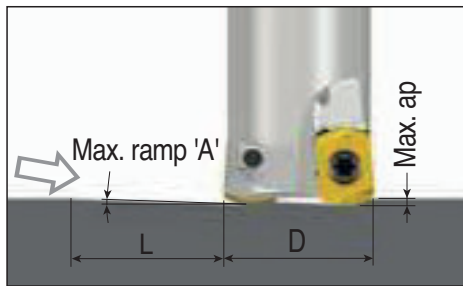
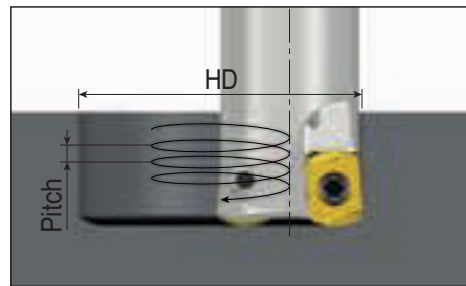


Straight ramping



Helical ramping

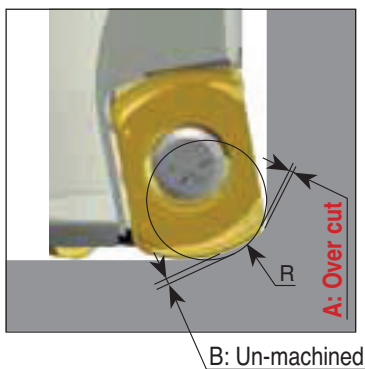


## BLMP 04

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down		
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.
Ø8	0.4	0.5	72	12.6		0.1
					16	0.1
Ø10	0.6	0.5	44	16.6		0.2
					20	0.2
Ø11	0.7	0.5	38	18.6		0.2
					22	0.3
Ø12	1.0	0.5	29	20.6		0.4
					24	0.4
Ø13	1.1	0.5	25	22.6		0.5
					26	0.5
Ø16	1.0	0.5	29	28.6		0.5
					32	0.5
Ø17	1.1	0.5	26	30.6		0.5
					34	0.5
Ø20	1.0	0.5	27	36.6		0.5
					40	0.5
Ø21	0.7	0.5	38	38.6		0.5
					42	0.5
Ø25	0.7	0.5	38	46.6		0.5
					50	0.5
Ø32	0.6	0.5	48	60.6		0.5
					64	0.5

## Programming technical data

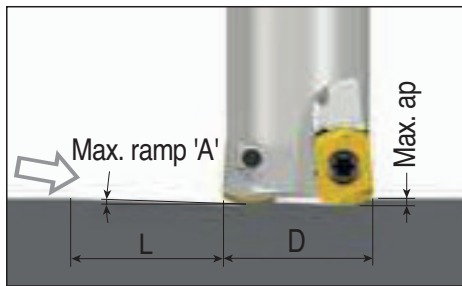


	R Program	A Over cut	B Un-machined
BLMP 04	0.8	0.00	0.28
	0.9	0.00	0.25
	1.0	0.08	0.22

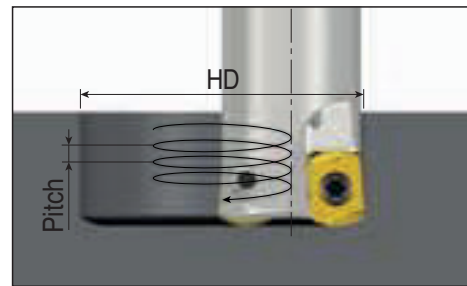
  : Recommended program 'R'

