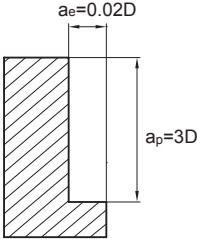
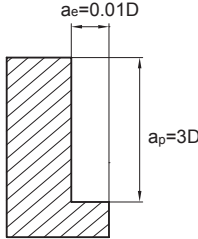


PML-4F-G★PM-4F-G★PML-4FL-G★PM-4FL-G(high speed side milling)

Workpiece material	Cast iron, Carbon steel, Alloy steel ~30HRC		Carbon steel, Alloy steel ~40HRC		Pre-hardened steel, quenched and tempered steel ~45HRC		Pre-hardened steel, quenched and tempered steel ~50HRC		Hardened steel ~55HRC		
Cutting speed	300m/min		250 m/min		200 m/min		150 m/min		100 m/min		
Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	
6	15915	1075	13260	900	10600	715	7960	535	5300	360	
8	11935	1070	9950	885	7960	715	5970	535	3980	360	
10	9550	1015	7960	870	6370	700	4775	525	3180	345	
12	7960	1015	6630	870	5300	700	3980	525	2650	345	
14	6820	975	5685	815	4550	650	3410	570	2275	325	
16	5970	975	4975	815	3980	650	2985	570	1990	325	
18	5305	975	4420	815	3540	650	2650	570	1770	325	
20	4775	975	3980	815	3180	650	2390	570	1590	325	
Maximum cutting depth											

1. Please select high-precision machine and tool holder.
2. Please use air blow or MQL(minimum oil mist cooling).
3. Down milling is recommended in the case of side milling.
4. When the machine rigidity and workpiece fixture stability is low, vibration and abnormal noise may be generated. Please reduce the rotating speed and feed speed stated above correspondingly.
5. Make overhang of tool as short as possible in conditions of non-interference.

PML-4EX-G★PM-4EX-G

Workpiece material	Cast iron, Carbon steel, Alloy steel ~30HRC		Stainless steel		Pre-hardened steel, quenched and tempered steel ~40HRC		Pre-hardened steel, quenched and tempered steel ~50HRC		Hardened steel ~55HRC		
	Diameter (mm)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)	Rotating speed (min ⁻¹)	Feed speed (mm/min)
6	5800	570	2650	85	4250	410	3600	345	3180	305	
8	4400	570	2000	85	3180	410	2700	350	2390	310	
10	3500	555	1600	85	2550	400	2150	340	1910	300	
12	2900	555	1350	85	2120	400	1800	340	1590	300	
16	2200	520	1000	80	1590	380	1350	315	1195	280	
20	1750	510	800	75	1270	375	1050	310	955	280	
Maximum cutting depth											

1. Please select high-precision machine and tool holder.
2. Please use air blow or cutting liquid with high mist retardant property.
3. Down milling is recommended in the case of side milling.
4. When the machine rigidity and workpiece fixture stability is low, vibration and abnormal noise may be generated. Please reduce the rotating speed and feed speed stated above correspondingly.
5. Make overhang of tool as short as possible in conditions of non-interference.