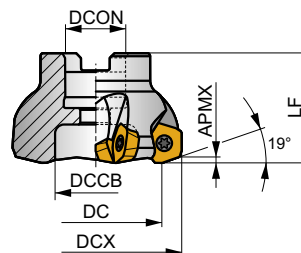
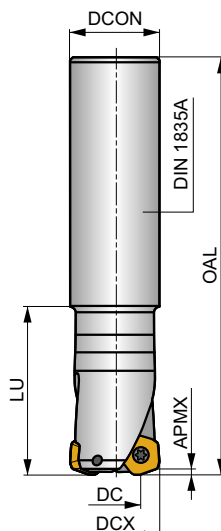


SPD09

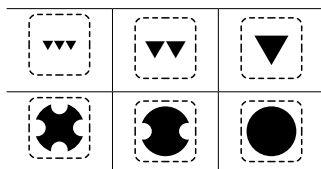
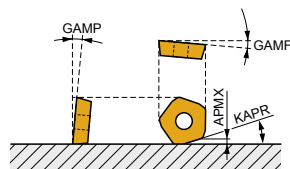


PRAMET

PENTA HF



KAPR	19°
APMX	2,0 mm






	0,065 - 0,975
	0,065 - 0,975



ISO	DCX	DC	OAL	LF	DCON	DCCB	LU	GAMP	GAMF								
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[°]								
32E2R060A32-SPD09-C	32	18,4	250	-	32	-	60	-24	+10	2	-	13100	✓	1,54	GI245	CO340	-
40E3R060A32-SPD09-C	40	25,5	250	-	32	-	60	-11	+10	3	-	11700	✓	1,43	GI245	CO340	-
42A03R-S19PD09-C	42	27,5	-	40	16	12	-	-8	+10	3	-	11500	✓	0,18	GI245	CO342	-
50A04R-S19PD09-C	50	35,3	-	40	22	18	-	-3	+10	4	-	10500	✓	0,23	GI245	CO343	-
50A05R-S19PD09-C	50	35,3	-	40	22	18	-	-3	+10	5	-	10500	✓	0,36	GI245	CO343	-
52A04R-S19PD09-C	52	37,3	-	40	22	18	-	-3	+10	4	-	10300	✓	0,25	GI245	CO343	-
63A05R-S19PD09-C	63	48,2	-	40	22	18	-	-1	+10	5	-	9400	✓	0,33	GI245	CO343	-
63A06R-S19PD09-C	63	48,2	-	40	22	18	-	-1	+10	6	-	9300	✓	0,47	GI245	CO343	-
S-63A07R-S19PD09-000197*	63	48,2	-	40	22	18	-	-1	+10	7	-	9200	✓	0,47	GI245	CO343	-
66A06R-S19PD09-C	66	51,2	-	40	22	18	-	-1	+10	6	-	9200	✓	0,35	GI245	CO343	-
66A06R-S19PD09-CF	66	51,2	-	50	27	22	-	-1	+10	6	-	9100	✓	0,68	GI245	CO344	-
80A05R-S19PD09-C	80	65,3	-	50	27	37	-	-1	+10	5	-	8300	✓	0,84	GI245	CO341	AC001
80A06R-S19PD09-C	80	65,3	-	50	27	37	-	-1	+10	6	-	8300	✓	0,88	GI245	CO341	AC001
100A06R-S19PD09-C	100	85,3	-	50	32	45	-	-1	+10	6	-	7400	✓	1,46	GI245	CO341	AC002
100A08R-S19PD09-C	100	85,3	-	50	32	45	-	-1	+10	8	-	7400	✓	1,40	GI245	CO341	AC002
125A08R-S19PD09-C	125	110,3	-	63	40	36	-	-1	+10	8	-	6600	✓	3,16	GI245	CO349	-
125A10R-S19PD09-C	125	110,3	-	63	40	36	-	-1	+10	10	-	6600	✓	3,15	GI245	CO349	-
140A08R-S19PD09-C	140	125,3	-	63	40	36	-	-1	+10	8	-	6200	✓	3,62	GI245	CO349	-