# Ramping Data

Straight ramping



Helical ramping

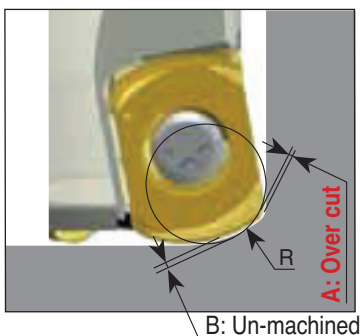


## BLMP 06

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down		
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.
Ø16	2.0	0.7	13	23	32	0.7
						0.7
Ø17	2.0	0.7	15	25	34	0.7
						0.7
Ø18	2.3	0.7	16	27	36	0.7
						0.7
Ø20	1.5	1.0	38	31	40	0.8
						1.0
Ø21	1.5	1.0	38	33	42	0.8
						1.0
Ø22	1.5	1.0	38	35	44	1.0
						1.0
Ø25	1.3	1.0	41	41	50	1.0
						1.0
Ø26	1.2	1.0	44	43	52	1.0
						1.0
Ø30	1.0	1.0	52	51	60	1.0
						1.0
Ø32	0.9	1.0	57	55	64	1.0
						1.0
Ø33	0.9	1.0	57	57	66	1.0
						1.0
Ø35	0.8	1.0	57	61	70	1.0
						1.0
Ø40	0.7	1.0	64	71	80	1.0
						1.0
Ø42	0.7	1.0	72	75	84	1.0
						1.0
Ø50	0.6	1.0	96	91	100	1.0
						1.0
Ø52	0.6	1.0	96	95	104	1.0
						1.0
Ø63	0.5	1.0	115	117	126	1.0
						1.0
Ø66	0.5	1.0	115	123	132	1.0
						1.0

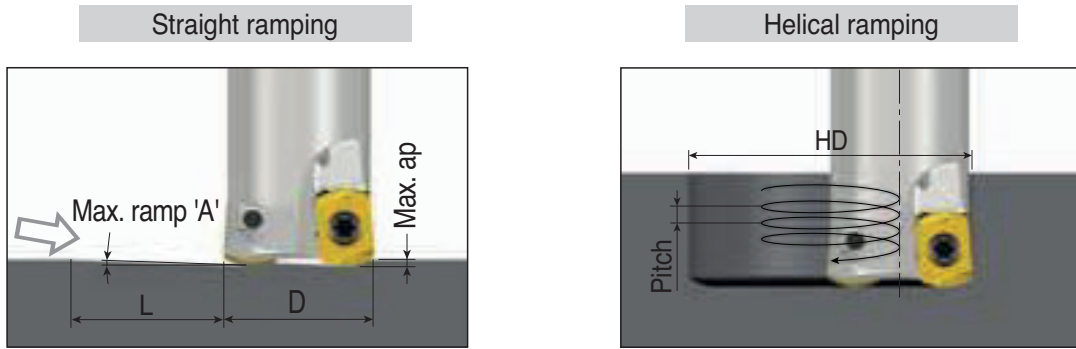
## Programming technical data



	R Program	A Over cut	B Un-machined
BLMP 06 (Ø16, Ø17, Ø18)	1.5	0	0.35
	2.0	0.1	0.22
	2.5	0.27	0.1
BLMP 06 (Ø20-)	2.0	0	0.42
	2.5	0.12	0.26
	3.0	0.29	0.17

     : Recommended program 'R'

# Ramping Data

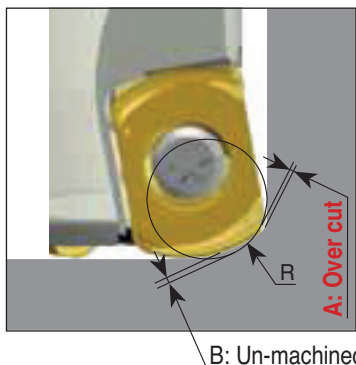


## BLMP 09

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down		
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.
Ø25	2.2	1.5	39	42	50	1.5
Ø26	2.2	1.5	39	44	52	1.5
Ø30	2.0	1.5	43	52	60	1.5
Ø32	2.0	1.5	43	56	64	1.5
Ø33	2.0	1.5	43	58	66	1.5
Ø35	2.0	1.5	43	60	70	1.5
Ø40	1.5	1.5	57	72	80	1.5
Ø42	1.5	1.5	57	76	84	1.5
Ø50	1.0	1.5	86	92	100	1.5
Ø52	1.0	1.5	86	96	104	1.5
Ø63	0.9	1.5	96	118	126	1.5
Ø66	0.9	1.5	96	124	132	1.5
Ø80	0.8	1.5	107	152	160	1.5
Ø100	0.7	1.5	123	192	200	1.5
Ø125	0.4	1.5	215	240	250	1.5

