

PMT

POWDER END MILLS FREZY PROSZKOWE



POWDER END MILLS PMT for high productivity on conventional milling machines for materials up to 40 HRC.

FREZY PROSZKOWE PMT przeznaczone są do wysokowydajnej obróbki materiałów >40 HRC na obrabiarkach konwencjonalnych.



IMPLEMENTS

P

K

N

POWDER METAL END MILLS PMT for high productivity on conventional milling machines for materials up to HRC40.

FREZY WALCOWO-CZOŁOWE PMT proszkowe do wysokowydajnej obróbki materiałów do 40 HRC na obrabiarkach konwencjonalnych.

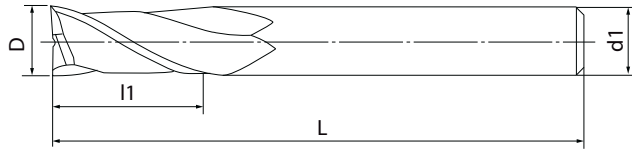
- PM-T END MILLS are #1 choice power milling!! High productivity!! For conventional milling machine.
- Frezy walcowo-czołowe PMT są podstawowym wyborem dla wydajnego frezowania!! Wysoka wydajność!! Do stosowania na obrabiarkach konwencjonalnych.

EDP No.		Z	Angle Kąt	Materials Materiały	D / R	Pag. / Str.
PMT36		2		P K N	D 1 - 25	3 - 4
PMT29		2		P K N	D 1 - 25	5 - 6
PMT42		3		P K N	D 1 - 25	7 - 8
PMT30		3		P K N	D 1 - 25	9 - 10
PMT38		4		P K N	D 1 - 25	11
PMT31		4		P K N	D 2 - 25	12
PMT41		3 - 5		P K N	D 6 - 25	13
PMT53		4		P K N	D 6 - 25	14
PMT55		4		P K N	D 4 - 20	15
PMT35		3 - 5		P K N	D 6 - 25	14
PMT26		3 - 6		P K N	D 4 - 25	15 - 16
PMT57		3 - 6		P K N	D 4 - 25	19
PMT33		3 - 5		P K N	D 6 - 25	17 - 17
PMT59		4 - 5		P K N	D 6 - 25	22
PMT34		3 - 5		P K N	D 6 - 25	18
PMT40		2		P K N	R 0,5 - 12,5	19
PMT32		2		P K N	R 1 - 12,5	20

PMT36
SQUARE TYPE WALCOWO-CZOŁOWE

2-Flute, Short Length 2-ostrzowe, krótkie

P		H		M		K		N		S				
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB



D code new Nowy kod	D code kod	D	d1	L	l1	Z	Shank Uchwyt
PMT36010000A06003047	PMT36010	1	6	47	2,5	2	A
PMT36020000A06004048	PMT36020	2	6	48	4	2	A
PMT36030000A06005049	PMT36030	3	6	49	5	2	A
PMT36040000A06007051	PMT36040	4	6	51	7	2	A
PMT36050000A06008052	PMT36050	5	6	52	8	2	A
PMT36060000A06008052	PMT36060	6	6	52	8	2	A
PMT36070000A10010060	PMT36070	7	10	60	10	2	A
PMT36080000A10011061	PMT36080	8	10	61	11	2	A
PMT36090000A10011061	PMT36090	9	10	61	11	2	A
PMT36100000A10013063	PMT36100	10	10	63	13	2	A
PMT36120000A12016073	PMT36120	12	12	73	16	2	A
PMT36140000A12016073	PMT36140	14	12	73	16	2	A
PMT36160000A16019079	PMT36160	16	16	79	19	2	A
PMT36180000A16019079	PMT36180	18	16	79	19	2	A
PMT36200000A20022088	PMT36200	20	20	88	22	2	A
PMT36220000A20022088	PMT36220	22	20	88	22	2	A
PMT36250000A25026102	PMT36250	25	25	102	26	2	A

	D ≤ 3,0	-14 — -28	D ≤ 30	-40 — -73	d1 ≤ 18	0 — -11
	D ≤ 6,0	-20 — -38	d1 ≤ 3	0 — -6	d1 ≤ 30	0 — -13
	D ≤ 10	-25 — -47	d1 ≤ 6	0 — -8		
	D ≤ 18	-32 — -59	d1 ≤ 10	0 — -9		

PMT36

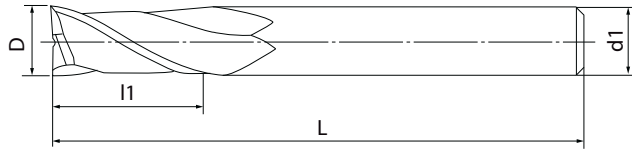
Cutting Conditions Parametry skrawania

SLOTTING / FREZOWANIE ROWKÓW

			Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural steels, carbon steels, cast irons Stal konstrukcyjna, węglowa, żeliwo		Carbon steels, alloy steels, tool steels Stal węglowa, stopowa, narzędziowa		Prehardened steels, alloy steels, tool steels Stal ulepszona, stopowa, narzędziowa		Alloy steels, tool steels, austenitic stainless steels Stal stopowa, narzędziowa, kwasoodporna	
					<20 HRC		20 - 30 HRC		30 - 35 HRC		35 - 40 HRC	
			<500 N/mm ²		500 - 800 N/mm ²		800 - 1000 N/mm ²		1000 - 1100 N/mm ²		1100 - 1300 N/mm ²	
D1 mm	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
2	2	1	7000	115	5900	90	4900	80	3150	65	2000	40
3	3	1,5	5000	160	4100	135	3350	115	2300	80	1800	62
4	4	2	4300	230	3600	175	3150	160	2000	92	1600	75
5	5	2,5	3900	255	3250	200	2600	185	1700	102	1350	75
6	6	3	3500	265	2900	210	2300	190	1450	110	1150	85
8	8	4	2600	275	2200	240	1800	200	1150	115	890	85
10	10	5	2100	300	1800	265	1450	230	900	125	700	102
12	12	6	1800	275	1450	240	1150	210	740	115	580	85
14	14	7	1600	265	1250	210	1000	195	630	110	500	80
16	16	8	1350	265	1150	195	890	180	560	102	440	80
18	18	9	1150	240	950	195	790	160	500	100	400	75
20	20	10	950	220	780	165	700	150	440	92	360	70
22	22	11	840	185	710	150	600	125	400	80	320	55
25	25	12,5	750	155	630	140	490	115	360	75	250	52

