




List 78PXNL: PXNL Exchangeable Heads

List 78PXNL-O: PXNL-O Exchangeable Heads

List 78PXNH: PXNH Exchangeable Heads


List 78PXNH-O: PXNH-O Exchangeable Heads

Side Milling

Work Material		Cast Iron		Carbon Steels		Alloy Steels		Hardened Steels Pre-hardened Steels		Stainless Steels	
Depth of Cut 		Aa=0.5Dc • Ar=0.3Dc				Aa=0.5Dc • 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)	Speed (RPM)	Feed (in/min)
(in)	(mm)										
3/8	-	3000	29.74	4010	34.71	3340	21.50	3000	14.45	2680	11.56
-	10	2860	28.35	3820	33.07	3180	20.47	2860	13.78	2550	11.00
-	12	2390	23.62	3180	27.56	2650	17.32	2390	11.42	2120	9.06
1/2	-	2255	22.32	3000	26.10	2500	16.25	2255	10.82	2000	8.60
5/8	-	1800	24.48	2400	28.56	2000	17.80	1800	11.88	1600	9.44
-	16	1790	24.41	2390	28.35	1990	17.72	1790	11.81	1590	9.45
3/4	-	1500	27.30	2000	31.40	1670	19.87	1500	12.75	1335	10.28
-	20	1430	25.98	1910	29.92	1590	18.90	1430	12.20	1270	9.84
-	25	890	17.72	1270	22.05	1020	13.38	890	8.66	760	6.69
1	-	875	17.41	1250	21.75	1000	13.10	875	8.49	745	6.56

- Cutting conditions shown above are for side milling with L/D ≤ 3.5xD.
- Adjust/reduce the cutting conditions when the overhang length is longer than 3.5xD.
- For side milling with PXMC Extra-Short Collet, increase Speed by 20-80% and Feed by 20-100%.
- For side milling with PXMC Short Collet, increase Speed by 30-50% and Feed by 10-80%.

Slotting

Work Material		Cast Iron		Carbon Steels		Alloy Steels		Hardened Steels Pre-hardened Steels		Stainless Steels	
Depth of Cut 		Aa=0.5Dc									
Mill Dia.		Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)
(in)	(mm)										
3/8	-	2345	14.90	3340	18.61	2680	11.17	2345	7.05	2000	5.36
-	10	2230	14.17	3180	17.72	2550	10.63	2230	6.70	1910	5.12
-	12	1860	11.81	2650	14.57	2120	8.66	1860	5.51	1590	4.33
1/2	-	1750	11.03	2505	13.78	2000	8.20	1750	5.08	1500	4.05
5/8	-	1400	12.74	2005	15.84	1600	9.44	1400	5.88	1200	4.80
-	16	1390	12.60	1990	15.75	1590	9.45	1390	5.91	1190	4.72
3/4	-	1165	14.91	1670	18.54	1335	11.21	1165	6.99	1000	5.40
-	20	1110	14.17	1590	17.72	1270	10.63	1110	6.69	950	5.12
-	25	760	11.02	1150	14.57	890	8.27	760	5.12	640	3.94
1	-	745	10.80	1130	14.35	875	8.14	745	4.99	630	3.84

- Cutting conditions shown above are for slotting with L/D ≤ 3.5xD.
- Adjust/reduce the cutting conditions when the overhang length is longer than 3.5xD.
- For slotting with PXMC Extra-Short Collet, increase Speed by 20-80% and Feed by 50-250%.
- For slotting with PXMC Short Collet, increase Speed by 20-50% and Feed by 30-200%.