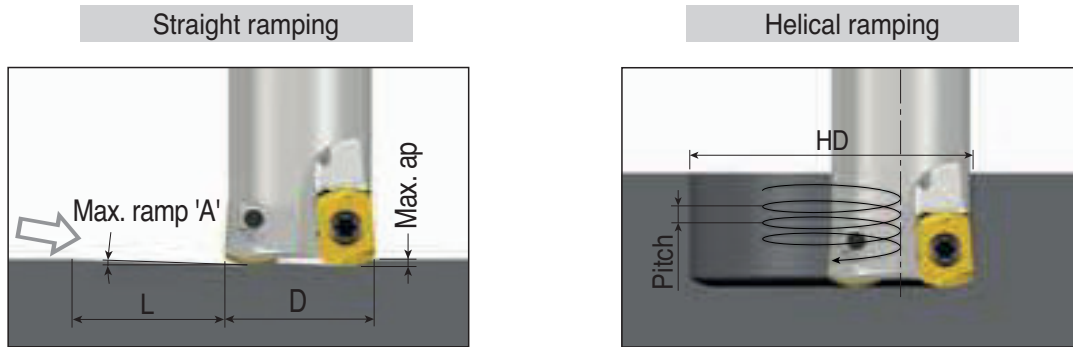
## Programming technical data



	R Program	A Over cut	B Un-machined
BLMP 09	2.5	0	0.61
	3.0	0.09	0.45
	3.5	0.24	0.30
	4.0	0.41	0.17
	3.0	0.36	0.04

**■** : Recommended program 'R'

# Ramping Data

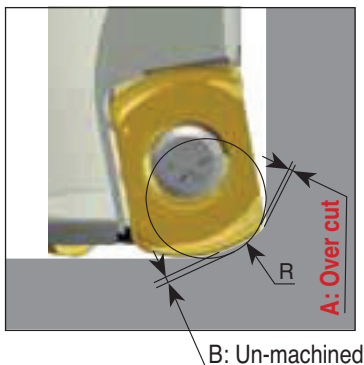


## BLMP 11

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down		
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.
Ø30	0.50	2.0	229	41		0.3
					60	0.7
Ø32	0.50	2.0	229	45		0.3
					64	0.7
Ø33	0.45	2.0	255	47		0.3
					66	0.7
Ø35	0.50	2.0	229	51		0.4
					70	0.8
Ø40	0.55	2.0	208	61		0.5
					80	1.0
Ø42	0.50	2.0	229	65		0.5
					84	1.0
Ø50	0.50	2.0	229	81		0.7
					100	1.2
Ø52	0.45	2.0	255	85		0.7
					104	1.1
Ø63	0.45	2.0	255	107		0.9
					126	1.3
Ø66	0.40	2.0	287	113		0.9
					132	1.2
Ø80	0.35	2.0	328	141		1.0
					160	1.3
Ø100	0.30	2.0	382	181		1.1
					200	1.4
Ø125	0.25	2.0	459	231		1.2
					250	1.5
Ø160	0.20	2.0	573	301		1.3
					320	1.5
Ø200	0.15	2.0	764	381		1.3
					400	1.4

## Programming technical data



	R Program	A Over cut	B Un-machined
BLMP 11	2.4	0.00	1.09
	3.0	0.00	0.90
	3.2	0.18	0.85

: Recommended program 'R'