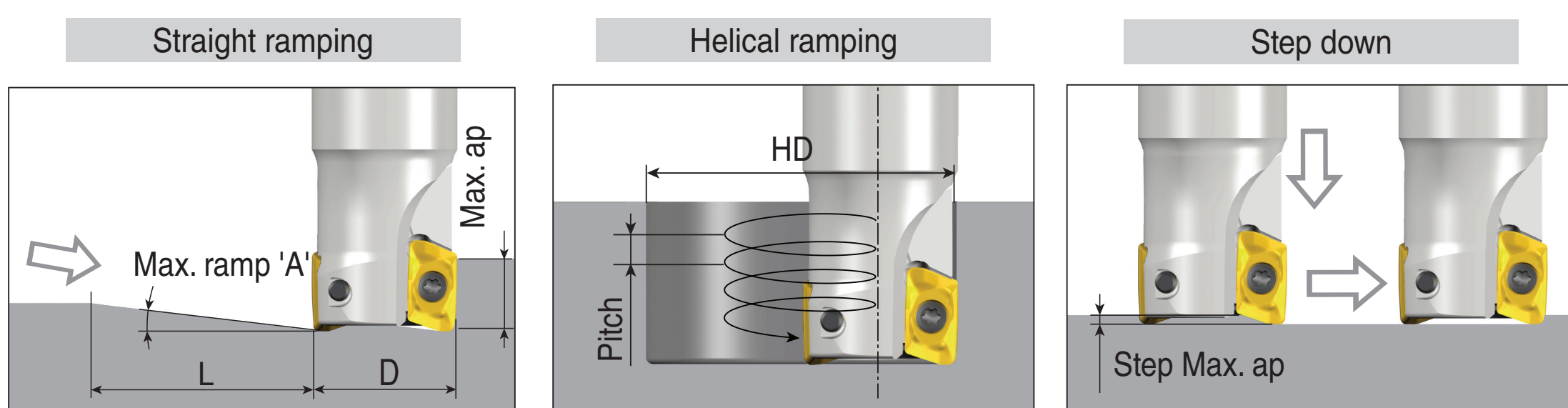


Ramping Data



AVKT 10: 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
Ø16	10.9	10	52	20		2.4	1.7
					32	9.7	
Ø18	8.3	10	69	24		2.7	2.0
					36	8.2	
Ø20	6.5	10	88	28		2.9	2.0
					40	7.2	
Ø25	4.3	10	133	38		3.1	2.0
					50	5.9	
Ø32	2.9	10	198	52		3.2	2.0
					64	5.1	
Ø40	2.1	10	267	68		3.3	2.0
					80	4.7	
Ø50	1.6	10	347	88		3.4	2.0
					100	4.5	
Ø63	1.2	10	459	114		3.5	2.0
					126	4.3	

AVKT 10: R1.6

(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
Ø16	10.4	9.8	53	20		2.3	1.5
					32	9.2	
Ø18	7.8	9.8	72	24		2.6	1.7
					36	7.7	
Ø20	6.1	9.8	92	28		2.7	1.7
					40	6.7	
Ø25	3.9	9.8	144	38		2.8	1.7
					50	5.3	
Ø32	2.6	9.8	212	52		2.9	1.7
					64	4.6	
Ø40	2	9.8	281	68		3.1	1.7
					80	4.4	
Ø50	1.5	9.8	374	88		3.1	1.7
					100	4.1	
Ø63	1.1	9.8	488	114		3.2	1.7
					126	4.0	

AVKT 10: R3.2

(unit: mm)

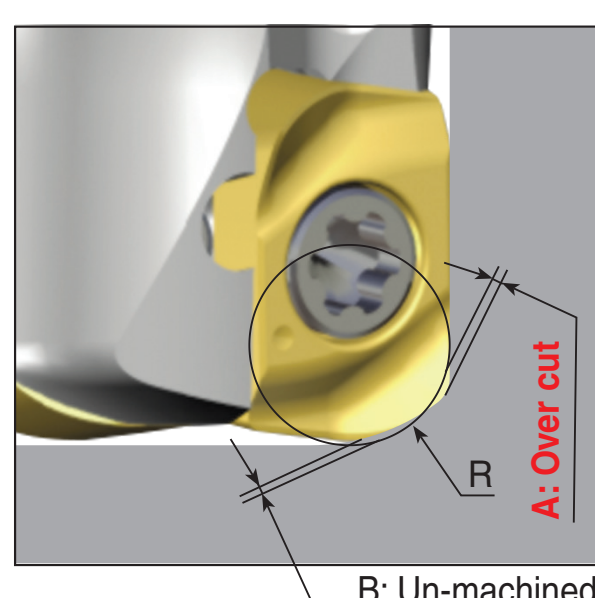
Cutter dia. (D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia. (HD)	Max. dia. (HD)	Max. pitch/rev.	Max. ap
Ø16	8.6	9.5	63	20		1.9	1.1
					32	7.6	
Ø18	6.2	9.5	87	24		2.0	1.4
					36	6.1	
Ø20	4.6	9.5	118	28		2.0	1.4
					40	5.1	
Ø25	2.9	9.5	188	38		2.1	1.4
					50	4.0	
Ø32	1.9	9.5	287	52		2.1	1.4
					64	3.3	
Ø40	1.45	9.5	375	68		2.2	1.4
					80	3.2	
Ø50	1.05	9.5	519	88		2.2	1.4
					100	2.9	
Ø63	0.8	9.5	681	114		2.2	1.4
					126	2.8	

AVKT 1004R-HF

(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
Ø16	7.6	1.0	7	20.5		1.0	0.8
					32	1.0	
Ø18	5.5	1.0	10	24.5		1.0	1.0
					36	1.0	
Ø20	4.2	1.0	14	28.5		1.0	1.0
					40	1.0	
Ø25	2.6	1.0	22	38.5		1.0	1.0
					50	1.0	
Ø32	1.7	1.0	34	52.5		1.0	1.0
					64	1.0	
Ø40	1.2	1.0	48	68.5		1.0	1.0
					80	1.0	
Ø50	0.9	1.0	64	88.5		1.0	1.0
					100	1.0	
Ø63	0.7	1.0	82	114.5		1.0	1.0
					126	1.0	

Programming technical data



	R Program	A Over cut	B Un-machined
AVKT 1004R-HF	1.7	0	0.49
	1.9	0	0.43
	2.0	0.01	0.40
	2.5	0.13	0.24
	3.0	0.30	0.11

 : Recommended program 'R'