	1275	17.85	1275	15.05
1	-	1890	55.75	1500	35.25	1250	17.50	1250	14.75

1. Cutting conditions shown above are for contouring with $L/D \leq 5xD$.
2. Adjust/reduce the cutting conditions when the overhang length is longer than $5xD$.

