





List 78PXVC: PXVC 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	
Depth of Cut 		Aa=0.5Dc • Ar=0.2Dc				Aa=0.5Dc • Ar=0.1Dc		Aa=0.5Dc • 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)
(in)	(mm)								
3/8	-	5020	47.50	4010	38.00	3350	31.80	2680	25.65
-	10	4780	45.28	3820	36.22	3190	30.31	2550	24.41
-	12	3980	37.80	3190	30.31	2660	25.20	2130	20.47
1/2	-	3780	35.83	3020	28.63	2520	23.90	2010	19.30
-	14	3420	32.68	2730	25.98	2280	21.65	1820	17.32
5/8	-	3025	28.67	2410	22.85	2015	19.10	1610	15.46
-	16	2990	28.35	2390	22.83	1990	18.90	1600	15.35
-	18	2660	25.20	2130	20.47	1770	16.93	1420	13.78
3/4	-	2520	23.90	2010	19.05	1680	15.93	1340	12.86
-	20	2390	22.83	1910	18.11	1600	15.35	1280	12.20
-	22	2180	20.87	1740	16.54	1450	13.78	1160	11.00
-	25	1910	18.11	1530	14.57	1280	12.20	1020	9.84
1	-	1890	17.92	1510	14.31	1260	11.95	1000	9.60
1 1/4 (5F)	-	1515	15.10	1210	9.53	1010	9.94	805	6.34
1 1/4 (8F)	-	1515	19.09	1210	15.48	1010	12.73	805	10.30
-	32 (5F)	1500	14.96	1200	9.45	1000	9.84	800	6.30
-	32 (8F)	1500	18.90	1200	15.35	1000	12.60	800	10.24

- Cutting conditions shown above are for side milling with L/D ≤ 5xD
- For side milling with 5xD < L/D ≤ 6xD, reduce Speed and Feed by 10%
- For side milling with 6xD < L/D ≤ 7xD, reduce Speed & Feed by 20%
- For side milling with PXMC Extra-Short Collet, increase Speed by 30-40% and Feed by 40-80%
- For side milling with PXMC Short Collet, increase Speed by 10-20% and Feed by 20-30%

Slotting

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 		Aa≤0.5Dc		Aa≤0.4Dc		Aa≤0.3Dc			
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	-	5020	39.70	4010	31.82	3340	26.47	2510	19.85
-	10	4780	37.80	3820	30.31	3180	25.20	2390	18.90
-	12	3980	31.50	3180	25.20	2650	20.87	1990	15.75
1/2	-	3760	29.61	3010	23.70	2505	19.72	1870	14.72
-	14	3410	26.77	2730	21.65	2270	17.72	1710	13.38
5/8	-	3010	23.70	2410	18.98	2005	15.79	1500	11.81
-	16	2980	23.62	2390	18.90	1990	15.75	1490	11.81
-	18	2650	20.87	2120	16.53	1770	13.78	1330	10.63
3/4	-	2505	19.72	2010	15.83	1670	13.15	1250	9.84
-	20	2390	18.90	1910	14.96	1590	12.60	1190	9.45
-	22	2170	16.93	1740	13.78	1450	11.42	1090	8.66
-	25	1910	14.96	1530	12.20	1270	9.84	950	7.48
1	-	1880	14.80	1505	11.85	1250	9.70	935	7.36

- Cutting conditions shown above are for slotting with L/D ≤ 5xD.
- For slotting with 5xD < L/D ≤ 6xD, reduce Speed and Feed by 20%.
- For slotting with 6xD < L/D ≤ 7xD, reduce Speed & Feed by 35%.
- For slotting with PXMC Extra-Short Collet, increase Speed by 10-20% and Feed by 10-50%.
- For slotting with PXMC Short Collet, increase Feed by 15-30%.
- Slotting with Ø1 1/4" or Ø32mm PXVC is not recommended due to the large number of flutes.

