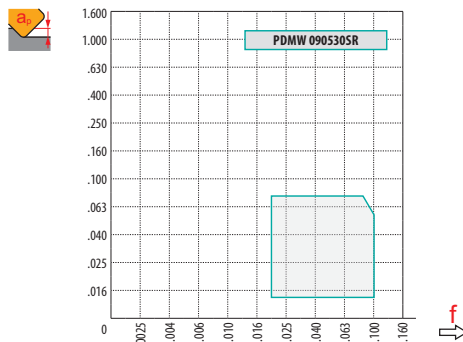
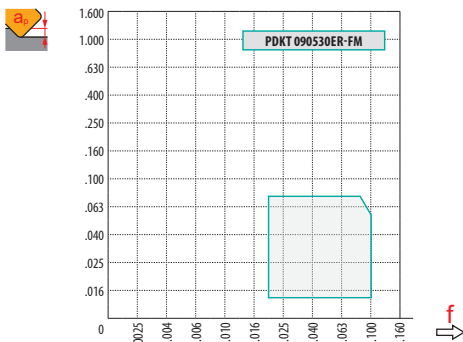
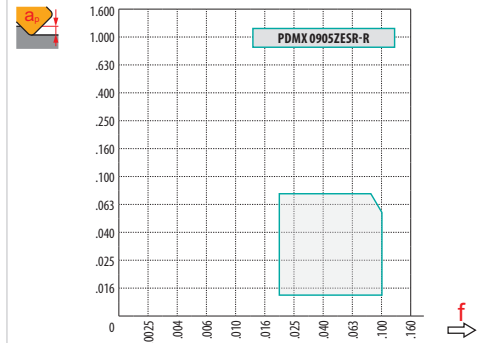
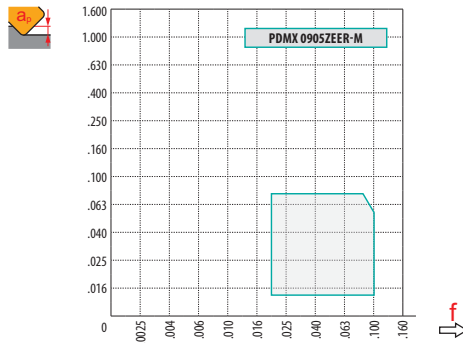
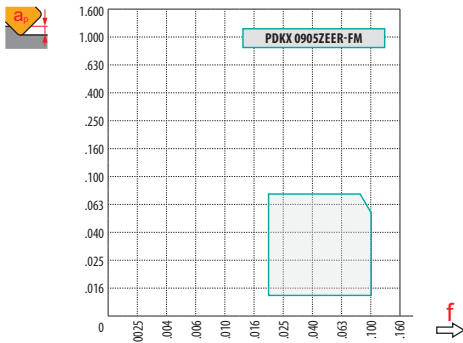




a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	.95	.85	.75	.85	.95	1.00	1.00	1.00	1.00
	.64	.64	.64	.64	.64	.65	.65	.67	.68	.71	.72	.74	.79	1.00

	PDKX 09-FM	PDMX 09-M	PDMX 09-R	PDKT 09-FM	PDMW 09
	-	-	-	3.0	3.0
	.079	.079	.079	-	-



(inch)													
DCX		.000	.012	.016	.020	.024	.028	.031	.035	.039	.049	.059	.079
1.250	DEF	.724	.791	.815	.839	.862	.886	.906	.929	.953	1.012	1.067	1.181
1.500		1.004	1.071	1.094	1.118	1.142	1.165	1.185	1.209	1.232	1.291	1.346	1.461
2.000		1.390	1.457	1.480	1.504	1.528	1.551	1.571	1.594	1.618	1.677	1.732	1.846
2.500		1.898	1.965	1.988	2.012	2.035	2.059	2.079	2.102	2.126	2.185	2.240	2.354
3.000		2.571	2.638	2.661	2.685	2.709	2.732	2.752	2.776	2.799	2.858	2.913	3.028
4.000		3.358	3.425	3.449	3.472	3.496	3.520	3.539	3.563	3.587	3.646	3.701	3.815
		.000	.012	.016	.020	.024	.028	.031	.035	.039	.049	.059	.079
		-	.118	.118	.114	.110	.106	.102	.098	.094	.089	.059	.059



Follow instructions provided for flat surface milling. When milling close to vertical surfaces, decrease feed per tooth (f_z) by 50 % to prevent vibrations and damage of the cutting edge.

(inch)		
DCX	max.	f_{max}
1.250	.197	.008
1.500	.197	.008
2.000	.236	.008
2.500	.276	.010
3.000	.315	.012
4.000	.315	.012

(inch)		
DCX	RPMX	APMX/l
1.500	8.0°	.071/.630
2.000	8.0°	.079/.630
2.500	7.0°	.079/.710
3.000	5.0°	.079/.710
4.000	3.0°	.079/.575




(inch)			
HFC			
	.020	.039	.079
	.118	.091	.059

(inch)				
DCX	DMIN	DMAX	DMIN	DMAX
1.500	2.508	3.150	.079	.079
2.000	3.280	3.937	.079	.079
2.500	4.299	4.961	.079	.079
3.000	5.642	6.299	.079	.079
4.000	7.217	7.874	.079	.079

(inch)		
DCX		f_{max}
1.250	.071	.008
1.500	.071	.008
2.000	.079	.008
2.500	.079	.008
3.000	.079	.008
4.000	.079	.010

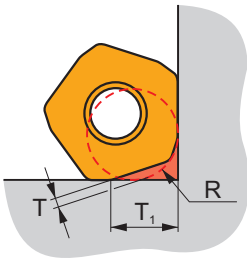



(inch)

		3	5	10	15	20	30	40	50	60	80	100
1.260		.024	.031	.045	.055	.063	.077	.089	.100	.109	.126	.141
1.575		.027	.035	.050	.061	.070	.086	.100	.111	.122	.141	.157
1.654		.028	.036	.051	.062	.072	.088	.102	.114	.125	.144	.161
1.969		.031	.039	.056	.068	.079	.096	.111	.124	.136	.157	.176
2.047		.031	.040	.057	.070	.080	.098	.114	.127	.139	.161	.180
2.480		.034	.044	.062	.077	.088	.108	.125	.140	.153	.177	.198
2.598		.035	.045	.064	.078	.090	.111	.128	.143	.157	.181	.202
3.150		.039	.050	.070	.086	.100	.122	.141	.157	.173	.199	.223



(inch)



	R	T	T ₁
1.250	.177	.043	.268
1.500 – 6.000	.177	.043	.287