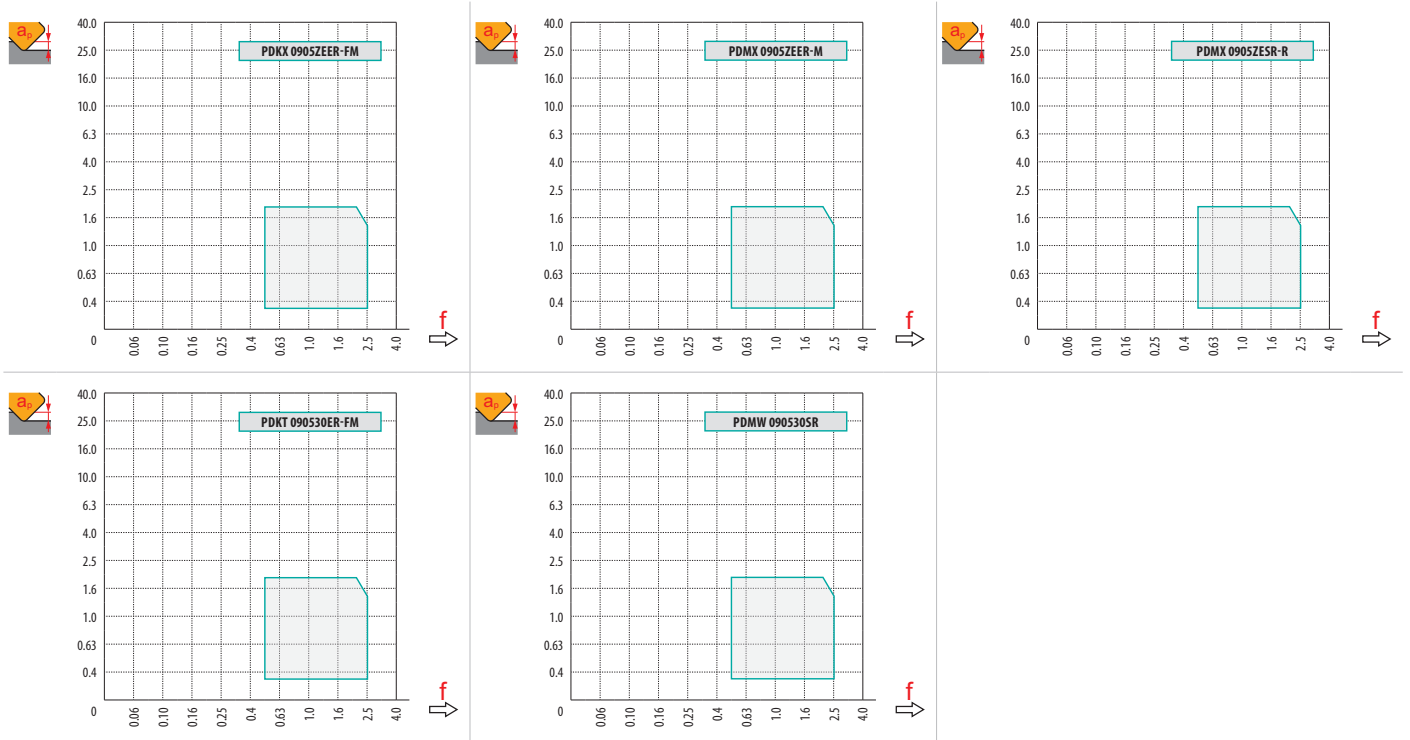




a_s DCX	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	PDKX 09-FM	PDMX 09-M	PDMX 09-R	PDKT 09-FM	PDMW 09
	-	-	-	3.0	3.0
	2.00	2.00	2.00	-	-



		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	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	40.2	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	
		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	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.



DCX	max	f_{max}
32	5.0	0.20
40	5.0	0.20
42	5.0	0.20
50	6.0	0.20
52	6.0	0.20
63	7.0	0.25
66	7.0	0.25
80	8.0	0.30
100	8.0	0.30



DCX	RPMX	APMX/I
40	8.0	1.80/16
42	8.0	2.00/16
50	8.0	2.00/16
52	8.0	2.00/16
63	7.0	2.00/18
66	6.0	2.00/21
80	5.0	2.00/24
100	3.0	2.00/40



	HFC		
a_p	0.5	1.0	2.0
f	3.0	2.3	1.5



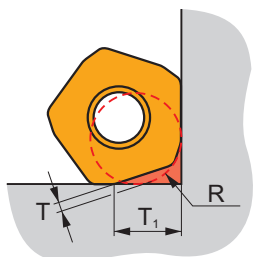
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
40	63.7	80.0	2.00	2.00
42	67.5	84.0	2.00	2.00
50	83.3	100.0	2.00	2.00
52	87.3	104.0	2.00	2.00
63	109.2	126.0	2.00	2.00
66	115.2	132.0	2.00	2.00
80	143.3	160.0	2.00	2.00
100	183.3	200.0	2.00	2.00



DCX	a_p	f_{max}
32	1.8	0.20
40	1.8	0.20
42	2.0	0.20
50	2.0	0.20
52	2.0	0.20
63	2.0	0.25
66	2.0	0.25
80	2.0	0.30
100	2.0	0.30



DCX	μm	3	5	10	15	20	30	40	50	60	80	100
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657



DCX	R	T	T_1
32	4.5	1.1	6.8
40 - 140	4.5	1.1	7.3