

### PML-4B★PM-4B★PML-4BL★PM-4BL/M/X

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 <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)	Rotating speed (min <sup>-1</sup> )	Feed speed (mm/min)
<b>R1.5</b>		15500	2055	7400	625	10600	975	8500	600	7430	525
<b>R2.0</b>		11500	2055	5550	795	8000	1190	6500	800	5570	685
<b>R2.5</b>		9500	2270	4450	795	6400	1190	5000	810	4455	720
<b>R3.0</b>		8000	2270	3700	840	5300	1245	4200	840	3715	745
<b>R4.0</b>		6000	2810	2750	985	4000	1515	3200	950	2785	825
<b>R5.0</b>		4800	2595	2200	925	3200	1405	2500	950	2230	825
<b>R6.0</b>		4000	2375	1850	925	2650	1320	2100	905	1855	800
<b>R8.0</b>		3000	2270	1350	815	2000	1295	1600	810	1395	705
<b>R10.0</b>		2400	2055	1100	795	1600	1200	1250	715	1115	640
Maximum cutting depth	<p>The diagram illustrates the maximum cutting depth parameters for the end mill. It shows a cross-section of the tool with a scalloped cutting edge. The axial cutting depth is labeled as <math>a_e = 0.2R</math>, and the radial cutting depth is labeled as <math>a_p = 0.1R</math>.</p>										

1. Please select high-precision machine and tool holder.
2. Please use air blow or cutting liquid with high mist retardant property.
3. 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.
4. Make overhang of tool as short as possible in conditions of non-interference.