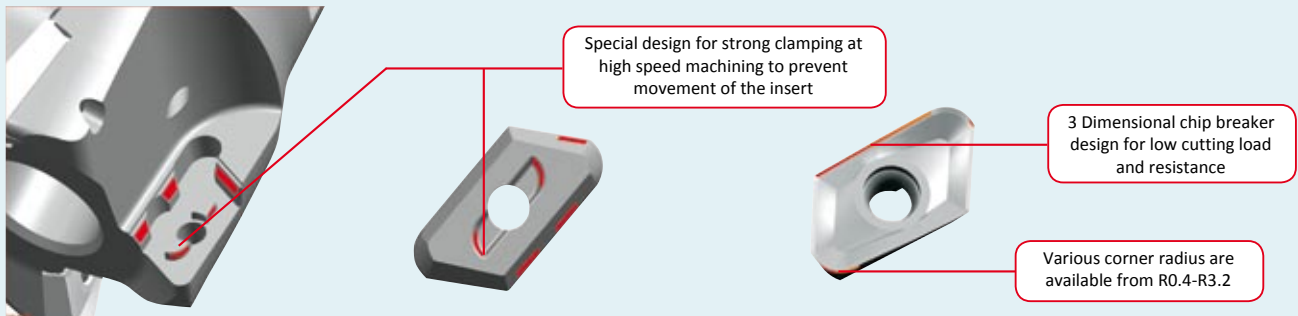


Pro-X Mill Features

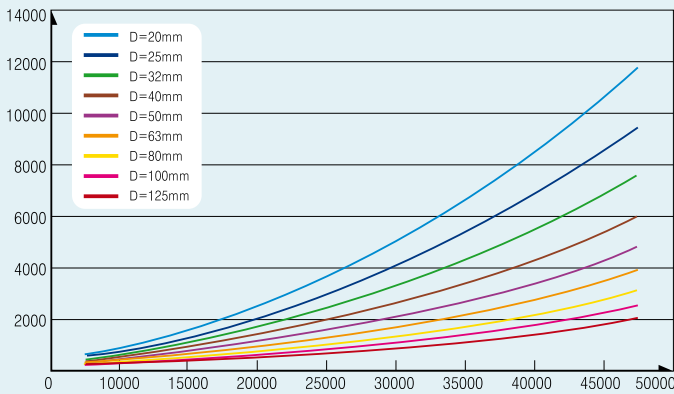
- Specially designed for machining aluminium, copper, plastic & brass
- Ultra strong clamping for high speed high metal removal
- Highly polished inserts prevents built up edge and good chip flow
- 19mm edge length for extra large depths of cut
- Precision balanced for machining at extreme speeds
- Through coolant



Clamping system for high speed machining



Centrifugal force as per RPM



Max RPM as per cutting diameter

Diameter ØD	Maximum RPM	
	n(min ⁻¹)	vc(m/min)
20	15,000	940
25	32,600	2,559
32	28,800	2,894
40	25,800	3,240
50	23,000	3,611
63	20,500	4,055
80	18,200	4,572
100	16,300	5,118
125	14,600	5,731

Recommended cutting conditions

Workpiece		Surface speed (m/min)	Feed fz (mm/t)
Aluminium alloy	RM < 280 MPa)	1,200	0.3
	RM > 280 MPa)	1,000	0.25
Copper alloy Thermo plastic	Long chipping	400 350	0.2 0.15
Aluminium alloy	Si < 12%	1,000	0.25
	Si > 12%	-	-
Copper alloy	Short chipping	500	0.2
Magnesium alloy	-	450	0.2
Duroplastics	-	200	0.15

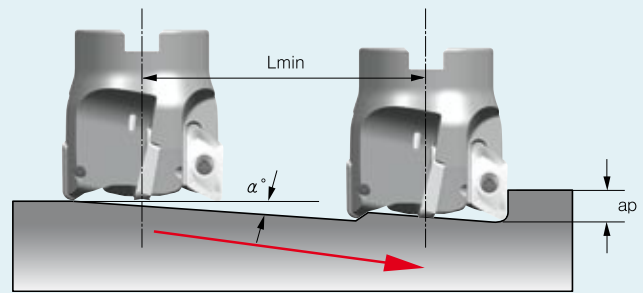
Ramping Data

PAXCM 5000 SERIES

Tool Dia	Ramping angle (a°) max	Lmin (mm)
40	11.31	50
50	7.24	78
63	5.1	112
80	3.86	148
100	3.94	145
125	2.14	267

