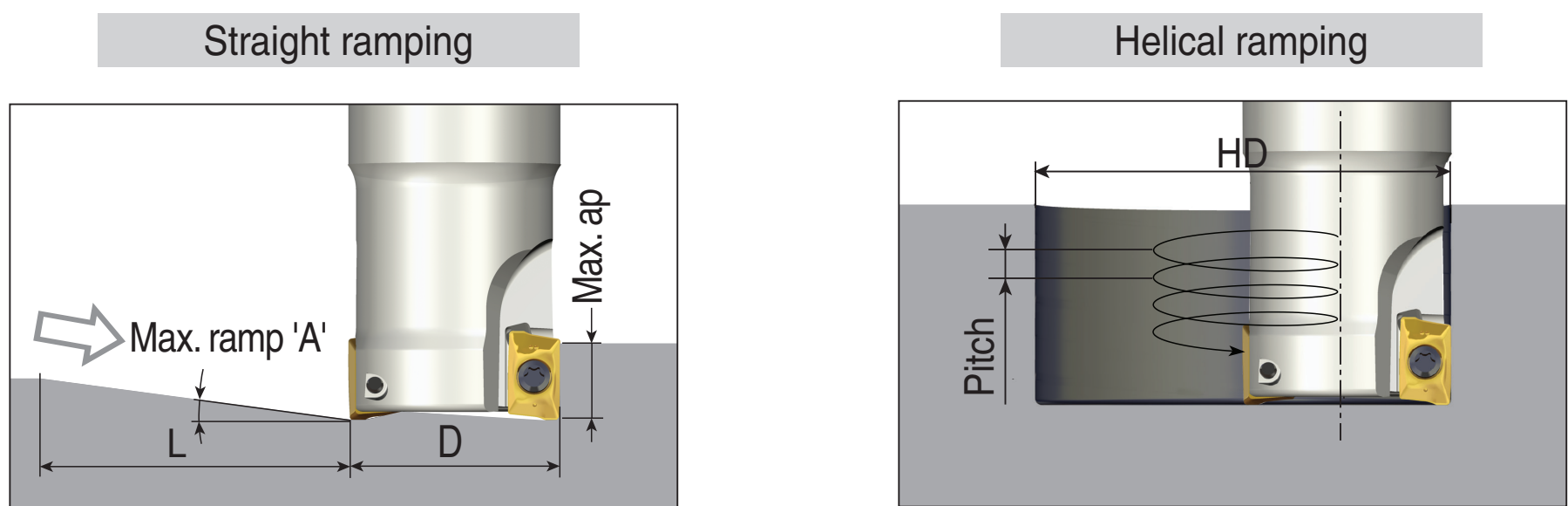


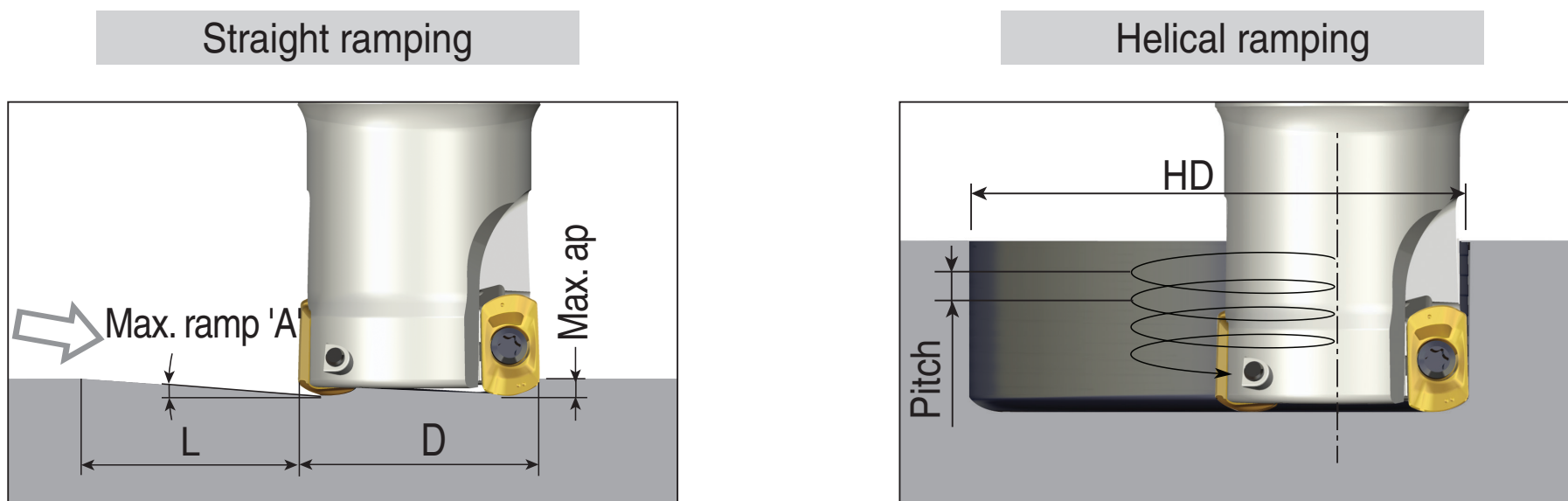
Ramping Data



AXMT 06

(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	1.0	5.0	287	9	16	0.0
Ø10	8.0	5.0	36	13	20	1.1
					3.7	
Ø11	6.0	5.0	48	15	22	1.1
					3.1	
Ø12	6.0	5.0	48	17	24	1.4
					3.4	
Ø13	5.5	5.0	52	19	26	1.5
					3.3	
Ø14	4.8	5.0	60	21	28	1.6
					3.1	
Ø15	4.3	5.0	67	23	30	1.6
					3.0	
Ø16	4.0	5.0	72	25	32	1.7
					3.0	
Ø17	3.5	5.0	82	27	34	1.6
					2.8	
Ø18	5.0	5.0	57	29	36	2.6
					4.2	
Ø19	4.8	5.0	60	31	38	2.7
					4.3	
Ø20	4.0	5.0	72	33	40	2.4
					3.7	
Ø21	3.5	5.0	82	35	42	2.3
					3.4	
Ø25	3.0	5.0	95	43	50	2.5
					3.5	
Ø32	2.0	5.0	143	57	64	2.3
					3.0	
Ø40	1.5	5.0	191	73	80	2.3
					2.8	

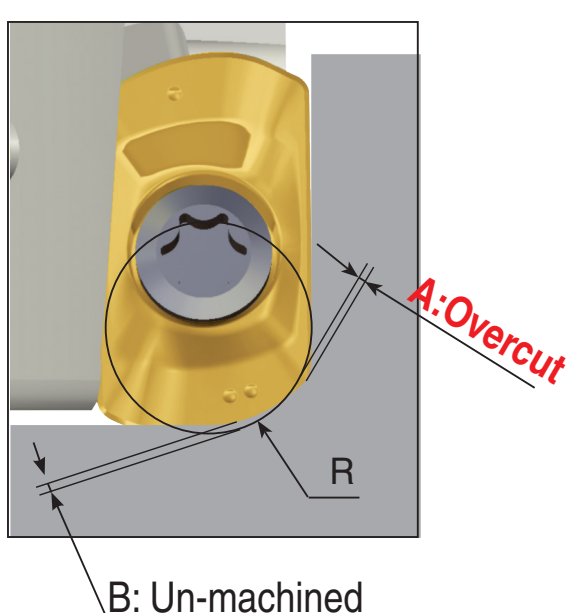


AXMT 0602R-HF

