

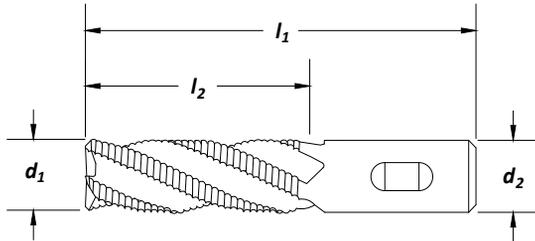
Rougher PM Plus™, Coarse Pitch

Styles: PM-538R - Single End
CLEVELAND

Note
Operating parameters
begin on page 310.


Surface Treatment

Bright TiCN


Feature:

For HIGH VOLUME aluminum roughing.

Powered Metal
Center Cutting

cutting diameter d_1	decimal equiv.	shank dia d_2 (in)	length of cut l_2 (in)	overall length l_1 (in)	no. of flutes	order number PM-538R			
						Bright 0° R	TiCN 0° R	TiCN .060° R	TiCN .120°
1/2	.5000	.500	1.250	3.250	3	C40003	C40015	-	-
1/2	.5000	.500	2.000	4.000	3	C40004	C40016	-	-
5/8	.6250	.625	1.625	3.750	3	C40005	C40017	-	-
5/8	.6250	.625	2.500	4.625	3	C40006	C40018	-	-
3/4	.7500	.750	1.625	3.875	3	C40007	C40019	C40033	C40035
3/4	.7500	.750	2.250	4.500	3	C40062	C40063	C40064	C40066
3/4	.7500	.750	3.000	5.250	3	C40008	C40020	C40036	C40038
1	1.0000	1.000	2.000	4.500	3	C40009	C40021	C40039	C40041
1	1.0000	1.000	3.000	5.500	3	C40010	C40022	C40042	C40044
1	1.0000	1.000	4.000	6.500	3	C40011	C40023	C40045	C40047
1-1/4	1.2500	1.250	2.000	4.500	3	C40048	C40049	C40050	C40052
1-1/4	1.2500	1.250	3.000	5.500	3	C40012	C40024	C40053	C40055
1-1/4	1.2500	1.250	4.000	6.500	3	C40013	C40025	C40056	C40058
1-1/4	1.2500	1.250	6.000	8.500	3	C40014	C40026	C40059	C40061
1-1/2	1.5000	1.250	2.000	4.500	3	C43244	C43246	-	-
1-1/2	1.5000	1.250	3.000	5.500	3	C43247	C43249	-	-
1-1/2	1.5000	1.250	4.000	6.500	3	C43250	C43252	-	-
1-1/2	1.5000	1.250	6.000	8.500	3	C43253	C43255	-	-

Material Reference	Steel (HRC)				Stainless Steel			Cast Iron (HRC)		Aluminum and Non-Ferrous	Hi-Temp Alloy		Hardened Steel (HRC)
	Low Carbon		Alloy		Austenitic	Martensitic	PH	Gray	Nodular		Ni, Co, Fe Based Super Alloy	Titanium	
	Hardness				300 Series	400 series		18-22	22-32				
Bright	13-38	>38	16-38	> 38						★			
TiCN										★			

★ = Best Performance ◆ = Acceptable