PMT29
SQUARE TYPE WALCOWO-CZOŁOWE
 2-Flute, Long Length 2-ostrzowe, długie

P		H		M		K		N		S				
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB
•	•							•	•	•	•	•	•	•



D code new Nowy kod	D code Kod	D	d1	L	l1	Z	Shank Uchwyt
PMT29010000A06003047	PMT29010	1	6	47	3	2	A
PMT29020000A06007051	PMT29020	2	6	51	7	2	A
PMT29030000A06008052	PMT29030	3	6	52	8	2	A
PMT29040000A06011055	PMT29040	4	6	55	11	2	A
PMT29050000A06013057	PMT29050	5	6	57	13	2	A
PMT29060000A06013057	PMT29060	6	6	57	13	2	A
PMT29070000A10016066	PMT29070	7	10	66	16	2	A
PMT29080000A10019069	PMT29080	8	10	69	19	2	A
PMT29090000A10019069	PMT29090	9	10	69	19	2	A
PMT29100000A10022072	PMT29100	10	10	72	22	2	A
PMT29120000A12026083	PMT29120	12	12	83	26	2	A
PMT29140000A12026083	PMT29140	14	12	83	26	2	A
PMT29160000A16032092	PMT29160	16	16	92	32	2	A
PMT29180000A16032092	PMT29180	18	16	92	32	2	A
PMT29200000A20038104	PMT29200	20	20	104	38	2	A
PMT29220000A20038104	PMT29220	22	20	104	38	2	A
PMT29250000A25045121	PMT29250	25	25	121	45	2	A

	D ≤ 3,0	-14 — -28	D ≤ 30	-40 — -73	d1 ≤ 18	0 — -11
	D ≤ 6,0	-20 — -38	d1 ≤ 3	0 — -6	d1 ≤ 30	0 — -13
	D ≤ 10	-25 — -47	d1 ≤ 6	0 — -8		
	D ≤ 18	-32 — -59	d1 ≤ 10	0 — -9		

PMT29

Cutting Conditions Parametry skrawania

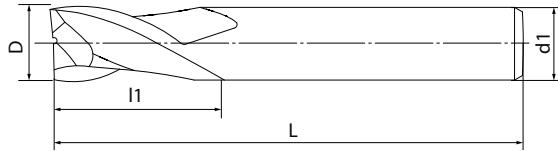
SLOTTING / FREZOWANIE ROWKÓW

			Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural steels, carbon steels, cast irons Stal konstrukcyjna, węglowa, żeliwo		Carbon steels, alloy steels, tool steels Stal węglowa, stopowa, narzędziowa		Prehardened steels, alloy steels, tool steels Stal ulepszona, stopowa, narzędziowa		Alloy steels, tool steels, austenitic stainless steels Stal stopowa, narzędziowa, kwasoodporna	
			<20 HRC		20 - 30 HRC		30 - 35 HRC		35 - 40 HRC			
			<500 N/mm ²		500 - 800 N/mm ²		800 - 1000 N/mm ²		1000 - 1100 N/mm ²		1100 - 1300 N/mm ²	
D1 mm	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
2	2	1	7000	115	5900	90	4900	80	3150	65	2000	40
3	3	1,5	5000	160	4100	135	3350	115	2300	80	1800	62
4	4	2	4300	230	3600	175	3150	160	2000	92	1600	75
5	5	2,5	3900	255	3250	200	2600	185	1700	102	1350	75
6	6	3	3500	265	2900	210	2300	190	1450	110	1150	85
8	8	4	2600	275	2200	240	1800	200	1150	115	890	85
10	10	5	2100	300	1800	265	1450	230	900	125	700	102
12	12	6	1800	275	1450	240	1150	210	740	115	580	85
14	14	7	1600	265	1250	210	1000	195	630	110	500	80
16	16	8	1350	265	1150	195	890	180	560	102	440	80
18	18	9	1150	240	950	195	790	160	500	100	400	75
20	20	10	950	220	780	165	700	150	440	92	360	70
22	22	11	840	185	710	150	600	125	400	80	320	55
25	25	12,5	750	155	630	140	490	115	360	75	250	52

PMT42
SQUARE TYPE WALCOWO-CZOŁOWE

3-Flute, Short Length 3-ostrzowe, krótkie

P		H		M		K		N		S				
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB
•	•							•	•	•	○	•	•	•



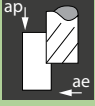
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PMT42010000A06003047	PMT42010	1	6	47	2,5	3	A
PMT42020000A06004048	PMT42020	2	6	48	4	3	A
PMT42030000A06005049	PMT42030	3	6	49	5	3	A
PMT42040000A06007051	PMT42040	4	6	51	7	3	A
PMT42050000A06008052	PMT42050	5	6	52	8	3	A
PMT42060000A06008052	PMT42060	6	6	52	8	3	A
PMT42070000A10010060	PMT42070	7	10	60	10	3	A
PMT42080000A10011061	PMT42080	8	10	61	11	3	A
PMT42090000A10011061	PMT42090	9	10	61	11	3	A
PMT42100000A10013063	PMT42100	10	10	63	13	3	A
PMT42120000A12016073	PMT42120	12	12	73	16	3	A
PMT42140000A12016073	PMT42140	14	12	73	16	3	A
PMT42160000A16019079	PMT42160	16	16	79	19	3	A
PMT42180000A16019079	PMT42180	18	16	79	19	3	A
PMT42200000A20022088	PMT42200	20	20	88	22	3	A
PMT42220000A20022088	PMT42220	22	20	88	22	3	A
PMT42250000A25026102	PMT42250	25	25	102	26	3	A

	D ≤ 3,0	-14 — -28	D ≤ 30	-40 — -73	d1 ≤ 18	0 — -11
	D ≤ 6,0	-20 — -38	d1 ≤ 3	0 — -6	d1 ≤ 30	0 — -13
	D ≤ 10	-25 — -47	d1 ≤ 6	0 — -8		
	D ≤ 18	-32 — -59	d1 ≤ 10	0 — -9		