PAXS 5000 SERIES

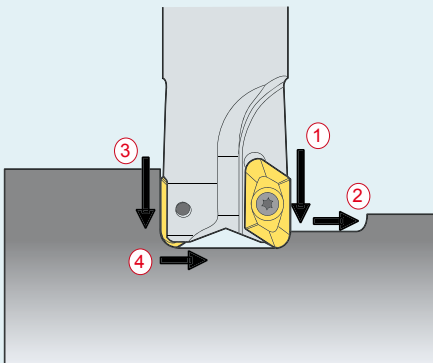
Tool Dia	Ramping angle (a°) max	Lmin (mm)
20	8.3	68
25	17.95	31
32	12.6	45
40	9.9	57



Lmin : Min. inclination cutting length
 a° : Max. ramping angle
 ap : Depth of cut

$$Lmin = \frac{ap}{\tan a^\circ} \text{ (mm)}$$

Plunging, Slotting and Drilling Data

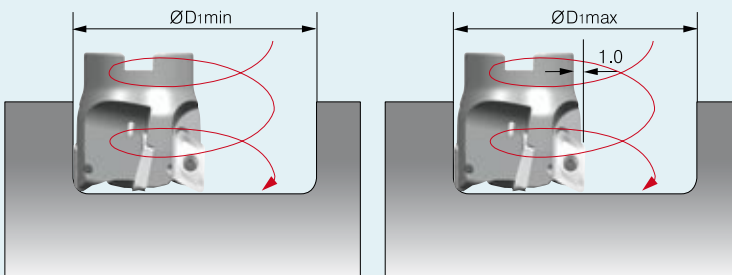


Cutting conditions for drilling

Tool Dia ØD	Maximum depth of cut ap(mm)
20	8
25	4
32	4
40-125	4

- When drilling, grooving machining sequence is 1 > 2 > 3 > 4
- When drilling, decrease the feed and cutting speed 30% ~ 50% from the recommended data

Helical Ramping Technical Data

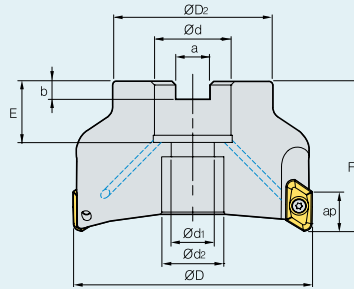
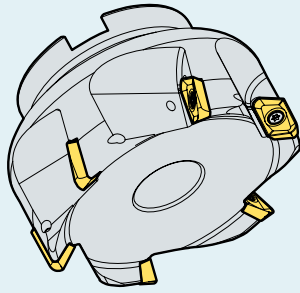


Tool Dia ØD	ØD1 Min	ØD1 Max
20	22	33
25	29	43
32	43	57
40	59	73
50	79	93
63	105	119
80	139	153
100	179	193
125	229	243

Pro-X Mill PAXCM 5000 SERIES



AA 90°



DESIGNATION	£		STOCK STATUS	ØD	ØD2	Ød	Ød1	Ød2	a	b	E	F	a° (MAX)	MAX RPM	ap	kg
PAXCM 5000 SERIES 5040HR-A	£109.00	3	●	40	34	16	9	14	8.4	5.6	19	40	11.31	25,800	17	0.15
5050HR-A	£116.00	4	●	50	42	22	11	18	10.4	6.3	21	50	7.24	23,000	17	0.3
5063HR-A	£129.00	4	●	63	49	22	11	18	10.4	6.3	21	50	5.1	20,500	17	0.56
5080HR-A	£134.00	5	●	80	57	27	14	20	12.4	7	23	50	3.86	18,200	17	1
5100HR-A	£153.00	6	●	100	67	32	18	26	14.4	8	26	63	3.94	16,300	17	2.2
5125HR-A	£198.00	7	●	125	87	40	22	32	16.4	9	29	63	2.14	14,600	17	3.5

