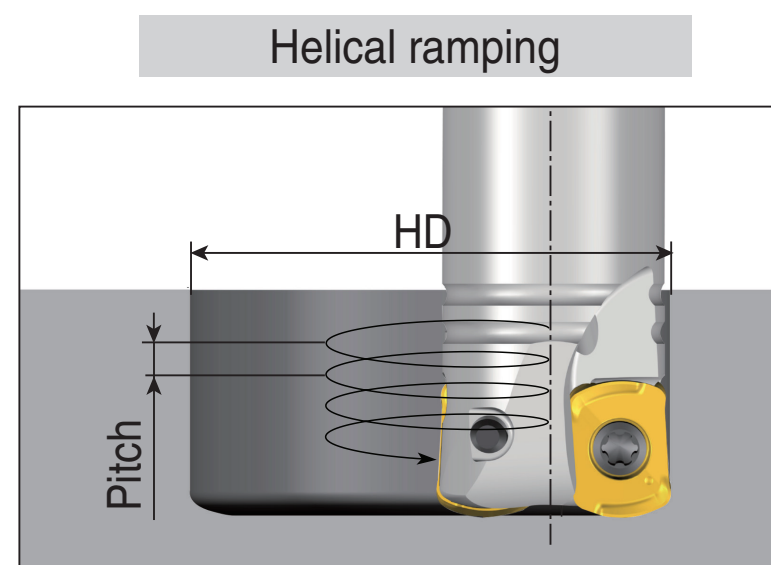
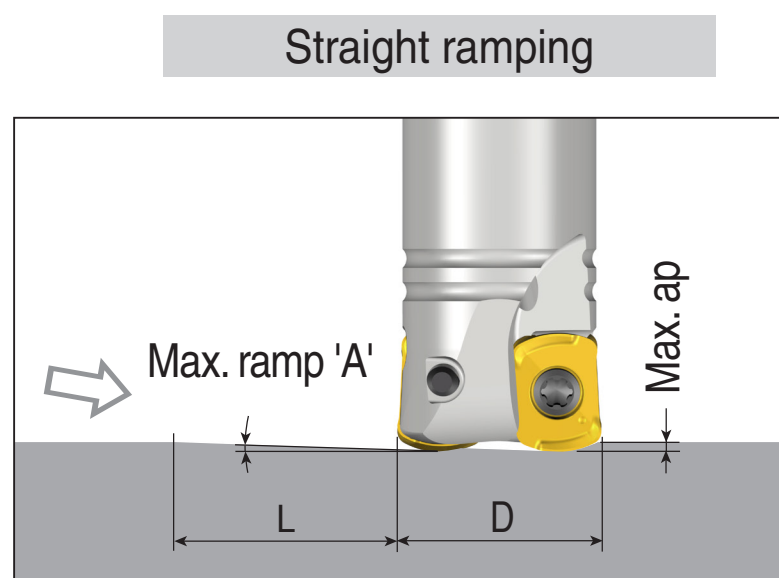


Ramping Data

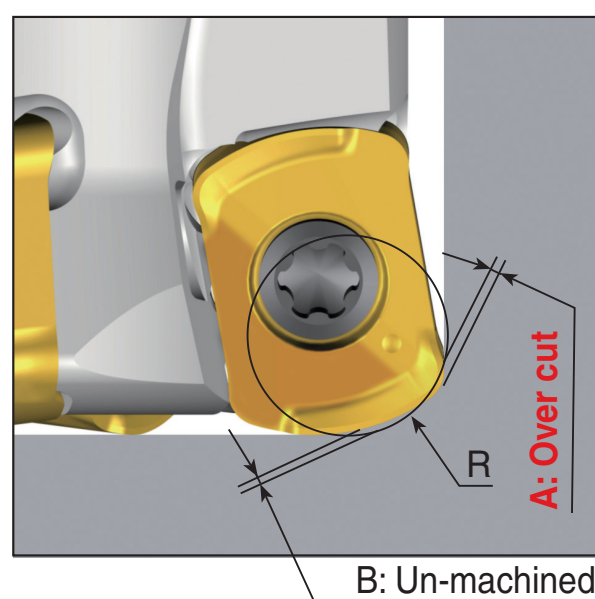


BLMV 06

(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	5.1	0.7	8	27		0.7
					32	0.7
Ø17	4.5	0.7	9	29		0.7
					34	0.7
Ø18	4.4	0.7	10	31		0.7
					36	0.7
Ø20	2.5	1.0	23	34		1.0
					40	1.0
Ø21	2.3	1.0	25	35		1.0
					42	1.0
Ø22	2.7	1.0	22	39		1.0
					44	1.0
Ø25	2.5	1.0	23	43		1.0
					50	1.0
Ø26	2.2	1.0	26	45		1.0
					52	1.0
Ø30	1.6	1.0	35	55		1.0
					60	1.0
Ø32	1.4	1.0	40	57		1.0
					64	1.0
Ø33	1.3	1.0	43	59		1.0
					66	1.0
Ø35	1.2	1.0	46	63		1.0
					70	1.0
Ø40	1.0	1.0	55	73		1.0
					80	1.0
Ø42	1.0	1.0	58	79		1.0
					84	1.0
Ø50	0.8	1.0	72	93		1.0
					100	1.0
Ø52	0.8	1.0	77	97		1.0
					104	1.0
Ø63	0.6	1.0	96	119		1.0
					126	1.0
Ø66	0.6	1.0	96	127		1.0
					132	1.0

Programming technical data



	R Program	A Over cut	B Un-machined
BLMV 06 (Ø16, Ø17)	1.5	0	0.36
	2.0	0.09	0.22
	2.5	0.27	0.10
BLMV 06 (Ø20~)	1.5	0	0.58
	2.0	0	0.41
	2.5	0.12	0.26
	3.0	0.29	0.12

Yellow background: Recommended program 'R'