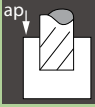
PMT42

Cutting Conditions Parametry skrawania

SIDE MILLING / FREZOWANIE OBWODOWE

			Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural steels, carbon steels, cast irons Stal konstrukcyjna, węglowa, żeliwo		Carbon steels, alloy steels, tool steels Stal węglowa, stopowa, narzędziowa		Prehardened steels, alloy steels, tool steels Stal ulepszona, stopowa, narzędziowa		Alloy steels, tool steels, austenitic stainless steels Stal stopowa, narzędziowa, kwasoodporna	
					<20 HRC		20 - 30 HRC		30 - 35 HRC		35 - 40 HRC	
			<500 N/mm ²		500 - 800 N/mm ²		800 - 1000 N/mm ²		1000 - 1100 N/mm ²		1100 - 1300 N/mm ²	
D1 mm	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
2	0,2	3	6500	70	5500	55	4800	45	3000	35	1900	28
3	0,3	4,5	4600	102	3900	85	3350	52	2200	45	1800	45
4	0,4	6	4300	140	3600	115	3000	80	1900	52	1500	55
5	0,5	7,5	3800	160	3200	130	2600	92	1700	62	1300	55
6	0,6	9	3350	230	2800	190	2300	140	1450	92	1100	75
8	0,8	12	2600	240	2200	210	1800	150	1150	102	890	85
10	1	15	100	250	1800	210	1400	160	890	115	680	92
12	1,2	18	1800	275	1450	230	1200	170	740	115	580	92
14	1,4	21	1600	250	1350	220	1000	160	660	110	500	85
16	1,6	24	1350	240	1150	210	890	150	560	102	440	85
18	1,8	27	1150	240	890	190	790	150	500	95	400	80
20	2	30	950	230	790	190	700	140	440	92	360	80
22	2,2	33	840	230	730	195	600	150	400	95	315	85
25	2,5	37,5	750	240	630	210	490	160	360	102	250	85

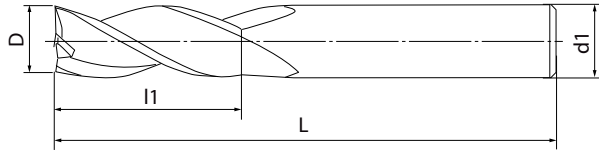
SLOTING / FREZOWANIE ROWKÓW

			Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural steels, carbon steels, cast irons Stal konstrukcyjna, węglowa, żeliwo		Carbon steels, alloy steels, tool steels Stal węglowa, stopowa, narzędziowa		Prehardened steels, alloy steels, tool steels Stal ulepszona, stopowa, narzędziowa		Alloy steels, tool steels, austenitic stainless steels Stal stopowa, narzędziowa, kwasoodporna	
					<20 HRC		20 - 30 HRC		30 - 35 HRC		35 - 40 HRC	
			<500 N/mm ²		500 - 800 N/mm ²		800 - 1000 N/mm ²		1000 - 1100 N/mm ²		1100 - 1300 N/mm ²	
D1 mm	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
2	2	1	8200	100	6800	80	5500	65	3800	50	2400	40
3	3	1,5	5800	145	4800	120	3800	75	2700	65	2200	65
4	4	2	5200	185	4400	155	3500	110	2300	75	1900	75
5	5	2,5	4700	210	4000	175	2900	125	2000	85	1700	75
6	6	3	4200	300	3600	250	2600	190	1800	125	1500	100
8	8	4	3200	330	2600	270	2000	200	1300	140	1100	115
10	10	5	2500	350	2100	290	1600	210	1000	150	890	125
12	12	6	2100	350	1800	300	1400	230	900	150	740	125
14	14	7	1800	350	1500	285	1150	210	780	140	630	120
16	16	8	1600	330	1300	275	1000	200	660	140	550	115
18	18	9	1350	310	1150	265	890	195	580	130	500	110
20	20	10	1250	300	1050	255	780	190	520	125	440	110
22	22	11	1150	310	950	265	740	195	470	130	400	110
25	25	12,5	1000	330	840	275	630	210	420	135	360	120

PMT30
SQUARE TYPE WALCOWO-CZOŁOWE

3-Flute, Short Length 3-ostrzowe, krótkie

P		H		M		N			S					
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB
•	•							•	•	•	○	•	•	•



D code new Nowy kod	D code Kod	D	d1	L	l1	Z	Shank Uchwyt
PMT30010000A06003047	PMT30010	1	6	47	3	3	A
PMT30020000A06007051	PMT30020	2	6	51	7	3	A
PMT30030000A06008052	PMT30030	3	6	52	8	3	A
PMT30040000A06011055	PMT30040	4	6	55	11	3	A
PMT30050000A06013057	PMT30050	5	6	57	13	3	A
PMT30060000A06013057	PMT30060	6	6	57	13	3	A
PMT30070000A10016066	PMT30070	7	10	66	16	3	A
PMT30080000A10019069	PMT30080	8	10	69	19	3	A
PMT30090000A10019069	PMT30090	9	10	69	19	3	A
PMT30100000A10022072	PMT30100	10	10	72	22	3	A
PMT30120000A12026083	PMT30120	12	12	83	26	3	A
PMT30140000A12026083	PMT30140	14	12	83	26	3	A
PMT30160000A16032092	PMT30160	16	16	92	32	3	A
PMT30180000A16032092	PMT30180	18	16	92	32	3	A
PMT30200000A20038104	PMT30200	20	20	104	38	3	A
PMT30220000A20038104	PMT30220	22	20	104	38	3	A
PMT30250000A25045121	PMT30250	25	25	121	45	3	A

	D ≤ 3,0	-14 — -28	D ≤ 30	-40 — -73	d1 ≤ 18	0 — -11
	D ≤ 6,0	-20 — -38	d1 ≤ 3	0 — -6	d1 ≤ 30	0 — -13
	D ≤ 10	-25 — -47	d1 ≤ 6	0 — -8		
	D ≤ 18	-32 — -59	d1 ≤ 10	0 — -9		

