



**List 78PXBE:** PXBE-P & PXBE-P-O Exchangeable Heads

Contouring

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	
Depth of Cut		$\leq \varnothing 0.500: Aa=0.07Dc \cdot Ar=0.15Dc$ $\geq \varnothing 0.625: Aa=0.10Dc \cdot Ar=0.15Dc$						$\leq \varnothing 0.500: Aa=0.05Dc \cdot Ar=0.1Dc$ $\geq \varnothing 0.625: Aa=0.03Dc \cdot Ar=0.1Dc$	
Mill Dia.		Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)	Speed (RPM)	Feed (in/min)
(in)	(mm)								
3/8	-	5010	88.90	4010	71.10	3340	59.13	3340	39.28
-	10	4770	84.65	3820	67.72	3180	56.30	3180	37.40
-	12	3980	70.47	3180	56.30	2650	46.85	2650	31.50
1/2	-	3780	66.97	3020	53.50	2520	44.65	2520	29.76
5/8	-	3025	53.60	2415	42.78	2015	35.70	2015	23.80
-	16	2980	52.75	2390	42.12	1990	35.43	1990	23.62
3/4	-	2520	44.65	2010	35.61	1680	29.76	1680	19.84
-	20	2390	42.12	1910	33.86	1590	28.35	1590	18.90
-	25	1920	33.98	1535	27.17	1275	22.57	1275	15.05
1	-	1890	33.45	1500	26.55	1250	22.12	1250	14.75

- Cutting conditions shown above are for contouring with L/D  $\leq$  5xD.
- Adjust/reduce the cutting conditions when the overhang length is longer than 5xD.

**List 78PXBE:** PXBE-N Exchangeable Heads

**List 78PXBE-O:** PXBE-N-O Exchangeable Heads

Contouring

Hardness				Up to 30 HRC		30-45 HRC		45-55 HRC		55-60 HRC	
Work Material		Mild Steels Carbon Steels Cast Iron		Alloy Steels Tool Steels		Hardened Steels Pre-hardened Steels		Hardened Steels		Hardened Steels	
Depth of Cut		$\leq \varnothing 0.500: Aa=0.07Dc \cdot Ar=0.15Dc$ $\geq \varnothing 0.625: Aa=0.05Dc \cdot Ar=0.15Dc$						$\leq \varnothing 0.500: Aa=0.05Dc \cdot Ar=0.1Dc$ $\geq \varnothing 0.625: Aa=0.03Dc \cdot Ar=0.1Dc$		$Aa=0.03Dc \cdot Ar=0.05Dc$	
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	-	8360	148.00	8360	148.00	6695	94.76	5010	59.13	3340	19.85
-	10	7960	140.95	7960	140.95	6370	90.16	4770	56.30	3180	18.90
-	12	6600	116.14	6600	116.14	5300	74.80	3950	45.27	2600	15.75
1/2	-	6235	109.74	6235	109.74	4970	70.08	3715	42.72	2230	13.38
5/8	-	4990	89.32	4990	89.32	3975	57.24	2970	35.64	1925	11.94
-	16	4950	88.58	4950	88.58	3950	57.09	2950	35.43	1900	11.81
3/4	-	4155	72.30	4155	72.30	3310	47.66	2475	31.19	1680	10.25
-	20	3950	68.90	3950	68.90	3150	45.27	2350	29.53	1600	9.84
-	25	3160	55.30	3160	55.30	2520	36.29	1880	23.50	1280	7.68
1	-	3110	54.42	3110	54.42	2485	35.78	1850	23.12	1260	7.56

- Cutting conditions shown above are for contouring with L/D  $\leq$  3.5xD.
- Adjust/reduce the cutting conditions when the overhang length is longer than 3.5xD.

