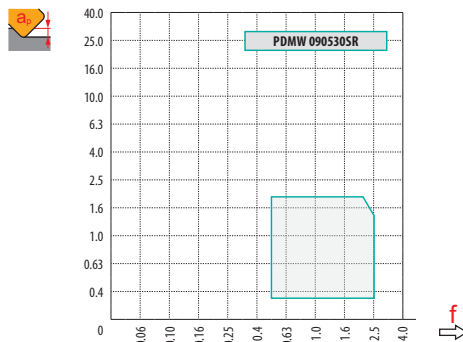
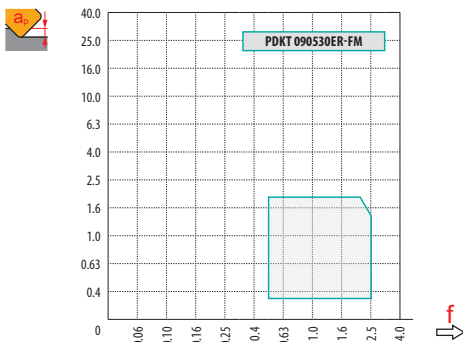
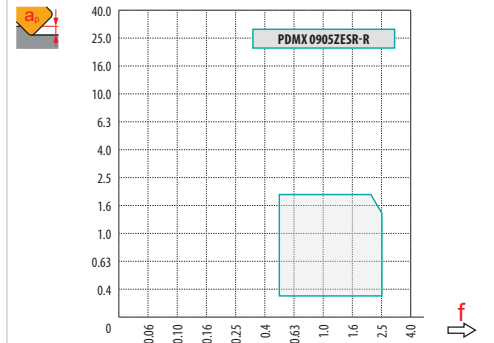
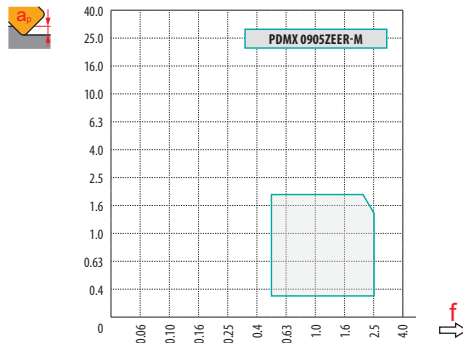
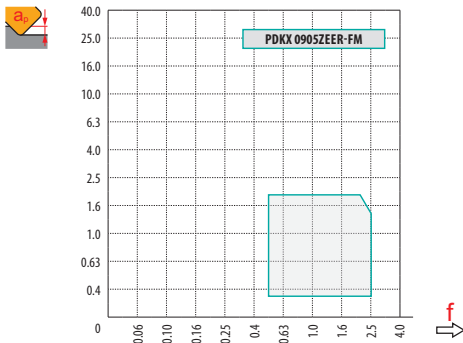







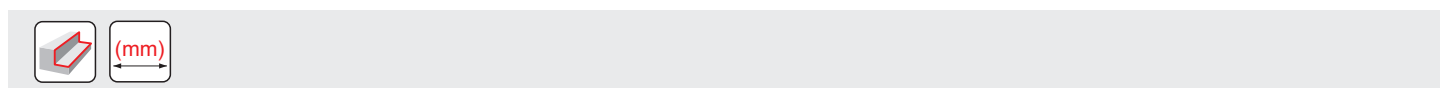


$a_e$ / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	.95	.85	.75	.85	.95	1.00	1.00	1.00	1.00
	.64	.64	.64	.64	.64	.65	.65	.67	.68	.71	.72	.74	.79	1.00

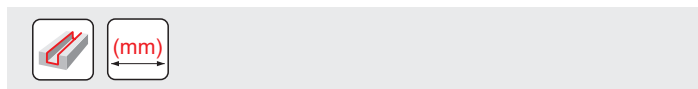
	PDKX 09-FM	PDMX 09-M	PDMX 09-R	PDKT 09-FM	PDMW 09
(mm)	-	-	-	3.0	3.0
(mm)	2.00	2.00	2.00	-	-






