

Special corner-R shaped, 6 flutes, High feed rate

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No. of Flutes: 6

6PDRS



Workpiece Materials ★ 1st choice

★
P
~30HRC

★
P
30~40HRC

★
H
~55HRC

★
H
~68HRC

APTiN

Radius
R

h6
Shank Dia.

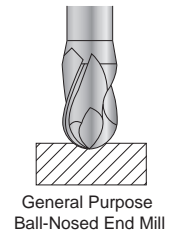
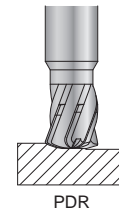
20°

6PDRS

(Unit : mm)

| Description | Std. | Outside Dia. | Mill Dia. tolerance | Length of cut | Under Neck Length | Shank diameter | Overall length | No. of Flutes |
|------------------------|--------------------------|--------------|---------------------|---------------|-------------------|----------------|----------------|---------------|
| | | ϕDc | | l | l_2 | ϕDs | L | Z |
| 6PDRS060-045-06 | <input type="checkbox"/> | 6 | -0.020 -0.038 | 4.5 | 9 | 6 | 57 | 6 |
| 6PDRS080-060-08 | <input type="checkbox"/> | 8 | -0.025 -0.047 | 6 | 12 | 8 | 63 | 6 |
| 6PDRS100-075-10 | <input type="checkbox"/> | 10 | -0.025 -0.047 | 7.5 | 15 | 10 | 72 | 6 |
| 6PDRS120-090-12 | <input type="checkbox"/> | 12 | -0.032 -0.059 | 9 | 18 | 12 | 83 | 6 |

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

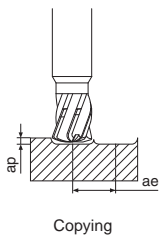


L



Solid End Mill

Recommended Cutting Conditions



Copying

| Workpiece Material | | Depth of Cut (apxae) (mm) | Outside Dia. Dc (mm) | $\phi 6$ | $\phi 8$ | $\phi 10$ | $\phi 12$ |
|-------------------------|-------|--------------------------------------|----------------------------|----------|----------|-----------|-----------|
| Pre-hardened steel | 52HRC | $\phi 6$: 0.32x3.3mm (0.32x0.55Dc) | Spindle Revolution (min-1) | 6,400 | 4,800 | 3,800 | 3,200 |
| | | $\phi 8$: 0.42x4.4mm (0.42x0.55Dc) | | 7,600 | 7,200 | 6,900 | 7,600 |
| Alloy steel (SCM, SNCM) | 45HRC | $\phi 10$: 0.53x5.5mm (0.53x0.55Dc) | Spindle Revolution (min-1) | 8,500 | 6,400 | 5,100 | 4,200 |
| | | $\phi 12$: 0.63x6.6mm (0.63x0.55Dc) | | 15,300 | 15,300 | 15,300 | 12,700 |

: Check Availability