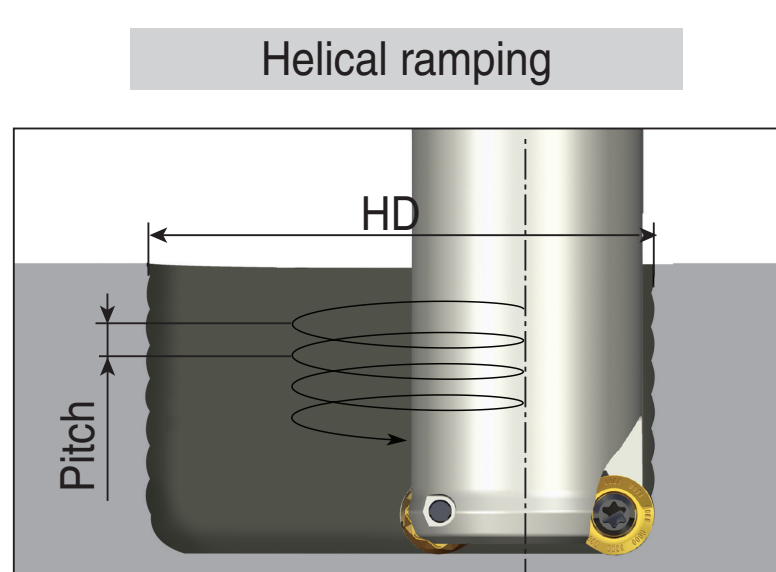
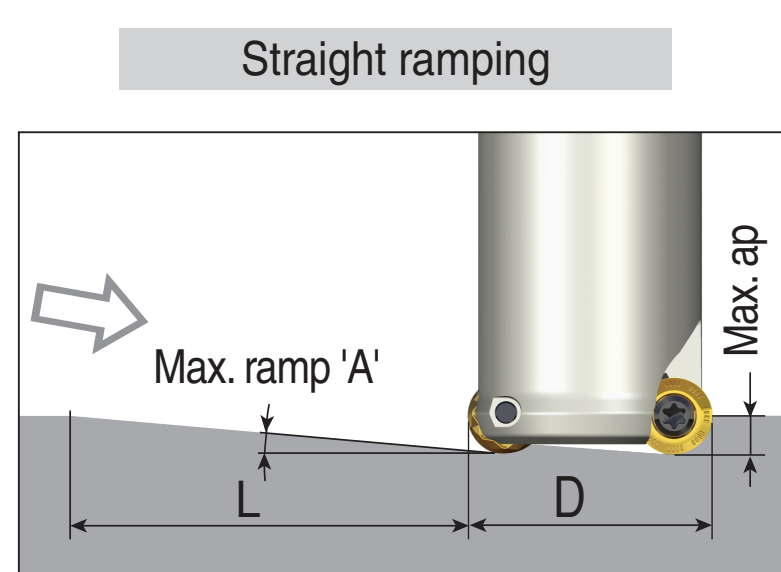


Ramping Data



RYM(H)X-08

(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	2.5	4.0	92	18	32	0.2
				20		1.9
Ø17	2.5	4.0	92	22	34	0.3
				26		2.0
Ø18	2.5	4.0	92	28	36	0.5
				32		2.1
Ø20	4.0	4.0	57	36	40	1.1
				40		3.4
Ø21	4.0	4.0	57	44	42	1.3
				48		3.4
Ø25	4.0	4.0	57	52	50	2.1
				56		3.4
Ø26	4.0	4.0	57	60	52	2.2
				64		3.4
Ø32	4.0	4.0	57	72	64	3.4
				80		3.4
Ø40	7.0	4.0	33	96	80	3.4
				112		3.4

RYMX-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.
Ø20	4.5	5.0	64	22	40	0.4
				24		4.2
Ø21	4.5	5.0	64	26	42	0.6
				28		4.4
Ø25	5.0	5.0	57	32	50	1.6
				34		4.3
Ø26	5.0	5.0	57	36	52	1.9
				38		4.3
Ø32	5.0	5.0	57	44	64	3.3
				48		4.3
Ø35	5.0	5.0	57	52	70	4.0
				56		4.3
Ø40	5.0	5.0	57	60	80	4.3
				64		4.3
Ø42	5.0	5.0	57	66	84	4.3
				70		4.3
Ø50	6.5	5.0	44	82	100	4.3
				86		4.3
Ø52	6.0	5.0	48	90	104	4.3
				94		4.3
Ø66	4.5	5.0	64	114	132	4.3
				132		4.3

RYMX-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.
Ø25	6.0	6.0	57	28	50	0.8
				30		5.1
Ø26	6.0	6.0	57	32	52	1.1
				34		5.1
Ø32	12.0	6.0	28	42	64	5.1
				44		5.1
Ø33	12.0	6.0	28	46	66	5.1
				48		5.1
Ø35	12.0	6.0	28	50	70	5.1
				54		5.1
Ø40	10.0	6.0	34	58	80	5.1
				62		5.1
Ø42	12.0	6.0	28	64	84	5.1
				68		5.1
Ø50	9.0	6.0	38	78	100	5.1
				82		5.1
Ø52	8.0	6.0	43	86	104	5.1
				90		5.1
Ø55	8.0	6.0	43	94	110	5.1
				98		5.1
Ø63	7.0	6.0	49	104	126	5.1
				110		5.1
Ø66	6.5	6.0	53	114	132	5.1
				120		5.1
Ø80	4.5	6.0	76	138	160	5.1
				144		5.1
Ø100	3.5	6.0	98	178	200	5.1
				184		5.1
Ø125	2.5	6.0	137	228	250	5.1
				234		5.1

RYMX-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.
Ø32	8.0	8.0	57	34	64	0.7
				36		6.8
Ø40	9.5	8.0	48	40	80	4.5
				42		6.8
Ø42	9.0	8.0	51	44	84	5.1
				46		6.8
Ø50	9.0	8.0	51	50	100	6.8
				54		6.8
Ø52	9.0	8.0	51	54	104	6.8
				58		6.8
Ø63	8.5	8.0	54	66	126	6.8
				70		6.8
Ø66	8.5	8.0	54	72	132	6.8
				76		6.8
Ø80	6.0	8.0	76	90	160	6.8
				96		6.8
Ø100	5.0	8.0	91	114	200	6.8
				120		6.8
Ø125	3.5	8.0	131	150	250	6.8
				160		6.8
Ø160	3.5	8.0	131	198	320	6.8
				216		6.8

RYMX-20

(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.
Ø50	8.0	10.0	71	62	100	4.5
				66		8.5
Ø63	12.5	10.0	45	88	126	8.5
				94		8.5
Ø80	8.5	10.0	67	122	160	8.5
				128		8.5
Ø100	6.5	10.0	88	162	200	8.5
				170		8.5
Ø125	4.5	10.0	127	212	250	8.5
				220		8.5
Ø160	4.0	10.0	143	282	320	8.5
				290		8.5
Ø200	2.5	10.0	229	362	400	8.5
				370		8.5
Ø250	2.4	10.0	239	462	500	8.5
				470		8.5