PMT30

Cutting Conditions Parametry skrawania

SIDE MILLING / FREZOWANIE OBWODOWE

			Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural steels, carbon steels, cast irons Stal konstrukcyjna, węglowa, żeliwo		Carbon steels, alloy steels, tool steels Stal węglowa, stopowa, narzędziowa		Prehardened steels, alloy steels, tool steels Stal ulepszona, stopowa, narzędziowa		Alloy steels, tool steels, austenitic stainless steels Stal stopowa, narzędziowa, kwasoodporna	
					<20 HRC		20 - 30 HRC		30 - 35 HRC		35 - 40 HRC	
			<500 N/mm ²		500 - 800 N/mm ²		800 - 1000 N/mm ²		1000 - 1100 N/mm ²		1100 - 1300 N/mm ²	
D1 mm	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
2	0,2	3	6500	70	5500	55	4800	45	3000	35	1900	28
3	0,3	4,5	4600	102	3900	85	3350	52	2200	45	1800	45
4	0,4	6	4300	140	3600	115	3000	80	1900	52	1500	55
5	0,5	7,5	3800	160	3200	130	2600	92	1700	62	1300	55
6	0,6	9	3350	230	2800	190	2300	140	1450	92	1100	75
8	0,8	12	2600	240	2200	210	1800	150	1150	102	890	85
10	1	15	100	250	1800	210	1400	160	890	115	680	92
12	1,2	18	1800	275	1450	230	1200	170	740	115	580	92
14	1,4	21	1600	250	1350	220	1000	160	660	110	500	85
16	1,6	24	1350	240	1150	210	890	150	560	102	440	85
18	1,8	27	1150	240	890	190	790	150	500	95	400	80
20	2	30	950	230	790	190	700	140	440	92	360	80
22	2,2	33	840	230	730	195	600	150	400	95	315	85
25	2,5	37,5	750	240	630	210	490	160	360	102	250	85

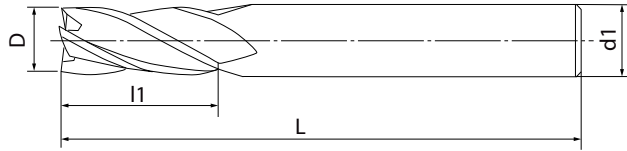
SLOTING / FREZOWANIE ROWKÓW

			Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural steels, carbon steels, cast irons Stal konstrukcyjna, węglowa, żeliwo		Carbon steels, alloy steels, tool steels Stal węglowa, stopowa, narzędziowa		Prehardened steels, alloy steels, tool steels Stal ulepszona, stopowa, narzędziowa		Alloy steels, tool steels, austenitic stainless steels Stal stopowa, narzędziowa, kwasoodporna	
					<20 HRC		20 - 30 HRC		30 - 35 HRC		35 - 40 HRC	
			<500 N/mm ²		500 - 800 N/mm ²		800 - 1000 N/mm ²		1000 - 1100 N/mm ²		1100 - 1300 N/mm ²	
D1 mm	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
2	2	1	8200	100	6800	80	5500	65	3800	50	2400	40
3	3	1,5	5800	145	4800	120	3800	75	2700	65	2200	65
4	4	2	5200	185	4400	155	3500	110	2300	75	1900	75
5	5	2,5	4700	210	4000	175	2900	125	2000	85	1700	75
6	6	3	4200	300	3600	250	2600	190	1800	125	1500	100
8	8	4	3200	330	2600	270	2000	200	1300	140	1100	115
10	10	5	2500	350	2100	290	1600	210	1000	150	890	125
12	12	6	2100	350	1800	300	1400	230	900	150	740	125
14	14	7	1800	350	1500	285	1150	210	780	140	630	120
16	16	8	1600	330	1300	275	1000	200	660	140	550	115
18	18	9	1350	310	1150	265	890	195	580	130	500	110
20	20	10	1250	300	1050	255	780	190	520	125	440	110
22	22	11	1150	310	950	265	740	195	470	130	400	110
25	25	12,5	1000	330	840	275	630	210	420	135	360	120

PMT38
SQUARE TYPE WALCOWO-CZOŁOWE

4-Flute, Short Length 4-ostrzowy, krótki

P	H	M	K	N			S							
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB



D code new Nowy kod	D code Kod	D	d1	L	l1	Z	Shank Uchwyt
PMT38010000A06003049	PMT38010	1	6	49	3	4	A
PMT38020000A06007051	PMT38020	2	6	51	7	4	A
PMT38030000A06008052	PMT38030	3	6	52	8	4	A
PMT38040000A06011055	PMT38040	4	6	55	11	4	A
PMT38050000A06013057	PMT38050	5	6	57	13	4	A
PMT38060000A06013057	PMT38060	6	6	57	13	4	A
PMT38070000A10016066	PMT38070	7	10	66	16	4	A
PMT38080000A10019069	PMT38080	8	10	69	19	4	A
PMT38090000A10019069	PMT38090	9	10	69	19	4	A
PMT38100000A10022072	PMT38100	10	10	72	22	4	A
PMT38120000A12026083	PMT38120	12	12	83	26	4	A
PMT38140000A12026083	PMT38140	14	12	83	26	4	A
PMT38160000A16032092	PMT38160	16	16	92	32	4	A
PMT38180000A16032092	PMT38180	18	16	92	32	4	A
PMT38200000A20038104	PMT38200	20	20	104	38	4	A
PMT38220000A20038104	PMT38220	22	20	104	38	4	A
PMT38250000A25045121	PMT38250	25	25	121	45	4	A

Cutting Conditions Parametry skrawania

Material Materiał	Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural Steel, Carbon Steel, Cast iron Stal węglowa, stal konstrukcyjna, żeliwo		Carbon Steel, Alloy Steel Stal węglowa, stal stopowa		Alloy Steel, Tool Steel, Prehardened Steel Stal stopowa, stal narzędziowa, stal ulepszona		Alloy steel, tool steel, austenitic stainless steel Stal stopowa, narzędziowa, nierdzewna austenityczna			
			<20 HRC		20 - 30HRC		30 - 35HRC		35 - 40HRC			
			<500 N/mm ²		500 - 800N/mm ²		800 - 1000N/mm ²		1000 - 1100N/mm ²		1100 - 1300N/mm ²	
d1(mm)	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
2	0,2	3	9200	290	8400	240	6100	170	4100	125	3300	85
3	0,3	4,5	6600	410	6000	350	4400	250	2700	180	2400	125
4	0,4	6	5300	480	4700	400	3600	300	2300	200	2000	150
5	0,5	7,5	4400	510	4000	420	2900	320	2000	220	1700	160
6	0,6	9	3900	540	3600	450	2600	330	1800	230	1450	180
8	0,8	12	3100	570	2600	480	2000	370	1400	240	1150	185
10	1	15	2300	630	2100	530	1600	380	1000	265	890	200
12	1,2	18	2000	570	1800	480	1400	370	890	240	720	185
14	1,4	21	1800	550	1600	460	1100	350	790	230	630	170
16	1,6	24	1600	510	1400	430	1000	340	680	220	550	165
18	1,8	27	1500	460	1250	400	890	310	630	195	500	150
20	2	30	1250	440	1050	370	780	275	530	175	440	140
22	2,2	33	1050	410	950	320	680	255	470	160	400	130
25	2,5	37,5	1000	370	840	305	630	230	420	150	360	125

