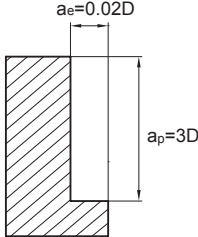
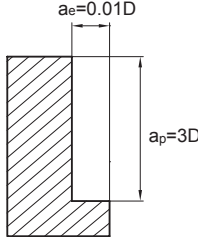


PML-6E★PM-6E

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	7000	1070	3700	195	5300	815	4200	650	3710	470	
8	5200	1070	2800	195	4000	815	3200	660	2785	485	
10	4200	1035	2200	195	3200	800	2500	630	2230	450	
12	3500	1035	1850	195	2650	800	2100	630	1855	450	
16	2600	975	1400	180	2000	750	1600	590	1390	435	
20	2050	960	1100	150	1600	740	1250	580	1115	420	
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.

PML-6EL★PM-6EL

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	900	2650	140	4250	655	3600	555	3180	490	
8	4400	900	2000	140	3180	655	2700	560	2390	495	
10	3500	875	1600	140	2550	635	2150	530	1910	470	
12	2900	875	1350	140	2120	635	1800	530	1590	470	
16	2200	825	1000	125	1590	600	1350	500	1195	445	
20	1750	810	800	110	1270	590	1050	495	955	440	
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.