


# CUTTING CONDITIONS

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## PXBE-P

Ball nose type    L/D≤5

	Mild steel - Carbon steel Cast iron SS400 · S55C · FC250 ~750 N/mm2		Alloy steel Tool steel SCM · SKT · SKS · SKD ~30 HRC		Stainless steel Hardened steel SUS304S · SKD ~45 HRC		Hardened steel Titanium alloy steel (wet) Ti-6Al-4V 45~55 HRC		
	Ø	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)
	10	4.770	2.150	3.820	1.720	3.180	1.430	3.180	950
	12	3.980	1.790	3.180	1.430	2.650	1.190	2.650	800
	16	2.980	1.340	2.390	1.070	1.990	900	1.990	600
	20	2.390	1.070	1.910	860	1.590	720	1.590	480
Max cutting depth									
			ap	Pf			ap	Pf	
			0,07D	0,15 D			0,04D	0,1 D	

## PXBE-N

Ball nose type    L/D≤3,5

	Mild steel - Carbon steel Cast iron SS400 · S55C · FC250 ~750 N/mm2		Alloy steel Tool steel SCM · SKT · SKS · SKD ~30 HRC		Stainless steel Hardened steel SUS304S · SKD ~45 HRC		Hardened steel Titanium alloy steel (wet) Ti-6Al-4V 45~55 HRC		Hardened steel 55~60 HRC		
	Ø	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)	S (min <sup>-1</sup> )	F (mm/min)
	10	7.960	3.580	7.960	3.580	6.370	2.290	4.770	1.430	3.180	480
	12	6.630	2.980	6.630	2.980	5.310	1.910	3.980	1.190	2.650	400
	16	4.970	2.240	4.970	2.240	3.980	1.430	2.980	900	1.990	300
	20	3.980	1.790	3.980	1.790	3.180	1.150	2.390	720	1.590	240
Max cutting depth											
			ap	Pf			ap	Pf			
			0,05D	0,15 D			0,04D	0,1 D			