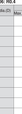
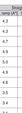
Ramping Data

CHASE2MILL





4XKT 00: R0.4 (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	4.3	6.2	62	21.5	32	32	3.2	3.2	0.8
Ø17	4.6	6.6	67	23	34	34	3.4	3.4	0.9
Ø18	4.7	6.2	75	25.5	36	36	3.6	3.6	1.1
Ø20	4.9	6.2	72	29.5	40	40	2.2	2.2	1.3
Ø21	5.0	6.2	71	31	42	42	2.1	2.1	1.4
Ø22	4.9	6.2	73	33	44	44	2.2	2.2	1.5
Ø25	4.6	6.2	77	41.5	50	50	2.5	2.5	1.8
Ø32	3.5	6.2	101	55.5	64	64	1.6	1.6	2.3
Ø33	3.4	6.2	104	57.5	66	66	1.7	1.7	2.4
Ø35	3.3	6.2	107	59.5	70	70	1.7	1.7	2.5
Ø36	3.0	6.2	118	63	72	72	1.8	1.8	2.7
Ø40	2.8	6.2	127	69.5	76	76	1.9	1.9	2.9
Ø42	2.6	6.2	136	73.5	80	80	2.0	2.0	3.1
Ø44	2.4	6.2	148	75.5	80	80	1.4	1.4	3.2
Ø50	2.0	6.2	173	89.5	100	100	3.8	1.7	3.8
Ø63	1.6	6.2	222	115.5	126	126	2.7	1.7	4.8

4XKT 00: R0.8 (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	3.7	6.0	60	21.5	32	32	3.2	3.2	0.8
Ø17	3.8	6.0	90	23.5	34	34	2.0	2.0	0.8
Ø18	4.0	6.0	82	25.5	36	36	2.2	2.2	0.9
Ø20	4.4	6.0	79	29.5	40	40	2.5	2.5	1.1
Ø21	4.6	6.0	75	31.5	42	42	2.3	2.3	1.2
Ø22	4.6	6.0	75	33	44	44	2.3	2.3	1.3
Ø25	4.6	6.0	77	41.5	50	50	2.4	2.4	1.5
Ø32	3.2	6.0	107	53.5	64	64	1.5	1.5	1.9
Ø33	3.1	6.0	111	55.5	66	66	1.6	1.6	2.0
Ø35	2.8	6.0	121	61.5	70	70	1.8	1.8	2.1
Ø36	2.7	6.0	125	63	72	72	1.8	1.8	2.2
Ø40	2.5	6.0	136	69.5	76	76	1.9	1.9	2.4
Ø42	2.4	6.0	140	69.5	80	80	2.0	2.0	2.5
Ø44	2.3	6.0	145	73.5	80	80	1.4	1.4	2.6
Ø50	1.9	6.0	161	89.5	100	100	1.6	1.6	2.9
Ø63	1.4	6.0	237	115.5	126	126	2.5	1.6	3.8

4XKT 00: R1.2 (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	3.0	6.0	115	21.5	32	32	2.0	2.0	0.7
Ø17	3.1	6.0	120	23.5	34	34	2.2	2.2	0.7
Ø18	3.6	6.0	95	25.5	36	36	2.5	2.5	0.8
Ø20	3.9	6.0	88	29.5	40	40	1.7	1.7	1.0
Ø21	4.1	6.0	84	31.5	42	42	1.9	1.9	1.1
Ø22	4.2	6.0	82	33	44	44	2.0	2.0	1.2
Ø25	3.9	6.0	88	41.5	50	50	2.8	1.3	1.4
Ø32	2.9	6.0	119	53.5	64	64	2.9	1.4	1.8
Ø33	2.8	6.0	125	55.5	66	66	2.9	1.4	1.9
Ø35	2.6	6.0	132	59.5	70	70	3.0	1.4	2.0
Ø36	2.5	6.0	137	61.5	72	72	3.0	1.4	2.1
Ø40	2.3	6.0	148	69.5	76	76	3.2	1.5	2.3
Ø42	2.2	6.0	153	69.5	80	80	4.1	1.6	2.4
Ø44	2.0	6.0	168	75.5	80	80	2.9	1.4	2.5
Ø50	1.7	6.0	202	89.5	100	100	3.1	1.4	2.8
Ø63	1.3	6.0	265	115.5	126	126	3.8	1.4	3.7

