

6PDRS

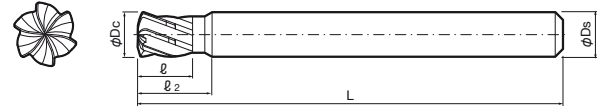
Number of Flutes: 6

Semi-Finishing of Hard Materials



Recommended Material

★ 1st Recommendation

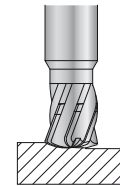


Lineup

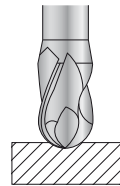
(Unit: mm)

Description	Std.	Outside Dia.	Outside Dia. tolerance	Under Neck Length	Edge Length	Shank Dia.	Total length	Number of Flutes
		øDc		ℓ ₂	ℓ	øDs	L	Z
6PDRS060-045-06	●	6	-0.020 -0.038	9	4.5	6	57	6
6PDRS080-060-08	●	8	-0.025 -0.047	12	6	8	63	6
6PDRS100-075-10	●	10	-0.025 -0.047	15	7.5	10	72	6
6PDRS120-090-12	●	12	-0.032 -0.059	18	9	12	83	6

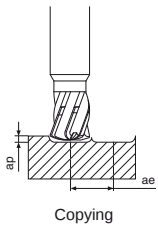
- Increased rigidity with large core diameter. 6 edge design enables high feed rate cutting. Achieves large machining allowance and high efficiency machining with special corner-R shape. Ramping and arc machining are possible.



PDR type

General Purpose
Ball-Nosed End Mill

Recommended Cutting Conditions



Copying

Workpiece		Depth of Cut (ap×ae) (mm)	Outside Dia. (mm)	ø6	ø8	ø10	ø12
Pre-hardened Steel (AISI P20, C)	52HRC	ø6 :0.32mm×0.55Dc ø8 :0.42mm×0.55Dc ø10:0.53mm×0.55Dc ø12:0.63mm×0.55Dc	Spindle Revolution (min-1)	6,400	4,800	3,800	3,200
			Feed Rate (mm/min)	7,600	7,200	6,900	7,600
SNCM439 (AISI 4340, C)	45HRC		Spindle Revolution (min-1)	8,500	6,400	5,100	4,200
			Feed Rate (mm/min)	15,300	15,300	15,300	12,700

For ramping and arc machining, please refer to page L47.