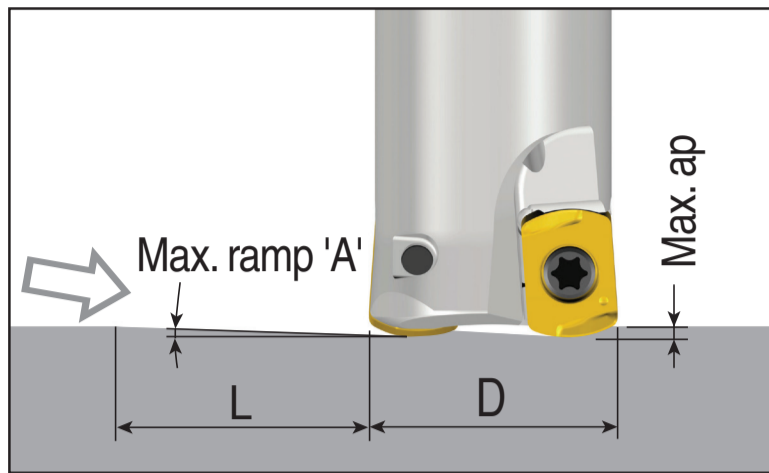
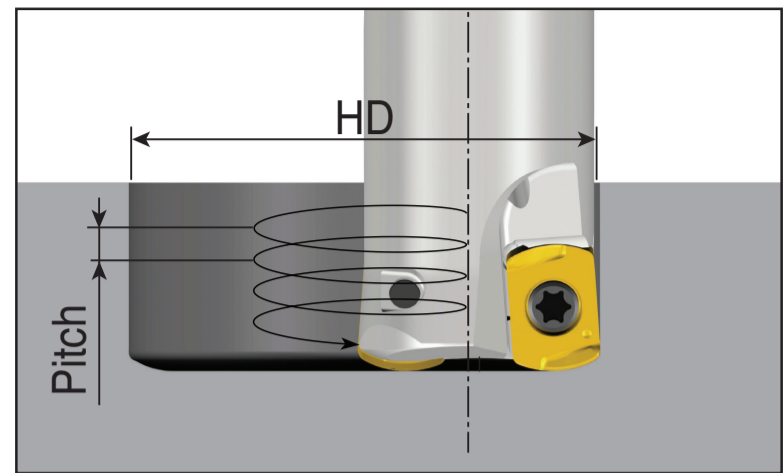


# Ramping Data

Straight ramping



Helical ramping

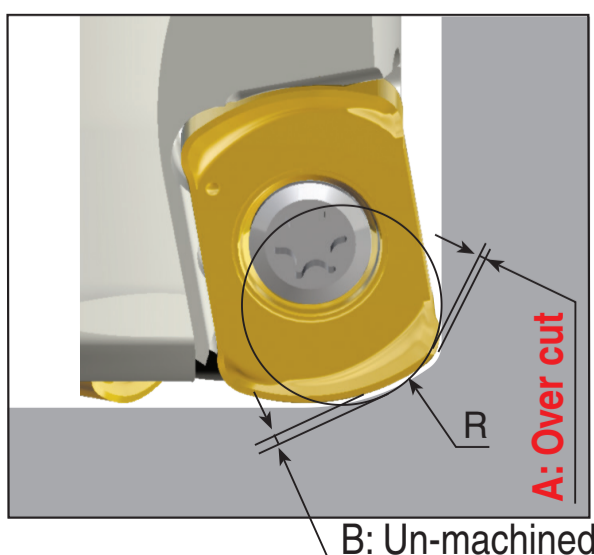


## BLMP 06

(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.
Ø16	2.0	0.7	13	23	32	0.7
Ø17	2.0	0.7	15	25	34	0.7
Ø18	2.3	0.7	16	27	36	0.7
Ø20	1.5	1.0	38	31	40	0.8
Ø21	1.5	1.0	38	33	42	1.0
Ø22	1.5	1.0	38	35	44	1.0
Ø25	1.3	1.0	41	41	50	1.0
Ø26	1.2	1.0	44	43	52	1.0
Ø30	1.0	1.0	52	51	60	1.0
Ø32	0.9	1.0	57	55	64	1.0
Ø33	0.9	1.0	57	57	66	1.0
Ø35	0.8	1.0	57	61	70	1.0
Ø40	0.7	1.0	64	71	80	1.0
Ø42	0.7	1.0	72	75	84	1.0
Ø50	0.6	1.0	96	91	100	1.0
Ø52	0.6	1.0	96	95	104	1.0
Ø63	0.5	1.0	115	117	126	1.0
Ø66	0.5	1.0	115	123	132	1.0

## Programming technical data



	R Program	A Over cut	B Un-machined
BLMP 06 (Ø16, Ø17, Ø18)	1.5	0	0.35
	2.0	0.1	0.22
	2.5	0.27	0.1
BLMP 06 (Ø20-)	2.0	0	0.42
	2.5	0.12	0.26
	3.0	0.29	0.17

**Yellow background:** Recommended program 'R'