4XKT 00: R1.6 (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	2.2	6.0	151	21.5	32	32	1.5	1.5	0.5
Ø17	2.4	5.8	138	23.5	34	34	1.7	1.7	0.5
Ø18	2.5	5.8	119	25.5	36	36	1.9	1.9	0.6
Ø20	3.2	5.8	104	29.5	40	40	2.1	2.1	0.8
Ø21	3.4	5.8	98	31.5	42	42	2.2	2.2	0.9
Ø22	3.7	5.8	90	39.5	50	50	2.5	1.1	1.1
Ø25	3.4	5.8	98	41.5	50	50	2.5	1.1	1.1
Ø32	2.5	5.8	135	53.5	64	64	2.6	1.2	1.5
Ø33	2.4	5.8	136	55.5	66	66	2.6	1.2	1.6
Ø35	2.3	5.8	144	59.5	70	70	2.8	1.2	1.7
Ø36	2.2	5.8	151	61.5	72	72	2.8	1.2	1.7
Ø40	2.0	5.8	162	69.5	76	76	2.9	1.3	1.9
Ø42	1.9	5.8	170	69.5	80	80	3.7	1.4	2.0
Ø44	1.8	5.8	185	75.5	88	88	2.7	1.2	2.1
Ø50	1.5	5.8	222	89.5	100	100	2.9	1.2	2.3
Ø63	1.1	5.8	294	115.5	126	126	3.5	1.2	3.1

4XKT 00: R2.0 (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	1.4	5.0	47	21.5	32	32	0.7	0.7	0.4
Ø17	1.5	5.0	50	23.5	34	34	0.7	0.7	0.4
Ø18	1.6	5.0	50	25.5	36	36	0.8	0.8	0.4
Ø20	1.8	5.0	57	29.5	40	40	0.9	0.9	0.5
Ø21	1.9	5.0	61	31.5	42	42	1.0	1.0	0.5
Ø22	2.0	5.0	64	33	44	44	1.0	1.0	0.6
Ø25	2.2	5.0	71	41.5	50	50	1.2	1.2	0.7
Ø32	2.3	5.0	78	53.5	64	64	1.4	1.4	0.9
Ø33	2.3	5.0	80	55.5	66	66	1.4	1.4	0.9
Ø35	2.3	5.0	82	59.5	70	70	1.5	1.5	1.0
Ø36	2.3	5.0	84	61.5	72	72	1.5	1.5	1.0
Ø40	2.3	5.0	88	69.5	76	76	1.6	1.6	1.1
Ø42	2.3	5.0	90	69.5	80	80	1.7	1.7	1.2
Ø44	2.3	5.0	93	75.5	88	88	1.5	1.5	1.3
Ø50	2.3	5.0	98	89.5	100	100	1.6	1.6	1.4
Ø63	2.3	5.0	106	115.5	126	126	1.9	1.9	1.6

4XKT 00: R0.4F (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	2.8	6.0	110	21.5	32	32	2.2	2.2	0.6
Ø17	3.0	6.0	115	23.5	34	34	2.4	2.4	0.6
Ø18	3.4	6.0	101	25.5	36	36	1.2	1.2	0.8
Ø20	3.7	6.0	90	29.5	40	40	1.5	1.5	0.9
Ø21	4.0	6.0	86	31.5	42	42	1.6	1.6	1.0
Ø22	4.1	6.0	84	39.5	50	50	2.0	1.0	1.1
Ø25	3.8	6.0	90	41.5	50	50	2.0	1.0	1.1
Ø32	2.8	6.0	123	53.5	64	64	2.3	1.1	1.4
Ø33	2.7	6.0	127	55.5	66	66	2.3	1.1	1.5
Ø35	2.7	6.0	131	59.5	70	70	2.4	1.1	1.5
Ø36	2.5	6.0	140	61.5	72	72	2.4	1.1	1.6
Ø40	2.3	6.0	149	69.5	76	76	2.9	1.3	1.7
Ø42	2.2	6.0	154	69.5	80	80	3.3	1.4	1.8
Ø44	2.1	6.0	160	75.5	80	80	4.0	1.3	1.9
Ø50	1.8	6.0	180	89.5	100	100	2.5	1.1	2.1
Ø63	1.6	6.0	208	115.5	126	126	3.0	1.3	2.8
Ø80	1.2	6.0	275	115.5	126	126	2.3	1.7	3.6

