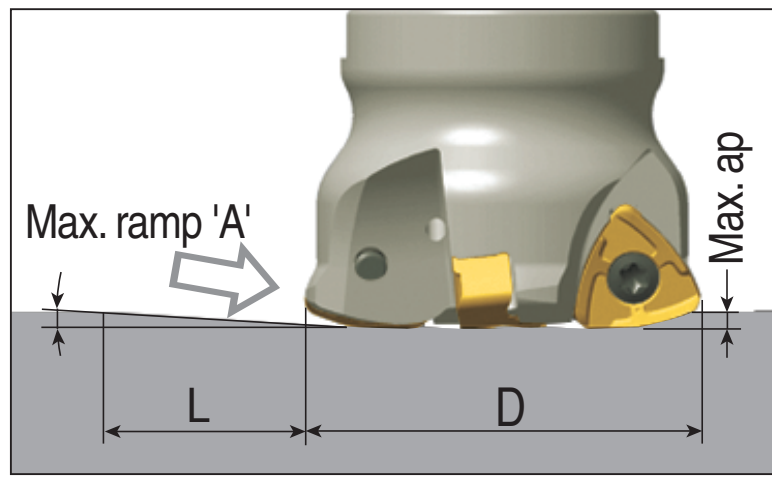
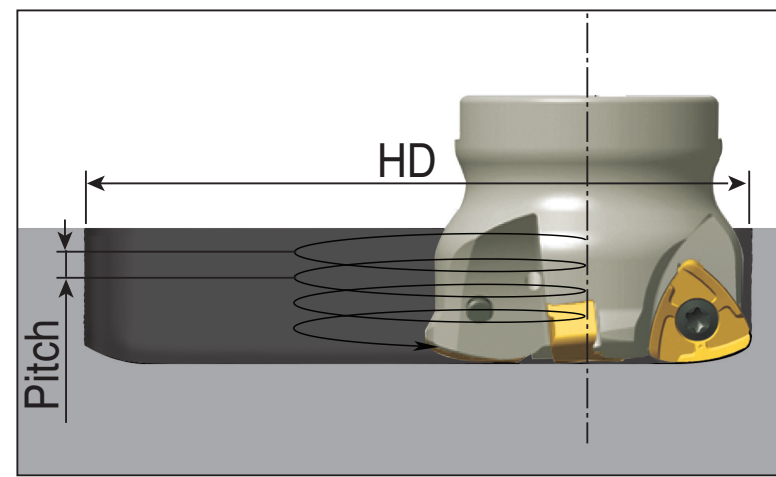


Ramping Data

Straight ramping



Helical ramping

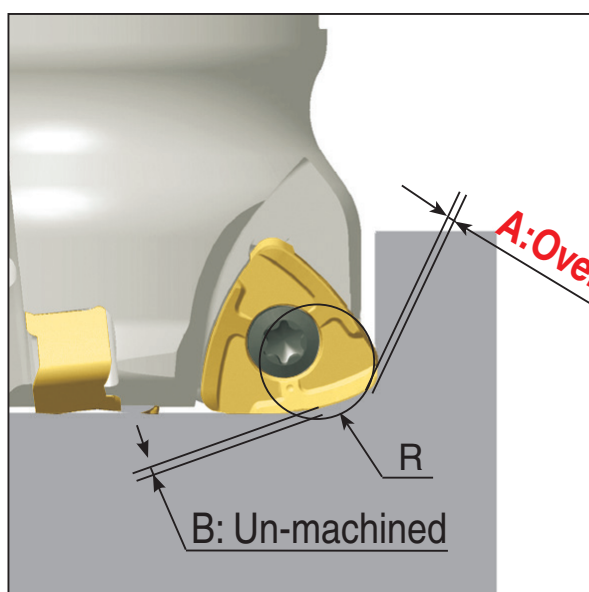


BLMP 13

(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. |
| Ø32 | 0.8 | 2.0 | 143 | 50 | | 0.7 |
| | | | | | 64 | 0.9 |
| Ø33 | 1.1 | 2.0 | 104 | 52 | | 1.0 |
| | | | | | 66 | 1.3 |
| Ø35 | 1.1 | 2.0 | 104 | 56 | | 1.1 |
| | | | | | 70 | 1.3 |
| Ø40 | 1.2 | 2.0 | 96 | 66 | | 1.4 |
| | | | | | 80 | 1.7 |
| Ø42 | 1.1 | 2.0 | 104 | 70 | | 1.3 |
| | | | | | 84 | 1.6 |
| Ø50 | 0.8 | 2.0 | 143 | 86 | | 1.2 |
| | | | | | 100 | 1.4 |
| Ø52 | 0.8 | 2.0 | 143 | 90 | | 1.3 |
| | | | | | 104 | 1.5 |
| Ø63 | 0.6 | 2.0 | 191 | 112 | | 1.2 |
| | | | | | 126 | 1.3 |
| Ø66 | 0.6 | 2.0 | 191 | 118 | | 1.2 |
| | | | | | 132 | 1.4 |
| Ø80 | 0.5 | 2.0 | 229 | 146 | | 1.3 |
| | | | | | 160 | 1.4 |
| Ø100 | 0.4 | 2.0 | 287 | 186 | | 1.3 |
| | | | | | 200 | 1.4 |
| Ø125 | 0.3 | 2.0 | 382 | 236 | | 1.2 |
| | | | | | 250 | 1.3 |
| Ø160 | 0.3 | 2.0 | 382 | 306 | | 1.6 |
| | | | | | 320 | 1.7 |
| Ø200 | 0.2 | 2.0 | 573 | 386 | | 1.3 |
| | | | | | 400 | 1.4 |
| Ø250 | 0.2 | 2.0 | 573 | 486 | | 1.7 |
| | | | | | 500 | 1.7 |

Programming technical data



| | R Program | A Over cut | B Un-machined |
|---------|-----------|------------|---------------|
| BLMP 13 | 3.0 | 0 | 1.31 |
| | 3.5 | 0 | 1.17 |
| | 4.0 | 0.04 | 1.03 |
| | 4.5 | 0.15 | 0.89 |
| | 5.0 | 0.3 | 0.76 |

3.0 : Recommended program 'R'