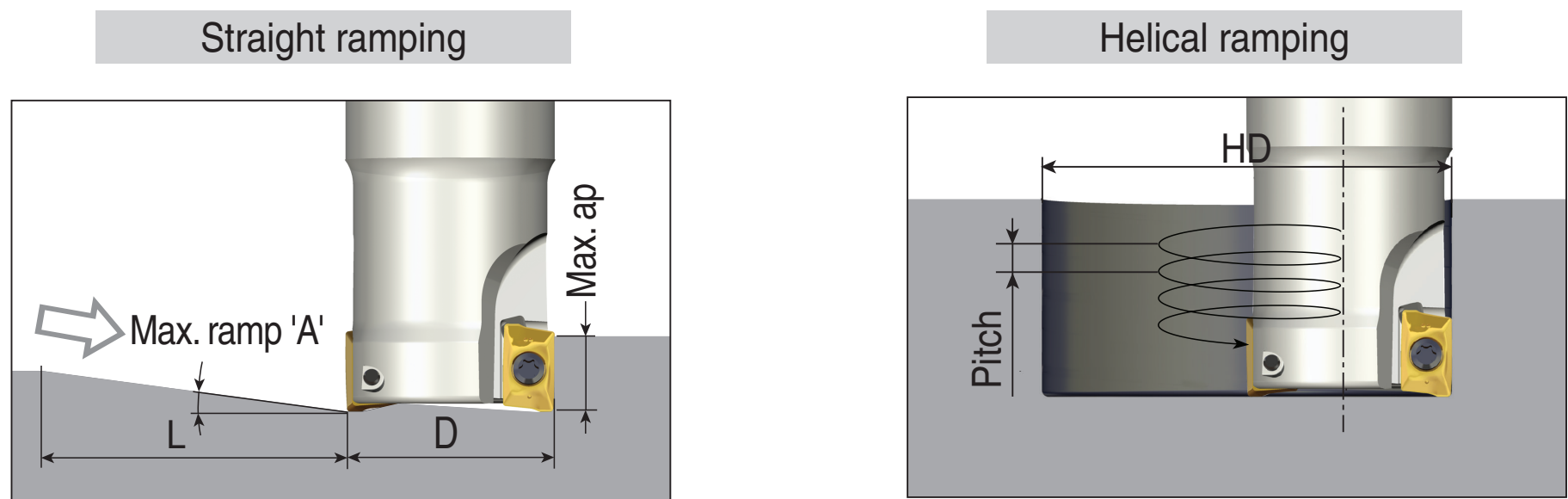


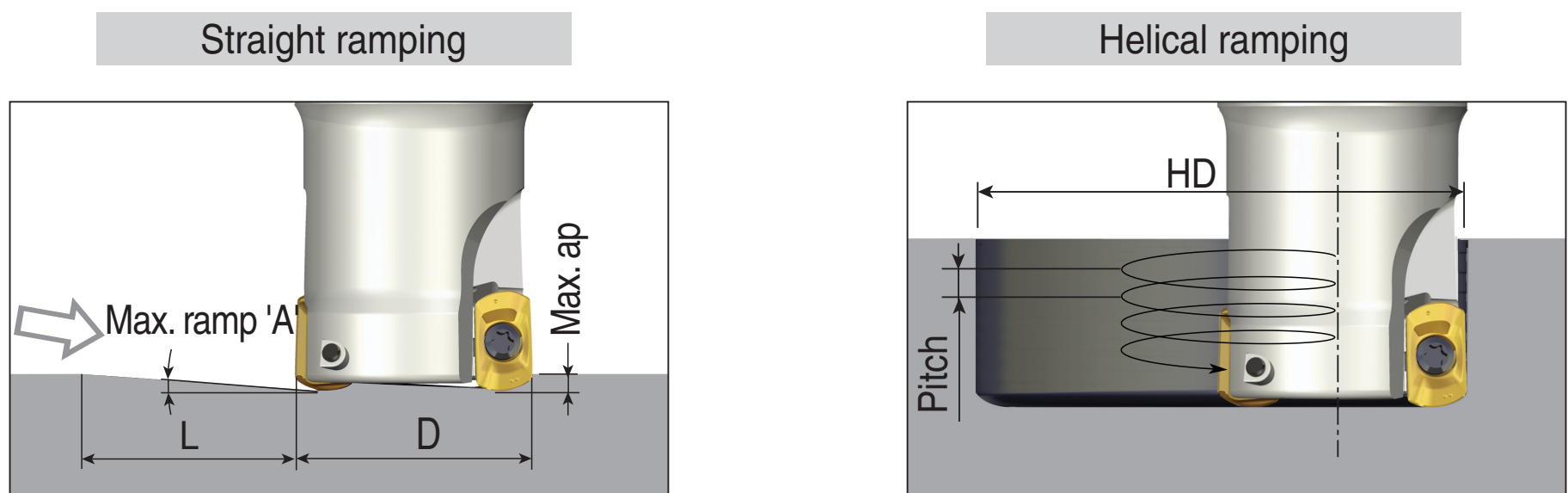
Ramping Data



APKT 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.
Ø10	7.5	9.0	68	14	20	1.4
Ø12	7.3	9.0	70	16	24	1.4
Ø14	6.0	9.0	86	18	28	1.1
Ø16	4.9	9.0	105	21.08	32	1.2
Ø17	4.4	9.0	117	23.08	34	1.2
Ø18	4.0	9.0	129	25.08	36	1.3
Ø20	3.4	9.0	152	29.08	40	1.4
Ø21	3.1	9.0	166	31.08	42	1.5
Ø22	2.8	9.0	184	33.08	44	1.4
Ø25	1.8	9.0	287	39.08	50	1.2
Ø26	2.0	9.0	258	41.08	52	1.4
Ø30	2.2	9.0	234	49.08	60	2.0
Ø32	2.0	9.0	258	53.08	64	2.0
Ø33	1.7	9.0	303	55.08	66	1.7
Ø40	1.5	9.0	344	69.08	80	2.0
Ø50	1.1	9.0	469	89.08	100	2.0
Ø63	0.8	9.0	645	115.08	126	1.9
Ø80	0.5	9.0	1032	149.08	160	1.9