(mm)													
		.00	.30	.40	.50	.60	.70	.80	.90	1.00	1.25	1.50	2.00
32		18.4	20.1	20.7	21.3	21.9	22.5	23.0	23.6	24.2	25.7	27.1	30.0
40		25.5	27.2	27.8	28.4	29.0	29.6	30.1	30.7	31.3	32.8	34.2	37.1
42		27.5	29.2	29.8	30.4	31.0	31.6	32.1	32.7	33.3	34.8	36.2	39.1
50		35.3	37.0	37.6	38.2	38.8	39.4	39.9	40.5	41.1	42.6	44.0	46.9
52		37.3	39.0	39.6	4.2	40.8	41.4	41.9	42.5	43.1	44.6	46.0	48.9
63		48.2	49.9	50.5	51.1	51.7	52.3	52.8	53.4	54.0	55.5	56.9	59.8
66		51.2	52.9	53.5	54.1	54.7	55.3	55.8	56.4	57.0	58.5	59.9	62.8
80		65.3	67.0	67.6	68.2	68.8	69.4	69.9	70.5	71.1	72.6	74.0	76.9
100		85.3	87.0	87.6	88.2	88.8	89.4	89.9	90.5	91.1	92.6	94.0	96.9
125		110.3	112.3	112.9	113.5	114.1	114.6	115.2	115.8	116.4	117.9	119.3	122.2
140	125.3	127.3	127.9	128.5	129.1	129.7	130.2	130.8	131.4	132.9	134.3	137.2	
		.00	.30	.40	.50	.60	.70	.80	.90	1.00	1.25	1.50	2.00
		-	3.00	3.00	2.90	2.80	2.70	2.60	2.50	2.40	2.25	1.50	1.50





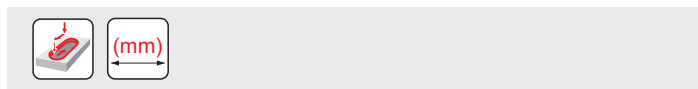
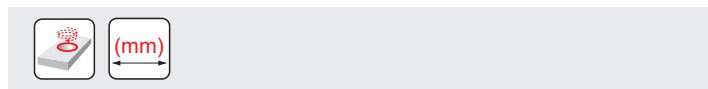
Follow instructions provided for flat surface milling. When milling close to vertical surfaces, decrease feed per tooth ( $f_z$ ) by 50 % to prevent vibrations and damage of the cutting edge.








		$f_{max}$
32	5.0	.20
40	5.0	.20
42	5.0	.20
50	6.0	.20
52	6.0	.20
63	7.0	.25
66	7.0	.25
80	8.0	.30
100	8.0	.30

	RPMX	APMX/l
40	8°	1.80/16
42	8°	2.00/16
50	8°	2.00/16
52	8°	2.00/16
63	7°	2.00/18
66	6°	2.00/21
80	5°	2.00/24
100	3°	2.00/40

HFC			
	.5	1.0	2.0
	3.0	2.3	1.5

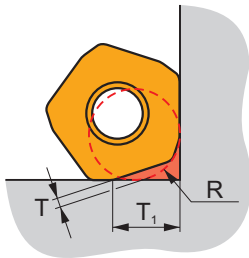


	DMIN	DMAX		
40	63.7	80.0	2.00	2.00
42	67.5	84.0	2.00	2.00
50	83.3	100.0	2.00	2.00
52	87.3	104.0	2.00	2.00
63	109.2	126.0	2.00	2.00
66	115.2	132.0	2.00	2.00
80	143.3	160.0	2.00	2.00
100	183.3	200.0	2.00	2.00

		$f_{max}$
32	1.8	.20
40	1.8	.20
42	2.0	.20
50	2.0	.20
52	2.0	.20
63	2.0	.25
66	2.0	.25
80	2.0	.30
100	2.0	.30



DCX	$\mu\text{m}$											
		3	5	10	15	20	30	40	50	60	80	100
32		.620	.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		.693	.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		.710	.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657



DCX	R	T	T <sub>1</sub>
32	4.5	1.1	6.8
40 - 140	4.5	1.1	7.3