* Milling cutter to be ordered specially

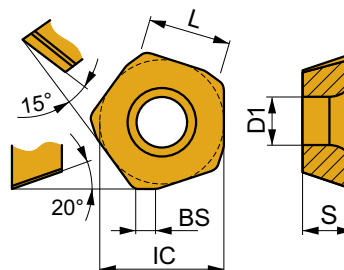
GI245	PD.X 0905ZE..			PDKT 0905..			PDMW 0905..
CO340	US 45011-T20P	5,0	M 5	11	-	-	Flag T20P
CO341	US 45011-T20P	5,0	M 5	11	SDR T20P-T	-	-
CO342	US 45011-T20P	5,0	M 5	11	SDR T20P-T	HS 90835	-
CO343	US 45011-T20P	5,0	M 5	11	SDR T20P-T	HS 1030C	-
CO344	US 45011-T20P	5,0	M 5	11	SDR T20P-T	HS 1230C	-
CO349	US 45011-T20P	5,0	M 5	11	SDR T20P-T	HSD 2040	-









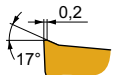
		
AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32

PDKX 09




	BS	IC	D1	L	S
0905	2,00	13,500	5,50	9,00	5,47

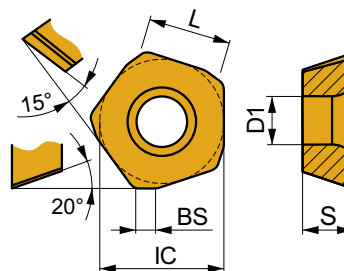











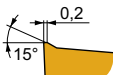
		ISO		P	M	K	N	S	H			RE	FN	FX	APMN	APMX
  		PDKX 0905ZEER-FM	M9340	☑	■					●	---	-	0,50	1,75	0,3	2,0
		M6330	☑	■			■			●	-	-	0,50	2,50	0,3	2,0
		M8345	■	■				■			●	+/-	-	0,50	2,50	0,3














PDMX 09

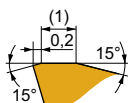


	BS	IC	D1	L	S
0905	2,00	13,500	5,50	9,00	5,47




		ISO		P	M	K	N	S	H			RE	FN	FX	APMN	APMX	
   		PDMX 0905ZEER-M	M9340	☑	■					●	---	-	0,50	1,75	0,3	2,0	
		M8330	■	☑	☑					●	-	-	0,50	2,50	0,3	2,0	
		M8345	■	■							●	+/-	-	0,50	2,50	0,3	2,0
		8215	☑	☑	☑						●	-	-	0,50	2,50	0,3	2,0

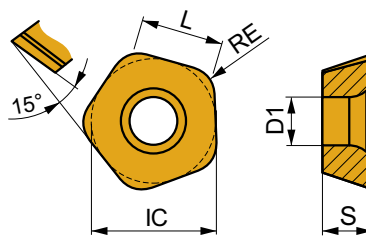
		ISO		P	M	K	N	S	H			RE	FN	FX	APMN	APMX	
  		PDMX 0905ZESR-R	M9325	☑	☐						---	-	0,50	1,75	0,3	2,0	
		M8330	☑	☐	■				☑		-	-	0,50	2,50	0,3	2,0	
		M8345	☑	☐								+/-	-	0,50	2,50	0,3	2,0
		8215	☑	☐	■					■		-	-	0,50	2,50	0,3	2,0



