(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.
Ø8	0.3	0.5	96	14	16	0.1
Ø10	0.5	0.5	57	14	20	0.1
					0.2	
Ø11	1.0	0.5	29	18	22	0.3
					0.5	
Ø12	2.3	0.5	12	18	24	0.5
					0.5	
Ø13	4.5	0.5	6	18	26	0.5
					0.5	
Ø14	3.5	0.5	8	18	28	0.5
					0.5	
Ø15	3.0	0.5	10	26	30	0.5
					0.5	
Ø16	2.8	0.5	10	26	32	0.5
					0.5	
Ø17	2.5	0.5	11	26	34	0.5
					0.5	
Ø18	2.3	0.5	12	26	36	0.5
					0.5	
Ø19	2.2	0.5	13	26	38	0.5
					0.5	
Ø20	1.9	0.5	15	34	40	0.5
					0.5	
Ø21	1.7	0.5	17	34	42	0.5
					0.5	
Ø25	1.4	0.5	20	44	50	0.5
					0.5	
Ø32	1.0	0.5	29	58	64	0.5
					0.5	
Ø40	0.7	0.5	41	74	80	0.5
					0.5	

Programming technical data



	R Program	A Over cut	B Un-machined
AXMT 0602R-HF	0.9	0	0.22
	1.0	0.01	0.19
	1.5	0.16	0.05
	2.0	0.35	0

Yellow background: Recommended program 'R'