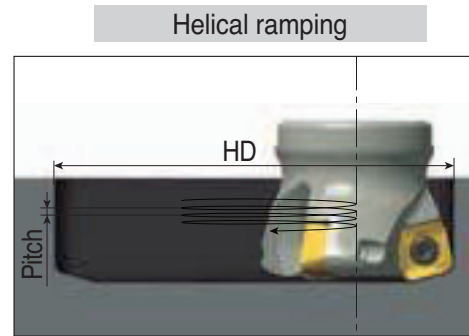
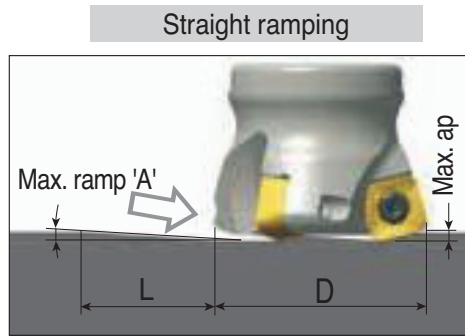


Ramping Data

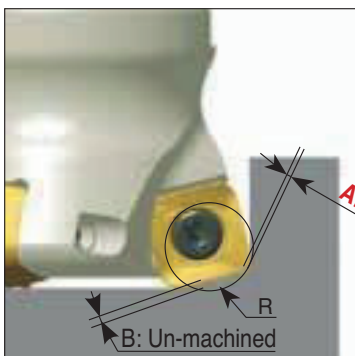


SBMT 09

(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	1.6	1.2	43	36	50	1.2
Ø26	1.7	1.2	40	38	52	1.2
Ø30	3.1	1.2	22	46	60	1.2
Ø32	3.9	1.2	18	50	64	1.2
Ø33	3.7	1.2	19	52	66	1.2
Ø35	3.4	1.2	18	56	70	1.2
Ø40	2.8	1.2	25	66	80	1.2
Ø42	2.6	1.2	26	70	84	1.2
Ø50	2	1.2	34	86	100	1.2
Ø52	1.9	1.2	38	90	104	1.2
Ø63	1.5	1.2	43	112	126	1.2
Ø66	1.1	1.2	63	118	132	1.2
Ø80	1.2	1.2	63	146	160	1.2

Programming technical data



	R Program	A Over cut	B Un-machined
SBMT 09	3.5	0.1	0.81
	3	0	0.9
	2.5	0	0.98
	2	0	1.1

 :Recommended program 'R'