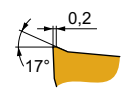
PDKT 09



	IC	D1	L	S
0905	13,500	5,50	9,00	5,47




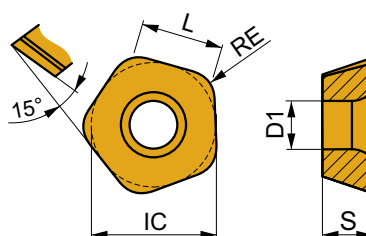
		ISO		P	M	K	N	S	H			RE	FN	FX	APMN	APMX	
   		PDKT 090530ER-FM	M9325	■	☑						---	3,0	0,50	1,75	0,3	2,0	
		M6330	☑	■					■		-	3,0	0,50	2,50	0,3	2,0	
		M8310	■	☑	☑							-	3,0	0,50	2,50	0,3	2,0
		M8330	■	☑	☑							-	3,0	0,50	2,50	0,3	2,0
		M8345	■	■					■			+/-	3,0	0,50	2,50	0,3	2,0
		8215	■	☑	☑							-	3,0	0,50	2,50	0,3	2,0















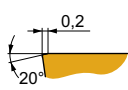
PDMW 09



	IC	D1	L	S
0905	13,500	5,50	9,00	5,47



		ISO		P	M	K	N	S	H			RE	FN	FX	APMN	APMX	
  		PDMW 090530SR	M9315	☑		☑				☑	---	3,0	0,50	1,75	0,3	2,0	
		M9325	☑		■							---	3,0	0,50	1,75	0,3	2,0
		M8310	☑		■					■		-	3,0	0,50	2,50	0,3	2,0
		M8345	☑									+/-	3,0	0,50	2,50	0,3	2,0



ISO		FN	FX	M9315	M9325	M9340	M6330	M8310	M8330	M8345	8215
P	●	0,50	2,50	468	451	391	352	402	352	259	385
	●	0,50	2,00	429	407	347	314	363	308	220	336
	✘	0,50	1,50	385	358	308	275	325	264	187	286
M	●	0,50	2,50	-	270	231	231	242	209	154	231
	●	0,50	2,00	-	242	209	204	215	187	132	198
	✘	0,50	1,50	-	215	182	176	193	160	110	171
K	●	0,50	2,50	446	-	-	-	380	336	-	363
	●	0,50	2,00	407	-	-	-	347	292	-	319
	✘	0,50	1,50	369	-	-	-	308	253	-	270
N	●	0,50	2,50	-	-	-	-	-	886	-	968
	●	0,50	2,00	-	-	-	-	-	781	-	842
	✘	0,50	1,50	-	-	-	-	-	671	-	721
S	●	0,50	2,15	-	132	116	116	121	105	77	116
	●	0,50	1,80	-	121	105	99	105	94	66	99
	✘	0,50	1,40	-	105	88	88	94	77	55	83
H	●	0,50	2,00	94	-	-	-	77	66	-	77
	●	0,50	1,60	83	-	-	-	72	61	-	66
	✘	0,50	1,20	77	-	-	-	61	50	-	55



a_e DCX	0,05	0,10	0,15	0,20	0,25	0,30	0,40	0,50	0,60	0,70	0,75	0,80	0,90	1,00
	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
	2,87	2,05	1,69	1,48	1,33	1,23	1,09	0,75	0,94	0,90	0,89	0,88	0,88	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	-	-




DCX	AP	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	DEF	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

AP	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 the instructions provided for milling flat surfaces. If milling close to a vertical surface, reduce the feed per tooth (f_z) by 50 % to prevent vibrations and edge breakage.




		
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






HFC			
	0,5	1,0	2,0
	2,99	2,30	1,49






	RPMX	APMX/l
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






	d_{min}	d_{max}		
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

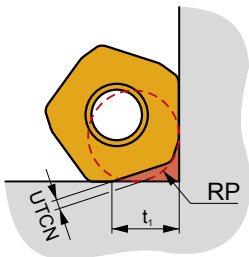



		
32	1,8	0,20
40	1,8	0,20
42	2,0	0,20
50	2,0	0,20
52	2,0	0,20
63	2,0	0,25
66	2,0	0,25
80	2,0	0,30
100	2,0	0,30



		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

i



	RP	UTCN	t ₁
32	4,5	1,1	6,8
40 - 140	4,5	1,1	7,3