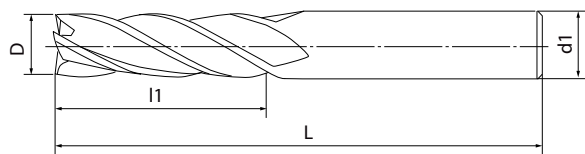
	D 0 — 30		
	d1 h6		

 UFG
 UFX
 UFJ
 UFD
 UFA
 UFC
 PMT
 UCX
 RB
 CBN
 HSS
 ICT

PMT31
SQUARE TYPE WALCOWO-CZOŁOWE

4-Flute, Long Length 4-ostrzowy, długi

P		H		M		K	N			S				
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	TI 200-410 GB



D code new Nowy kod	D code Kod	D	d1	L	l1	Z	Shank Uchwyt
PMT31020000A06010054	PMT31020	2	6	54	10	4	B
PMT31030000A06012056	PMT31030	3	6	56	12	4	B
PMT31040000A06019063	PMT31040	4	6	63	19	4	B
PMT31050000A06024068	PMT31050	5	6	68	24	4	B
PMT31060000A06024068	PMT31060	6	6	68	24	4	B
PMT31070000A10030080	PMT31070	7	10	80	30	4	B
PMT31080000A10038088	PMT31080	8	10	88	38	4	B
PMT31090000A10038088	PMT31090	9	10	88	38	4	B
PMT31100000A10045095	PMT31100	10	10	95	45	4	B
PMT31120000A12053110	PMT31120	12	12	110	53	4	B
PMT31140000A12053110	PMT31140	14	12	110	53	4	B
PMT31160000A16063123	PMT31160	16	16	123	63	4	B
PMT31180000A16063123	PMT31180	18	16	123	63	4	B
PMT31200000A20075141	PMT31200	20	20	141	75	4	B
PMT31220000A20075141	PMT31220	22	20	141	75	4	B
PMT31250000A25090166	PMT31250	25	25	166	90	4	B

Cutting Conditions Parametry skrawania

Material Materiał	Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural Steel, Carbon Steel, Cast iron Stal węglowa, stal konstrukcyjna, żeliwo		Carbon Steel, Alloy Steel Stal węglowa, stal stopowa		Alloy Steel, Tool Steel, Prehardened Steel Stal stopowa, stal narzędziowa, stal ulepszona		Alloy steel, tool steel, austenitic stainless steel Stal stopowa, narzędziowa, nierdzewna austenityczna			
			<20 HRC		20 - 30HRC		30 - 35HRC		35 - 40HRC			
			<500 N/mm ²		500 - 800N/mm ²		800 - 1000N/mm ²		1000 - 1100N/mm ²		1100 - 1300N/mm ²	
d1(mm)	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
2	0,2	3	9200	290	8400	240	6100	170	4100	125	3300	85
3	0,3	4,5	6600	410	6000	350	4400	250	2700	180	2400	125
4	0,4	6	5300	480	4700	400	3600	300	2300	200	2000	150
5	0,5	7,5	4400	510	4000	420	2900	320	2000	220	1700	160
6	0,6	9	3900	540	3600	450	2600	330	1800	230	1450	180
8	0,8	12	3100	570	2600	480	2000	370	1400	240	1150	185
10	1	15	2300	630	2100	530	1600	380	1000	265	890	200
12	1,2	18	2000	570	1800	480	1400	370	890	240	720	185
14	1,4	21	1800	550	1600	460	1100	350	790	230	630	170
16	1,6	24	1600	510	1400	430	1000	340	680	220	550	165
18	1,8	27	1500	460	1250	400	890	310	630	195	500	150
20	2	30	1250	440	1050	370	780	275	530	175	440	140
22	2,2	33	1050	410	950	320	680	255	470	160	400	130
25	2,5	37,5	1000	370	840	305	630	230	420	150	360	125



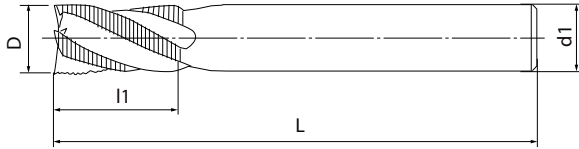
D 0 — 30

d1 h6

PMT41
SQUARE TYPE WALCOWO-CZOŁOWE

Multi Flute, Fine Pitch Wielostrzowy, łamacz drobny

P			H		M		N			S				
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB
•	•							•	•	•	○	•	•	



D code new Nowy kod	D code Kod	D	d1	L	l1	Z	Shank Uchwyt
PMT4106000A06013057	PMT41060	6	6	13	57	3	B
PMT4107000A10016066	PMT41070	7	10	16	66	3	B
PMT4108000A10019069	PMT41080	8	10	19	69	3	B
PMT4109000A10019069	PMT41090	9	10	19	69	3	B
PMT4110000A10022072	PMT41100	10	10	22	72	4	B
PMT4112000A12026083	PMT41120	12	12	26	83	4	B
PMT4114000A12026083	PMT41140	14	12	26	83	4	B
PMT4116000A16032092	PMT41160	16	16	32	92	4	B
PMT4118000A16032092	PMT41180	18	16	32	92	4	B
PMT4120000A20038104	PMT41200	20	20	38	104	4	B
PMT4122000A20038104	PMT41220	22	20	38	104	5	B
PMT4125000A25045121	PMT41250	25	25	45	121	5	B

