




List 78PXSM: PXSM Exchangeable Heads

Side Milling

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 Titanium Alloys		Heat Resistant Alloys Inconel	
Depth of Cut 		Aa≤0.5Dc • Ar≤0.05Dc				Aa≤0.5Dc • Ar≤0.02Dc		Aa≤0.3Dc • Ar≤0.02Dc			
Mill Dia.		Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
(in)	(mm)	(RPM)	(in/min)	(RPM)	(in/min)	(RPM)	(in/min)	(RPM)	(in/min)	(RPM)	(in/min)
3/8	-	6020	91.36	5020	59.55	4010	47.53	3350	39.70	2000	17.32
-	10	5730	81.50	4780	56.70	3820	45.28	3190	37.80	1910	16.54
-	12	4750	68.90	3950	45.28	3150	37.40	2650	31.50	1550	13.78
1/2	-	4485	65.03	3725	42.84	2980	35.16	2500	29.75	1450	12.91
5/8 (6F)	-	3590	52.06	2970	34.16	2385	28.38	1955	23.66	1160	10.32
5/8 (8F)	-	3590	69.65	2970	45.44	2385	37.92	1955	31.67	1160	13.92
-	16 (6F)	3550	51.57	2950	33.86	2350	27.95	1950	23.62	1150	10.24
-	16 (8F)	3550	68.90	2950	45.28	2350	37.40	1950	31.50	1150	13.78
3/4	-	2990	71.76	2475	47.52	1985	39.10	1630	33.09	995	14.43
-	20	2850	68.90	2350	45.28	1900	37.40	1550	31.50	950	13.78
-	25	2280	55.12	1880	36.22	1520	29.92	1240	25.20	760	11.02
1	-	2240	54.21	1855	35.80	1490	29.35	1220	24.77	745	10.80

- 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.