Stock Status ● Stock item (next day delivery) □ Non-stock item (7-10 days)

Insert selection by radius

Designation	Radius	Picture
XEKT19M504FR-MA H01	0.4	
XEKT19M508FR-MA H01	0.8	
XEKT19M512FR-MA H01	1.2	
XEKT19M516FR-MA H01	1.6	
XEKT19M520FR-MA H01	2.0	
XEKT19M530FR-MA H01	3.0	
XEKT19M532FR-MA H01	3.2	



Spares & Accessories

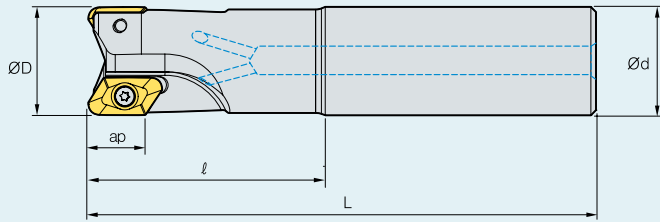
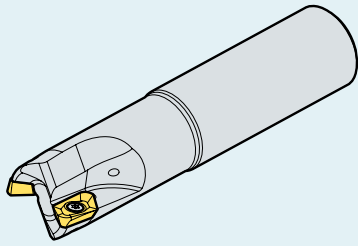
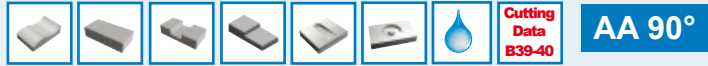
HOLDER SERIES	INSERT DESIGNATION	No EDGES	INSERT PAGE	SCREW	WRENCH	ARBORS
PAXCM 5000	XEKT19	2	B12	PTKA0408	TW15S	

Section G

Pro-X Mill Features

- Specially designed for machining aluminium, copper, plastic & brass
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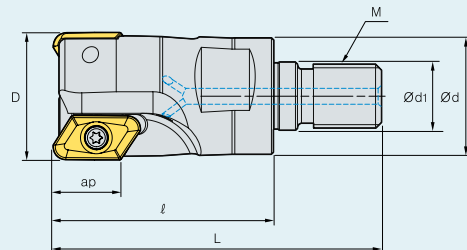
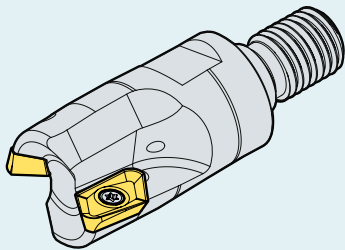
Pro-X Mill
PAXS 5000 SERIES



DESIGNATION	£	STOCK STATUS	ØD		Ød	ℓ	L	a° (MAX)	MAX RPM	ap	kg.
5020HR-A	£71.00	●	20	1	20	60	130	8.3	15,000	17	0.24
PAXS 5000 SERIES 5025HR-A	£79.00	●	25	2	25	60	140	17.95	32,600	17	0.4
5032HR-A	£84.00	●	32	2	32	70	150	12.6	28,800	17	0.74
5040HR-A	£114.00	●	40	3	40	70	160	9.91	25,800	17	1.0

Stock Status ● Stock item (next day delivery) □ Non-stock item (7-10 days)

Pro-X Mill
PAXM 5000 SERIES



DESIGNATION	£	STOCK STATUS	ØD		Ød	Ød1	ℓ	L	M	ap	kg.
PAXM 5000 SERIES 5025HR-A-M12	£168.00	●	25	2	23	12.5	55	76	M12	17	0.12
5032HR-A-M16	£173.00	●	32	2	29	17.0	55	79	M16	17	0.2
5040HR-A-M16	£189.00	□	40	3	29	17.0	55	82	M16	17	0.4

Stock Status ● Stock item (next day delivery) □ Non-stock item (7-10 days)

Spares & Accessories

HOLDER SERIES	INSERT DESIGNATION	No EDGES	INSERT PAGE	SCREW	WRENCH	END MILL HOLDERS	MODULAR ADAPTORS
PAXM 5000	XEKT19	2	B12	PTKA0407	TW15S		B50

Section G