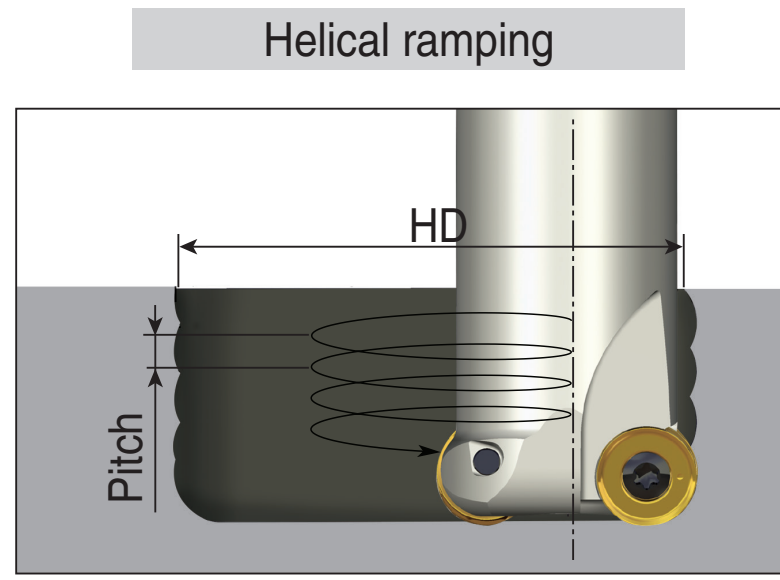
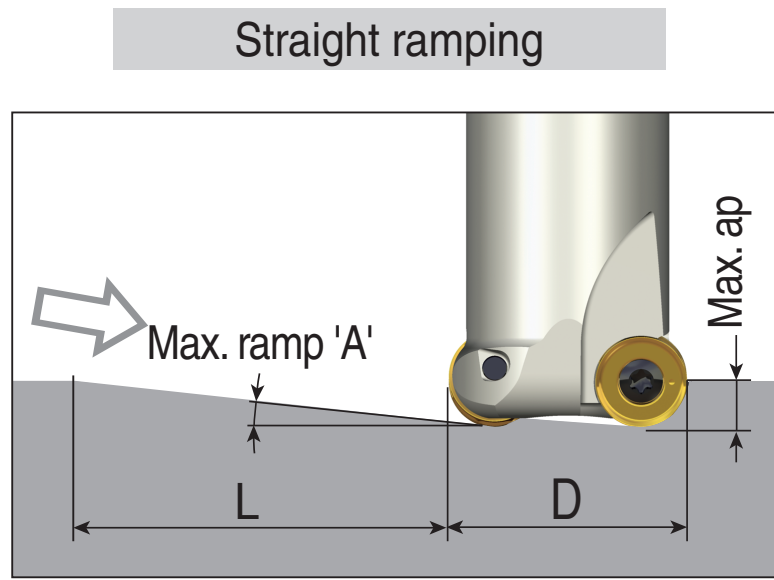


Ramping Data



RNMU 10

(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	1.1	5.0	261	33	50	0.4
Ø26	1.1	5.0	261	35	52	0.5
Ø32	0.9	5.0	318	47	64	0.6
Ø33	0.9	5.0	318	49	66	0.7
Ø40	0.9	5.0	318	63	80	1.0
Ø42	0.9	5.0	318	67	84	1.0
Ø50	0.7	5.0	409	83	100	1.6
Ø52	0.8	5.0	358	87	104	1.3

RNMU 12

(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	1.4	6.0	246	42	64	0.7
Ø33	1.4	6.0	246	44	66	0.7
Ø40	1.3	6.0	265	58	80	1.1
Ø50	1.0	6.0	344	78	100	1.3
Ø52	1.0	6.0	344	82	104	1.4
Ø63	1.0	6.0	344	104	126	1.9
Ø66	1.0	6.0	344	110	132	2.0
Ø80	0.9	6.0	382	138	160	2.4
Ø100	0.7	6.0	491	178	200	2.5

RNMU 16

(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.
Ø40	1.4	8.0	328	52	80	0.8
Ø42	1.4	8.0	328	56	84	0.9
Ø50	1.3	8.0	353	72	100	1.3
Ø52	1.0	8.0	459	76	104	1.1
Ø63	1.0	8.0	459	98	126	1.6
Ø66	1.0	8.0	459	104	132	1.8
Ø80	1.0	8.0	459	132	160	2.4
Ø100	0.9	8.0	510	172	200	3.0
Ø125	0.9	8.0	510	222	250	4.1