4XKT 00: R0.8F (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	3.5	2.3	38	21.5	32	32	2.9	0.8	0.8
Ø17	3.6	2.3	37	23.5	34	34	3.1	0.8	0.8
Ø18	4.0	2.3	32	25.5	36	36	1.1	0.8	0.9
Ø20	4.3	2.3	29	29.5	40	40	1.3	0.9	1.0
Ø21	4.5	2.3	27	31.5	42	42	1.4	0.9	1.1
Ø22	4.4	2.3	30	33	44	44	1.5	0.9	1.2
Ø25	4.3	2.3	27	39.5	50	50	2.1	0.9	1.3
Ø32	4.2	2.3	29	41.5	50	50	2.1	0.9	1.6
Ø33	3.3	2.3	38	53.5	64	64	2.3	1.0	1.6
Ø35	3.3	2.3	40	55.5	66	66	2.3	1.0	1.6
Ø36	3.1	2.3	42	59.5	70	70	2.3	1.0	1.7
Ø40	2.8	2.3	47	61.5	72	72	2.3	1.0	1.8
Ø42	2.6	2.3	51	69.5	80	80	2.3	1.0	1.9
Ø44	2.4	2.3	55	69.5	80	80	1.7	1.0	2.0
Ø50	2.1	2.3	64	89.5	100	100	2.1	1.0	2.2
Ø63	1.7	2.3	78	115.5	126	126	2.3	1.0	2.9

4XKT 00: R0.8-F (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	3.1	1.8	35	21.5	32	32	1.9	0.7	0.7
Ø17	3.2	1.8	34	23.5	34	34	2.1	0.7	0.7
Ø18	3.6	1.8	30	25.5	36	36	1.3	0.9	0.9
Ø20	3.9	1.8	26	29.5	40	40	1.5	0.9	1.0
Ø21	4.1	1.8	24	31.5	42	42	1.6	0.9	1.1
Ø22	4.6	1.8	24	39.5	50	50	1.9	1.5	1.5
Ø25	4.4	1.8	25	41.5	50	50	1.9	1.5	1.5
Ø32	3.3	1.8	35	53.5	64	64	1.9	1.5	1.9
Ø33	3.1	1.8	39	55.5	66	66	1.9	1.5	1.9
Ø35	2.9	1.8	36	59.5	70	70	1.9	1.5	2.1
Ø36	2.8	1.8	39	61.5	72	72	1.9	1.5	2.1
Ø40	2.5	1.8	44	69.5	76	76	1.9	1.5	2.3
Ø42	2.4	1.8	48	75.5	86	86	1.9	1.5	2.5
Ø50	1.9	1.8	57	89.5	100	100	1.9	1.5	2.8
Ø63	1.5	1.8	75	115.5	126	126	1.9	1.5	3.8

4XKT 00: R1.0-F (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	2.7	2.1	44	21.5	32	32	2.1	0.6	0.6
Ø17	2.9	2.1	41	23.5	34	34	2.3	0.6	0.7
Ø18	3.3	2.1	36	25.5	36	36	1.5	0.8	0.8
Ø20	3.6	2.1	33	29.5	40	40	1.8	0.8	0.9
Ø21	3.8	2.1	32	31.5	42	42	1.9	0.8	1.0
Ø22	4.1	2.1	27	39.5	50	50	2.2	1.4	1.1
Ø25	4.2	2.1	29	41.5	50	50	2.2	1.4	1.1
Ø32	3.1	2.1	39	53.5	64	64	2.1	1.4	1.4
Ø33	2.9	2.1	43	55.5	66	66	2.1	1.4	1.4
Ø35	2.8	2.1	43	59.5	70	70	2.1	1.4	1.5
Ø36	2.6	2.1	45	61.5	72	72	2.1	1.4	1.5
Ø40	2.5	2.1	48	69.5	76	76	2.1	1.5	1.6
Ø42	2.3	2.1	51	69.5	80	80	2.1	1.5	1.7
Ø50	2.1	2.1	56	75.5	80	80	2.1	1.5	1.8
Ø63	1.8	2.1	67	89.5	100	100	2.1	1.5	2.1
Ø80	1.4	2.1	86	115.5	126	126	2.1	1.5	2.7