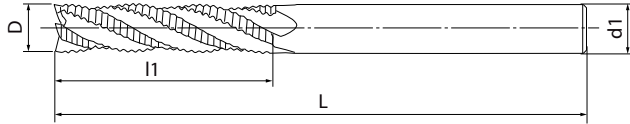
Cutting Conditions Parametry skrawania

			Structural steels, carbon steels Stal konstrukcyjna, węglowa		Carbon Steel, Cast iron Stal węglowa, żeliwo		Carbon Steel, Alloy Steel Stal węglowa, stal stopowa		Alloy Steel, Tool Steel, Prehardened Steel Stal stopowa, stal narzędziowa, stal ulepszona		Stainless steel Stal nierdzewna		
			<20 HRC		20 - 30HRC		30 - 40HRC		30 - 40HRC				
d1 (mm)			-500N/mm ²		500 - 800N/mm ²		800 - 1000N/mm ²		1000 - 1300N/mm ²		1000 - 1300N/mm ²		
ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
6	3	9	2800	230	2200	180	1600	115	1300	105	1300	105	
8	4	12	2400	290	1900	230	1400	160	1050	125	1050	125	
10	5	15	1900	415	1500	315	1050	195	890	160	890	160	
12	6	18	1600	415	1200	330	900	230	740	180	740	180	
14	7	21	1400	415	1050	330	760	230	630	180	630	180	
16	8	24	1200	415	950	330	660	230	550	180	550	180	
18	9	27	1050	415	890	330	610	230	490	180	490	180	
20	10	30	960	425	760	330	530	230	440	180	440	180	
22	11	33	890	425	650	330	470	230	400	180	400	180	
25	12,5	37,5	790	415	600	315	420	220	360	180	360	180	

PMT35
SQUARE TYPE WALCOWO-CZOŁOWE

Multi Flute, Fine Pitch Wieloostrzowy, łamacz drobny

P		H		M		K		N		S				
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB



D code new Nowy kod	D code Kod	D	d1	L	l1	Z	Shank Uchwyt
PMT35060000A06024068	PMT35060	6	6	24	68	3	B
PMT35070000A10030080	PMT35070	7	10	30	80	3	B
PMT35080000A10038088	PMT35080	8	10	38	88	3	B
PMT35090000A10038088	PMT35090	9	10	38	88	3	B
PMT35100000A10045095	PMT35100	10	10	45	95	4	B
PMT35120000A12053110	PMT35120	12	12	53	110	4	B
PMT35140000A12053110	PMT35140	14	12	53	110	4	B
PMT35160000A16063123	PMT35160	16	16	63	123	4	B
PMT35180000A16063123	PMT35180	18	16	63	123	4	B
PMT35200000A20075141	PMT35200	20	20	75	141	4	B
PMT35220000A20075141	PMT35220	22	20	75	141	5	B
PMT35250000A25090166	PMT35250	25	25	90	166	5	B

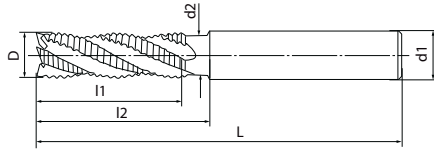
Cutting Conditions Parametry skrawania

			Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural steels, carbon steels, cast irons Stal konstrukcyjna, węglowa, żeliwo		Carbon steels, alloy steels, tool steels Stal węglowa, stopowa, narzędziowa		Prehardened steels, alloy steels, tool steels Stal ulepszona, stopowa, narzędziowa	
			<500 N/mm ²		500 - 800 N/mm ²		800 - 1000 N/mm ²		1000 - 1200 N/mm ²	
D1 mm	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
6	3	9	2800	230	2200	180	1600	115	1300	105
8	4	12	2400	290	1900	230	1400	160	1050	125
10	5	15	1900	415	1500	315	1050	195	890	160
12	6	18	1600	415	1200	330	900	230	740	180
14	7	21	1400	415	1050	330	760	230	630	180
16	8	24	1200	415	950	330	660	230	550	180
18	9	27	1050	415	890	330	610	230	490	180
20	10	30	960	425	760	330	530	230	440	180
22	11	33	890	425	650	330	470	230	400	180
25	12,5	37,5	790	415	600	315	420	220	360	180

PMT26

SQUARE TYPE WALCOWO-CZOŁOWE
Multi Flute, Short Wielostrzowy, krótkie

P		H		M		K		N		S				
<750 N/mm2	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB
•	•							•	•	•	•	•	•	•



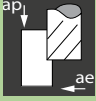
D code HA Kod HA	D code HB Kod HB	D	d1	d2	L	l1	l2	Z	Shank Uchwyt
PMT26040000A06000057	PMT26040000B06000057	4	6	-	57	11		3	A/B
PMT26050000A06000057	PMT26050000B06000057	5	6	-	57	13		4	A/B
PMT26060000A06000057	PMT26060000B06000057	6	6	-	57	13		4	A/B
PMT26070000A10000066	PMT26070000B10000066	7	10	-	66	16		4	A/B
PMT26080000A10000069	PMT26080000B10000069	8	10	-	69	19		4	A/B
PMT26090000A10000069	PMT26090000B10000069	9	10		69	19		4	A/B
PMT26100000A10031072	PMT26100000B10031072	10	10	9,5	72	22	31	4	A/B
PMT26120000A12037083	PMT26120000B12037083	12	12	11,5	83	26	37	4	A/B
PMT26140000A12000083	PMT26140000B12000083	14	12	-	83	26		5	A/B
PMT26160000A16044092	PMT26160000B16044092	16	16	15	92	32	44	5	A/B
PMT26180000A16000092	PMT26180000B16000092	18	16	-	92	32		6	A/B
PMT26200000A20054104	PMT26200000B20054104	20	20	19	104	38	54	6	A/B
PMT26250000A25063121	PMT26250000B25063121	25	25	24	121	45	63	6	A/B

	D ≤ 6	± 60	D ≤ 6	0 — -8
	d1 ≤ 10	± 75	d1 ≤ 10	0 — -9
	D ≤ 18	± 90	d1 ≤ 18	0 — -11
	d1 ≤ 30	± 105	d1 ≤ 30	0 — -13

PMT26

Cutting Conditions Parametry skrawania

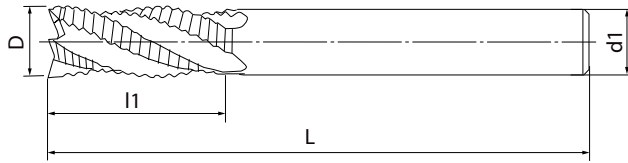
SIDE MILLING / FREZOWANIE OBWODOWE

			Structural steels, carbon steels Stal konstrukcyjna, węglowa		Structural steels, carbon steels, cast irons Stal konstrukcyjna, węglowa, żeliwo		Carbon steels, alloy steels, tool steels Stal węglowa, stopowa, narzędziowa		Prehardened steels, alloy steels, tool steels Stal ulepszona, stopowa, narzędziowa		Stainless steel Stal nierdzewna	
			<500 N/mm ²		500 - 800 N/mm ²		800 - 1000 N/mm ²		1000 - 1200 N/mm ²			
			<20 HRC		20 - 30 HRC		30 - 40 HRC					
D1 mm	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
6	3	9	2800	230	2200	180	1600	115	1300	105	1450	110
8	4	12	2400	290	1900	230	1400	160	1050	125	1200	140
10	5	15	1900	415	1500	315	1050	195	890	160	950	170
12	6	18	1600	415	1200	330	900	230	740	180	800	205
14	7	21	1400	415	1050	330	760	230	630	180	690	205
16	8	24	1200	415	950	330	660	230	550	180	600	205
18	9	27	1050	415	890	330	610	230	490	180	550	205
20	10	30	960	425	760	330	530	230	440	180	480	205
22	11	33	890	425	650	330	470	230	400	180	430	205
25	12,5	37,5	790	415	600	315	420	220	360	180	390	200
25	12,5	37,5	1253	738	947	558	626	369	474	250		

