



PM75

Cutting data

PM75E 4 Flute end mill												
MATERIAL GROUP	HRc		Size (mm)									
			6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0	
P	11	< 20	v_c (m/min)	70	70	77	77	77	77	77	77	77
	12		f_z	0.016	0.028	0.039	0.047	0.049	0.053	0.059	0.065	0.063
	13	20-35	v_c (m/min)	44	44	49	49	49	49	49	49	49
	14		f_z	0.016	0.028	0.038	0.047	0.050	0.052	0.059	0.066	0.065
M	21		v_c (m/min)	48	48	48	48	48	48	48	48	48
	22		f_z	0.018	0.029	0.048	0.056	0.060	0.063	0.071	0.077	0.078
K	31		v_c (m/min)	45	55	50	50	50	55	55	55	50
	34		f_z	0.018	0.028	0.038	0.047	0.050	0.052	0.059	0.066	0.065
S	51		v_c (m/min)	15	15	18	18	18	18	18	18	18
	52		f_z	0.016	0.024	0.039	0.047	0.049	0.053	0.059	0.065	0.063

1.5 x D

0.3 x D

0.5 x D

D

PM75S Roughing end mill												
MATERIAL GROUP	HRc		Size (mm)									
			6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0	25.0	
P	11	< 20	v_c (m/min)	60	69	68	65	66	69	72	68	68
	12		f_z	0.021	0.030	0.056	0.069	0.063	0.069	0.074	0.087	0.106
	13	20-35	v_c (m/min)	43	51	47	49	48	48	50	48	47
	14		f_z	0.018	0.028	0.046	0.063	0.061	0.069	0.086	0.086	0.107
M	21		v_c (m/min)	39	43	43	43	44	43	45	44	44
	22		f_z	0.019	0.030	0.045	0.064	0.059	0.069	0.075	0.084	0.104
K	31		v_c (m/min)	40	50	45	45	45	50	50	50	45
	34		f_z	0.020	0.030	0.053	0.069	0.063	0.069	0.062	0.072	0.088
S	51		v_c (m/min)	12	12	15	15	15	15	15	15	15
	52		f_z	0.018	0.028	0.042	0.061	0.055	0.066	0.060	0.069	0.082

Technical drawing of a roughing end mill showing a 1.5 x D cutting depth and a 0.5 x D chip thickness.

Recommended cutting depths are **maximum** depths, and **speeds and feeds** are a **starting point** based on these depths.
All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up.
For material guide, please refer to main catalogues.



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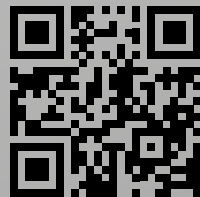
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PM75

Multiple Helix end mills.



High performance HSS-PM multiple helix 4-flute and roughing end mills to celebrate 75 years of Clarkson quality cutting tools.



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PM75

Clarkson PM75 multiple helix end mills are designed for excellent performance in a wide range of workpiece materials. The multiple helix geometry has variations to the helix angle along the length of the flute as well as differing angles on alternate flutes to reduce chatter and improve tool harmonics. The tools work exceptionally well in unstable cutting conditions.

We think these tools are among the best tools available to maximize productivity in a wide range of materials. If you would like to challenge us to improve your machining process, contact your local distributor to arrange for a demonstration.

All information in this brochure is provided in accordance with ISO13399.

High performance substrate.
HSS-PM base designed for extended tool life across a wide range of material groups.

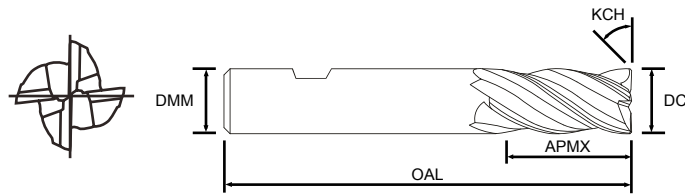
Unequal indexed flutes.
For reduced vibration and increased chip flow.

Multiple helix geometry.
For improved stability and reduced chatter giving better workpiece finishes.



Series No. PM75E

- Specially designed to reduce vibration and improve workpiece finish.
- Excellent performance in unstable conditions.



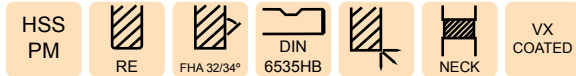
EUROPA CODE ORDCODE	SIZE DC	SHANK DIAMETER DMM	LENGTH OF CUT APMX	OVERALL LENGTH OAL	CHAMFER WIDTH CHW
PM75E0300	3.0	6	8	52	0.10
PM75E0400	4.0	6	11	55	0.15
PM75E0500	5.0	6	13	57	0.15
PM75E0600	6.0	6	13	57	0.20
PM75E0800	8.0	8	19	69	0.20
PM75E1000	10.0	10	22	72	0.30
PM75E1200	12.0	12	26	83	0.35
PM75E1400	14.0	12	26	83	0.35
PM75E1600	16.0	16	32	92	0.40
PM75E1800	18.0	16	32	92	0.40
PM75E2000	20.0	20	38	104	0.50
PM75E2500	25.0	25	45	121	0.50

P		H		M		K		S		N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●	●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	84
●	●				●	●	○	○							

For material guide, please refer to main catalogues.

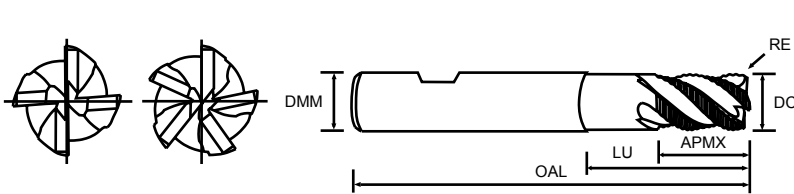
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PM75



Series No. PM75S

- Specially designed to reduce vibration and improve workpiece finish.
- Excellent performance in unstable conditions.



EUROPA CODE ORDCODE	SIZE DC	CORNER RADIUS RE	SHANK DIAMETER DMM	LENGTH OF CUT APMX	EFFECTIVE LENGTH LU	OVERALL LENGTH OAL	NECK DIAMETER DN	NO. OF FLUTES ZEFP
PM75S0600	6.0	0.5	6	13	-	57	5.5	4
PM75S0800	8.0	0.5	10	19	-	69	7.5	4
PM75S1000	10.0	0.5	10	22	31	72	9.2	4
PM75S1200	12.0	0.5	12	26	37	83	11.0	4
PM75S1400	14.0	1.0	12	26	-	83	13.0	5
PM75S1600	16.0	1.0	16	32	44	92	16.0	5
PM75S1800	18.0	1.0	16	32	-	92	17.0	5
PM75S2000	20.0	1.0	20	38	54	104	19.0	5
PM75S2500	25.0	1.0	25	45	63	121	24.0	5

P		H		M		K		S		N				O	
11	12	15	21	22	31	32	41	42	43	61	62	63	64	81	82
●	●		●	●	●	●									
13	14	16	23		33	34	51	52	53	71	72	73	74	83	84
●	●				●	●	○	○							

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