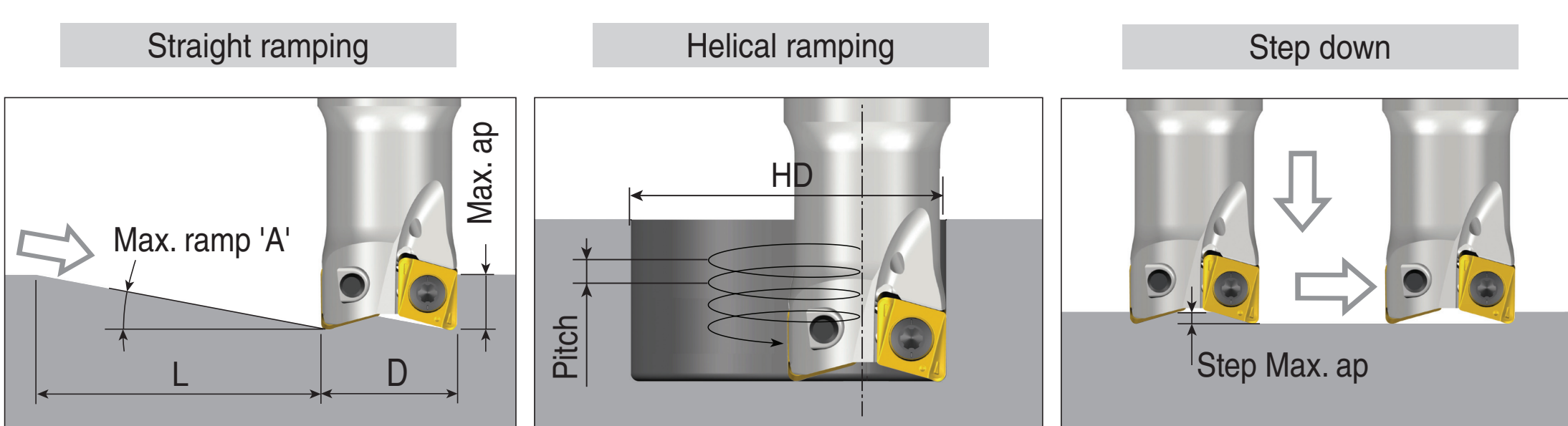


Ramping Data



4NKT 04: R0.2

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø8	4.2	3.5	48	9.9	16	0.4	0.4
Ø10	4.6	3.5	44	13.9	20	0.8	0.6
				15.9	22	1.2	
Ø12	4.8	3.5	42	17.9	24	1.3	0.8
				19.9	26	1.6	
Ø16	4.4	3.5	46	25.9	32	2.0	1.0
				33.9	40	3.1	
Ø20	3.3	3.5	61	43.9	50	2.2	1.0
				57.9	64	2.9	
Ø32	1.9	3.5	106	73.9	80	2.3	1.0
						2.8	
Ø40	1.4	3.5	138			2.3	1.0
						2.7	

4NKT 04: R0.4

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø8	3.7	3.5	54	9.9	16	0.3	0.4
Ø10	4.2	3.5	48	13.9	20	2.8	0.5
				15.9	22	0.8	
Ø12	4.8	3.5	42	17.9	24	1.1	0.6
				19.9	26	2.5	
Ø16	4.5	3.5	44	25.9	32	1.2	0.7
				33.9	40	1.5	
Ø20	4.7	3.5	43	43.9	50	1.9	0.8
				57.9	64	2.9	
Ø32	4.1	3.5	49	73.9	80	2.1	0.9
						3.1	
Ø40	3.1	3.5	65			2.0	0.9
						2.9	
Ø25	2.3	3.5	85	43.9	50	2.1	0.9
				57.9	64	2.7	
Ø32	1.7	3.5	115	73.9	80	2.1	0.9
						2.6	
Ø40	1.3	3.5	149			2.1	0.9
						2.5	