PMT33
SQUARE TYPE WALCOWO-CZOŁOWE

Croase Form, Short Łamacz zgrubny, krótkie

P	H	M	K	N			S							
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB



D code new Nowy kod	D code Kod	D	d1	L	l1	Z	Shank Uchwyt
PMT33060000A06013057	PMT33060	6	6	57	13	3	B
PMT33070000A10016066	PMT33070	7	10	66	16	3	B
PMT33080000A10019069	PMT33080	8	10	69	19	3	B
PMT33090000A10019069	PMT33090	9	10	69	19	3	B
PMT33100000A10022072	PMT33100	10	10	72	22	4	B
PMT33120000A12026083	PMT33120	12	12	83	26	4	B
PMT33140000A12026083	PMT33140	14	12	83	26	4	B
PMT33160000A16032092	PMT33160	16	16	92	32	4	B
PMT33180000A16032092	PMT33180	18	16	92	32	4	B
PMT33200000A20038104	PMT33200	20	20	104	38	4	B
PMT33220000A20038104	PMT33220	22	20	104	38	5	B
PMT33250000A25045121	PMT33250	25	25	121	45	5	B

PMT33

Cutting Conditions Parametry skrawania

SIDE MILLING / FREZOWANIE OBWODOWE

			Structural steel, carbon steel Stal konstrukcyjna, węglowa		Structural steel, carbon steel, cast iron Stal konstrukcyjna, węglowa, żeliwo		Carbon steel, alloy steel, tool steel Stal węglowa, stopowa, narzędziowa		Prehardened steel, alloy steel, tool steel Stal ulepszona, stopowa, narzędziowa	
			500N/mm ²		500 - 800N/mm ²		800 - 1000N/mm ²		1000 - 1200N/mm ²	
			d1(mm)	ae	ap	RPM	mm/min	RPM	mm/min	RPM
6	3	9	2800	230	2200	180	1600	115	1300	105
8	4	12	2400	290	1900	230	1400	160	1050	125
10	5	15	1900	415	1500	315	1050	195	890	160
12	6	18	1600	415	1200	330	900	230	740	180
14	7	21	1400	415	1050	330	760	230	630	180
16	8	24	1200	415	950	330	660	230	550	180
18	9	27	1050	415	890	330	610	230	490	180
20	10	30	960	425	760	330	530	230	440	180
22	11	33	890	425	650	330	470	230	400	180
25	12,5	37,5	790	415	600	315	420	220	360	180

	D ≤ 6	± 60	D ≤ 6	0 — -8
	d1 ≤ 10	± 75	d1 ≤ 10	0 — -9
	D ≤ 18	± 90	d1 ≤ 18	0 — -11
	d1 ≤ 30	± 105	d1 ≤ 30	0 — -13

PMT34
SQUARE TYPE WALCOWO-CZOŁOWE
 Multi Flute, Short Wielostrzowy, krótkie

P	H	M	K	N	S									
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB



D code new Nowy kod	D code Kod	D	d1	L	l1	Z	Shank Uchwyt
PMT34060000A06024068	PMT34060	6	6	68	24	3	B
PMT34070000A10030080	PMT34070	7	10	80	30	3	B
PMT34080000A10038088	PMT34080	8	10	88	38	3	B
PMT34090000A10038088	PMT34090	9	10	88	38	3	B
PMT34100000A10045095	PMT34100	10	10	95	45	4	B
PMT34120000A12053110	PMT34120	12	12	110	53	4	B
PMT34140000A12053110	PMT34140	14	12	110	53	4	B
PMT34160000A16063123	PMT34160	16	16	123	63	4	B
PMT34180000A16063123	PMT34180	18	16	123	63	4	B
PMT34200000A20075141	PMT34200	20	20	141	75	4	B
PMT34220000A20075141	PMT34220	22	20	141	75	5	B
PMT34250000A25090166	PMT34250	25	25	166	90	5	B

Cutting Conditions Parametry skrawania

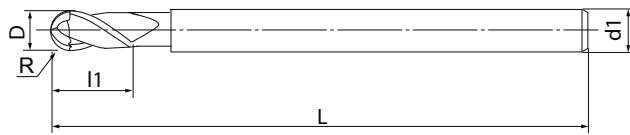
			Structural steel, carbon steel Stal konstrukcyjna, węglowa		Structural steel, carbon steel, cast iron Stal konstrukcyjna, węglowa, żeliwo		Carbon steel, alloy steel, tool steel Stal węglowa, stopowa, narzędziowa		Prehardened steel, alloy steel, tool steel Stal ulepszona, stopowa, narzędziowa	
			<500N/mm ²		<20HRC		20 - 30HRC		30 - 40HRC	
d1(mm)	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
6	3	9	2800	230	2200	180	1600	115	1300	105
8	4	12	2400	290	1900	230	1400	160	1050	125
10	5	15	1900	415	1500	315	1050	195	890	160
12	6	18	1600	415	1200	330	900	230	740	180
14	7	21	1400	415	1050	330	760	230	630	180
16	8	24	1200	415	950	330	660	230	550	180
18	9	27	1050	415	890	330	610	230	490	180
20	10	30	960	425	760	330	530	230	440	180
22	11	33	890	425	650	330	470	230	400	180
25	12,5	37,5	790	415	600	315	420	220	360	180

μm	D ≤ 10	± 75	d1 ≤ 18	0 — -11
	D ≤ 18	± 90	d1 ≤ 30	0 — -13
	D ≤ 30	± 105		
	d1 ≤ 10	0 — -9		