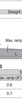
4XKT 00: R1.5-F (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	1.9	1.6	31	21.5	32	32	1.5	0.4	0.4
Ø17	2.1	3.3	88	23.5	34	34	0.7	0.5	0.5
Ø18	2.6	3.3	73	25.5	36	36	0.8	0.6	0.6
Ø20	3.0	3.3	63	29.5	40	40	0.9	0.6	0.8
Ø21	3.2	3.3	59	31.5	42	42	1.0	0.9	0.9
Ø22	3.9	3.3	49	39.5	50	50	1.2	0.8	1.1
Ø25	3.7	3.3	51	41.5	50	50	1.2	0.8	1.1
Ø32	2.7	3.3	70	53.5	64	64	1.3	0.8	1.3
Ø33	2.6	3.3	71	55.5	66	66	1.3	0.8	1.3
Ø35	2.4	3.3	77	59.5	70	70	1.3	0.8	1.3
Ø36	2.3	3.3	80	61.5	72	72	1.3	0.8	1.3
Ø40	2.2	3.3	86	69.5	76	76	1.3	0.8	1.3
Ø42	2.1	3.3	90	69.5	80	80	1.3	0.8	1.3
Ø50	1.9	3.3	100	89.5	100	100	1.3	0.8	1.3
Ø63	1.6	3.3	120	115.5	126	126	1.3	0.8	1.3
Ø80	1.2	3.3	151	115.5	126	126	1.3	0.8	1.3

4XKT 00: R2.0-F (unit: mm)

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	0.8	3.0	78	21.5	32	32	0.6	0.2	0.2
Ø17	1.1	3.0	136	23.5	34	34	0.6	0.2	0.2
Ø18	1.6	3.0	127	25.5	36	36	0.6	0.3	0.3
Ø20	2.1	3.0	82	29.5	40	40	0.7	0.3	0.3
Ø21	2.3	3.0	76	31.5	42	42	0.8	0.3	0.4
Ø22	3.2	3.0	54	39.5	50	50	1.0	0.9	0.9
Ø25	3.0	3.0	57	41.5	50	50	1.0	0.9	0.9
Ø32	2.2	3.0	76	53.5	64	64	1.0	0.9	1.0
Ø33	2.0	3.0	86	55.5	66	66	1.0	0.9	1.0
Ø35	1.9	3.0	88	59.5	70	70	1.0	0.9	1.0
Ø36	1.8	3.0	95	61.5	72	72	1.0	0.9	1.0
Ø40	1.7	3.0	101	69.5	76	76	1.0	0.9	1.0
Ø42	1.5	3.0	111	75.5	80	80	1.0	0.9	1.0
Ø50	1.3	3.0	132	89.5	100	100	1.0	0.9	1.0
Ø63	1.0	3.0	172	115.5	126	126	1.0	0.9	1.0

4XKT 00: R0.4F - R2.0



4XKT 00: R0.4F - R2.0

Cutter dia.Ø	Straight ramp down			Helical ramp down				Deep ramp down	
	Max. ramp ∡	Min. ap	Max. ap	Min. length L1	Min. dia.Ø1	Max. dia.Ø1	Min. pitch/dia.	Max. pitch/dia.	Max. ap
Ø16	0.6	1.0	88	21.5	32	32	0.3	0.2	0.2
Ø17	0.7	1.0	72	23.5	34	34	0.3	0.2	0.2
Ø18	1.1	1.0	50	25.5	36	36	0.4	0.2	0.3
Ø20	1.7	1.0	34	29.5	40	40	0.5	0.2	0.3
Ø21	1.9	1.0	29	31.5	42	42	0.5	0.2	0.3
Ø22	2.3	1.0	24	39.5	50	50	0.6	0.2	0.4
Ø25	2.2	1.0	25	41.5	50	50	0.6	0.2	0.4
Ø32	2.4	1.0	24	53.5	64	64	0.7	0.2	0.5
Ø33	1.8	1.0	32	55.5	66	66	0.7	0.2	0.5
Ø35	1.4	1.0	41	59.5	70	70	0.7	0.2	0.5
Ø36	1.0	1.0	52	61.5	72	72	0.7	0.2	0.5
Ø40	1.0	1.0	52	69.5	76	76	0.7	0.2	0.5
Ø42	1.0	1.0	52	69.5	80	80	0.7	0.2	0.5
Ø50	1.0	1.0	52	89.5	100	100	0.7	0.2	0.5
Ø63	1.0	1.0	52	115.5	126	126	0.7	0.2	0.5

Programming technical data

	Ø	Ø1	Ø
4XKT 00010205-HF	Program	Chell cut	Un-maintained
	2.5	1.0	0.4