4NKT 04: R0.8

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø8	2.2	3.5	91	9.9	16	0.2	0.2
Ø10	3.0	3.5	67	13.9	20	1.6	0.4
				15.9	22	0.5	
Ø12	3.7	3.5	54	17.9	24	1.4	0.5
				19.9	26	0.8	
Ø16	3.5	3.5	57	25.9	32	1.9	0.5
				33.9	40	1.0	
Ø20	3.9	3.5	51	43.9	50	2.0	0.6
				57.9	64	1.3	
Ø32	3.5	3.5	57	73.9	80	2.4	0.7
						1.6	
Ø40	2.6	3.5	77			2.6	0.7
						1.7	
Ø25	1.9	3.5	103	43.9	50	2.4	0.7
				57.9	64	1.7	
Ø32	1.5	3.5	134	73.9	80	2.3	0.7
						1.7	
Ø40	1.1	3.5	174			2.2	0.7
						1.8	

4NHT 04: R0.5-F

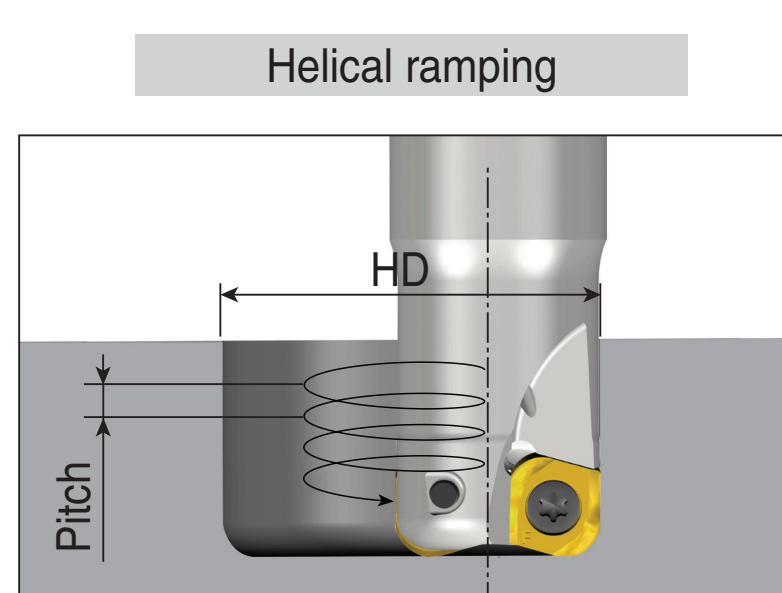
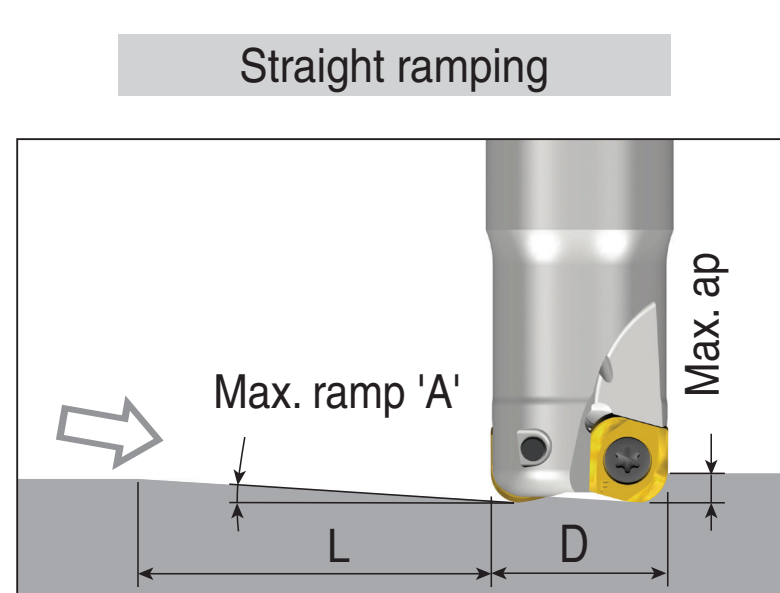
(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø8	3.4	2.2	37	9.9	16	0.3	0.3
Ø10	4.0	2.2	31	13.9	20	1.3	0.5
				15.9	22	0.7	
Ø12	4.6	2.2	27	17.9	24	1.9	0.6
				19.9	26	1.1	
Ø16	4.3	2.2	29	25.9	32	2.2	0.7
				33.9	40	1.2	
Ø20	4.6	2.2	27	43.9	50	1.5	0.8
				57.9	64	2.2	
Ø32	3.9	2.2	32	73.9	80	1.8	0.9
						2.2	
Ø40	2.9	2.2	43			2.2	0.9
						1.9	
Ø25	2.2	2.2	57	43.9	50	2.2	0.9
				57.9	64	1.9	
Ø32	1.6	2.2	76	73.9	80	2.2	0.9
						2.0	
Ø40	1.3	2.2	97			2.1	0.9
						2.2	