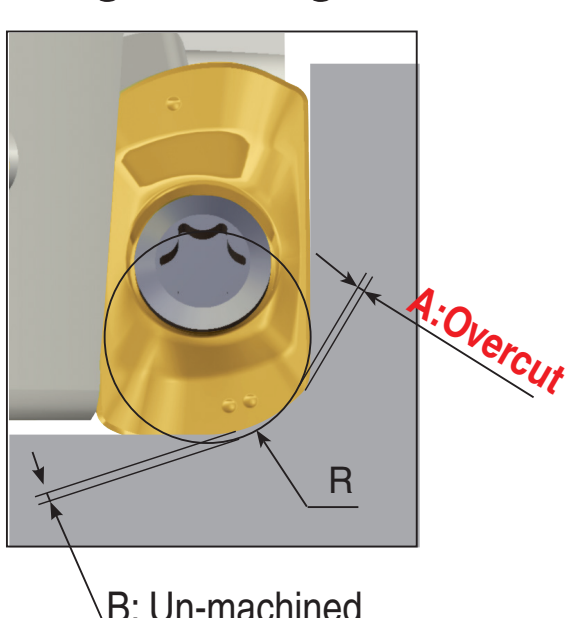


APKT 09T3R-HF

(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	3.8	1.0	15	22	32	1.0
Ø17	3.5	1.0	16	24	34	1.0
Ø18	3.4	1.0	17	26	36	1.0
Ø20	3.0	1.0	19	30	40	1.0
Ø21	2.3	1.0	25	32	42	1.0
Ø22	2.0	1.0	29	34	44	1.0
Ø25	2.1	1.0	27	40	50	1.0
Ø26	2.0	1.0	29	42	52	1.0
Ø30	1.8	1.0	32	50	60	1.0
Ø32	1.6	1.0	36	54	64	1.0
Ø33	1.5	1.0	38	56	66	1.0
Ø40	1.2	1.0	48	70	80	1.0
Ø50	0.9	1.0	64	90	100	1.0
Ø63	0.5	1.0	115	116	126	1.0
Ø80	0.4	1.0	143	150	160	1.0

Programming technical data



	R Program	A Over cut	B Un-machined
APKT 09T3R-HF	1.5	0	0.47
	1.7	0	0.29
	2.0	0.04	0.3
	2.5	0.18	0.15
	3.0	0.36	0.04

Yellow background: Recommended program 'R'