PMT40

BALL NOSE KULISTE 2-Flute, Short Length 2-ostrzowe, krótkie

			HSM V _{max}	M	R		B							AIR
P			H		M		K	N				S		
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB
•	•							•	•	•	○		•	•



D code new Nowy kod	D code Kod	R	D	d1	L	l1	Z	Shank Uchwyt
PMT40010005A06003047	PMT40010	0,5	1	6	47	2,5	2	B
PMT40020010A06004048	PMT40020	1	2	6	48	4	2	B
PMT40030015A06005049	PMT40030	1,5	3	6	49	5	2	B
PMT40040020A06007051	PMT40040	2	4	6	51	7	2	B
PMT40050025A06008052	PMT40050	2,5	5	6	52	8	2	B
PMT40060030A06008052	PMT40060	3	6	6	52	8	2	B
PMT40070035A10010060	PMT40070	3,5	7	10	60	10	2	B
PMT40080040A10011061	PMT40080	4	8	10	61	11	2	B
PMT40090045A10011061	PMT40090	4,5	9	10	61	11	2	B
PMT40100050A10013063	PMT40100	5	10	10	63	13	2	B
PMT40120060A12016073	PMT40120	6	12	12	73	16	2	B
PMT40140070A12016073	PMT40140	7	14	12	73	16	2	B
PMT40160080A16019079	PMT40160	8	16	16	79	19	2	B
PMT40180090A16019079	PMT40180	9	18	16	79	19	2	B
PMT40200100A20022088	PMT40200	10	20	20	88	22	2	B
PMT40220110A20022088	PMT40220	11	22	20	88	22	2	B
PMT40250125A25026102	PMT40250	12,5	25	25	102	26	2	B

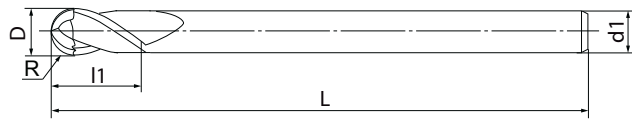
Cutting Conditions Parametry skrawania

			Structural steel, carbon steel Stal konstrukcyjna, węglowa		Structural steel, carbon steel, cast iron Stal konstrukcyjna, węglowa, żeliwo		Carbon steel, alloy steel, tool steel Stal węglowa, stopowa, narzędziowa		Prehardened steel, alloy steel, tool steel Stal ulepszona, stopowa, narzędziowa	
			<500N/mm ²		<20HRC		20 - 30HRC		30 - 40HRC	
			500 - 800N/mm ²		800 - 1000N/mm ²		1000 - 1200N/mm ²			
d1(mm)	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
3	1,5	0,6	7300	340	5800	230	3900	125	2000	55
4	2	0,8	6000	430	4620	290	3000	160	1600	75
6	3	1,2	4400	480	3500	320	2300	180	1200	85
8	4	1,3	3350	530	2600	350	1800	200	890	85
10	5	2	2750	600	2100	400	1400	230	680	102
12	6	2,4	2300	530	1800	350	1200	200	580	85
16	8	3,2	1700	480	1300	320	890	180	440	80
20	10	4	1350	420	1000	280	680	150	360	70
25	12,5	5	950	310	740	210	470	115	250	52

	D 30 — 0		±0,02
	d1 h6		

PMT32
BALL NOSE KULISTE
 2-Flute, Long Length 2-ostrzowe, długie

			HSM V _{max}	M	R	B								AIR
P			H		M		K	N				S		
<750 N/mm ²	<30 HRC	<42 HRC	<55 HRC	<65 HRC	<70 HRC	<250 HB	<320 HB	GG	Al 100 HB	Al, Si <10% 130HB	CU, ZN 35-300 HB	GFK	NICO 200-300 HB	Ti 200-410 GB
•	•							•	•	•	○		•	•



D code new Nowy kod	D code Kod	R	D	d1	L	l1	Z	Shank Uchwyt
PMT32020010A06007054	PMT32020	1	2	6	54	7	2	B
PMT32030015A06008056	PMT32030	1,5	3	6	56	8	2	B
PMT32040020A06011063	PMT32040	2	4	6	63	11	2	B
PMT32050025A06013068	PMT32050	2,5	5	6	68	13	2	B
PMT32060030A06013068	PMT32060	3	6	6	68	13	2	B
PMT32070035A10016080	PMT32070	3,5	7	10	80	16	2	B
PMT32080040A10019088	PMT32080	4	8	10	88	19	2	B
PMT32090045A10019088	PMT32090	4,5	9	10	88	19	2	B
PMT32100050A10022095	PMT32100	5	10	10	95	22	2	B
PMT32120060A12026110	PMT32120	6	12	12	110	26	2	B
PMT32140070A12026110	PMT32140	7	14	12	110	26	2	B
PMT32160080A16032123	PMT32160	8	16	16	123	32	2	B
PMT32180090A16032123	PMT32180	9	18	16	123	32	2	B
PMT32200100A20038141	PMT32200	10	20	20	141	38	2	B
PMT32220110A20038141	PMT32220	11	22	20	141	38	2	B
PMT32250125A25045166	PMT32250	12,5	25	25	166	45	2	B

Cutting Conditions Parametry skrawania

			Structural steel, carbon steel Stal konstrukcyjna, węglowa		Structural steel, carbon steel, cast iron Stal konstrukcyjna, węglowa, żeliwo		Carbon steel, alloy steel, tool steel Stal węglowa, stopowa, narzędziowa		Prehardened steel, alloy steel, tool steel Stal ulepszona, stopowa, narzędziowa	
			<500N/mm ²		<20HRC		20 - 30HRC		30 - 40HRC	
			500 - 800N/mm ²		800 - 1000N/mm ²		1000 - 1200N/mm ²			
d1(mm)	ae	ap	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
3	1,5	0,6	7300	340	5800	230	3900	125	2000	55
4	2	0,8	6000	430	4620	290	3000	160	1600	75
6	3	1,2	4400	480	3500	320	2300	180	1200	85
8	4	1,3	3350	530	2600	350	1800	200	890	85
10	5	2	2750	600	2100	400	1400	230	680	102
12	6	2,4	2300	530	1800	350	1200	200	580	85
16	8	3,2	1700	480	1300	320	890	180	440	80
20	10	4	1350	420	1000	280	680	150	360	70
25	12,5	5	950	310	740	210	470	115	250	52

	D 30 — 0		±0,02
	d1 h6		