4NHT 04: R1.0-F

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø8	1.5	2.0	74	9.9	16	0.1	0.1
Ø10	2.5	2.0	45	13.9	20	0.6	0.3
				15.9	22	0.5	
Ø12	3.3	2.0	35	17.9	24	1.2	0.4
				19.9	26	0.8	
Ø16	3.1	2.0	37	25.9	32	1.7	0.5
				33.9	40	0.9	
Ø20	3.5	2.0	33	43.9	50	1.1	0.5
				57.9	64	2.0	
Ø32	3.0	2.0	38	73.9	80	1.4	0.6
						2.0	
Ø40	2.2	2.0	51			2.0	0.7
						1.5	
Ø25	1.7	2.0	65	43.9	50	2.0	0.7
				57.9	64	1.5	
Ø32	1.3	2.0	88	73.9	80	2.0	0.7
						1.6	
Ø40	1.0	2.0	115			1.9	0.7
						1.6	

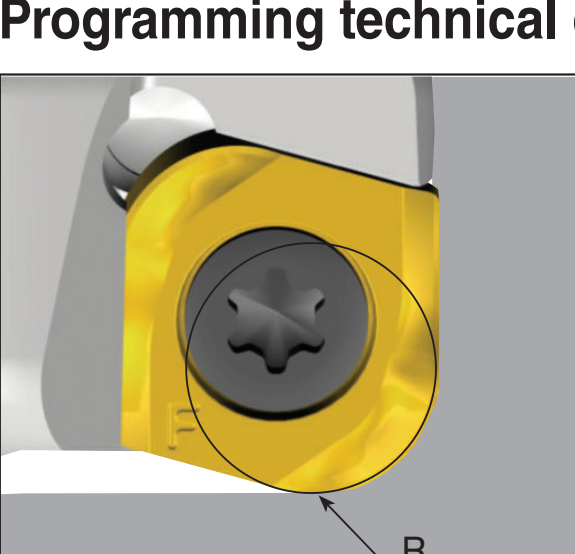


4NKT 04-HF: R1.2

(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	0.1	0.5	191	9.9	16	0.0
Ø10	0.8	0.5	34	13.9	20	0.1
				15.9	22	0.2
Ø12	1.6	0.5	18	17.9	24	0.4
				19.9	26	0.4
Ø16	2.0	0.5	14	25.9	32	0.5
				33.9	40	0.5
Ø20	1.9	0.5	15	43.9	50	0.5
				57.9	64	0.5
Ø32	2.3	0.5	12	73.9	80	0.5
						0.5
Ø40	1.7	0.5	16			0.5
						0.5

Programming technical data



	R Program	A Over cut	B Un-machined
4NKT 040212R-HF	1.2	0	0