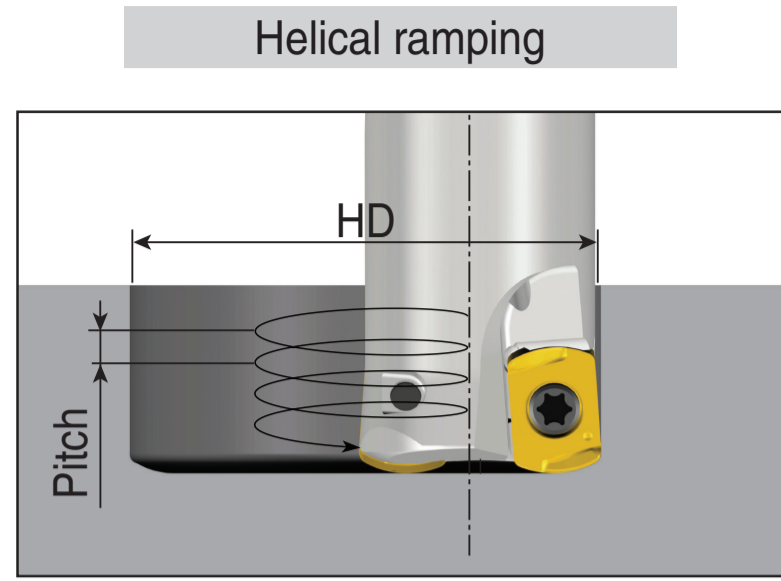
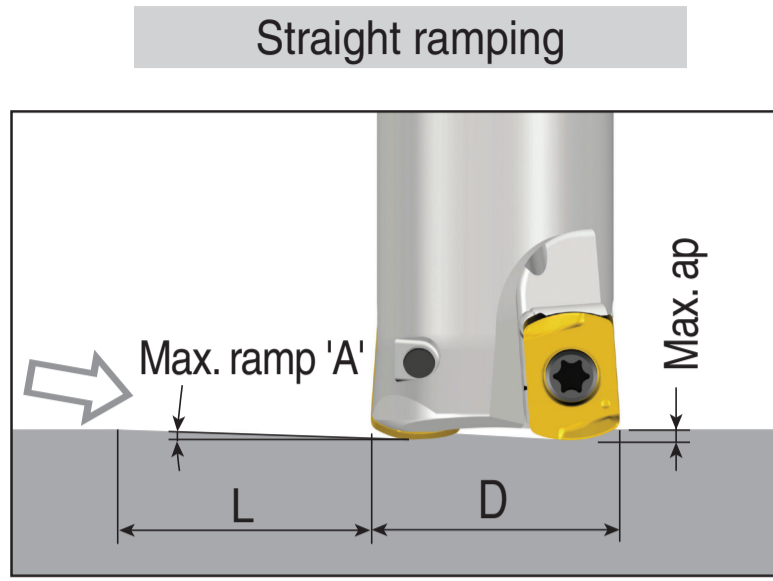


Ramping Data

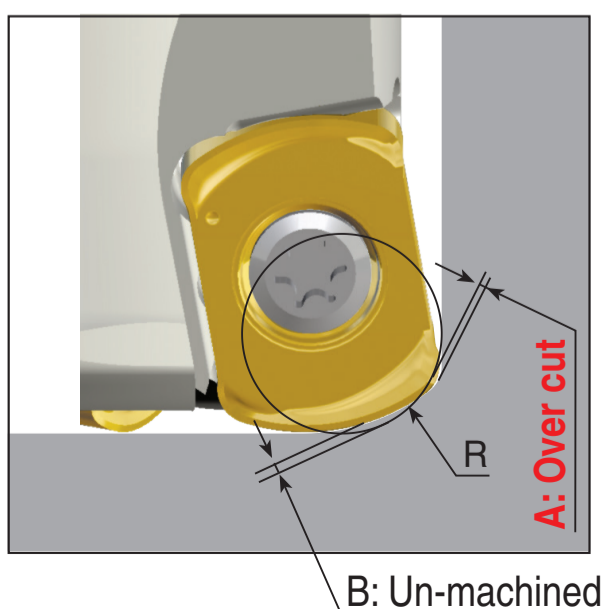


BLMP 09

(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.
Ø25	2.2	1.5	39	42	50	1.5
Ø26	2.2	1.5	39	44	52	1.5
Ø30	2.0	1.5	43	52	60	1.5
Ø32	2.0	1.5	43	56	64	1.5
Ø33	2.0	1.5	43	58	66	1.5
Ø35	2.0	1.5	43	60	70	1.5
Ø40	1.5	1.5	57	72	80	1.5
Ø42	1.5	1.5	57	76	84	1.5
Ø50	1.0	1.5	86	92	100	1.5
Ø52	1.0	1.5	86	96	104	1.5
Ø63	0.9	1.5	96	118	126	1.5
Ø66	0.9	1.5	96	124	132	1.5
Ø80	0.8	1.5	107	152	160	1.5
Ø100	0.7	1.5	123	192	200	1.5
Ø125	0.4	1.5	215	240	250	1.5

Programming technical data



	R Program	A Over cut	B Un-machined
BLMP 09	2.5	0	0.61
	3.0	0.09	0.45
	3.5	0.24	0.30
	4.0	0.41	0.17
	3.0	0.36	0.04

Yellow background: Recommended program 'R'