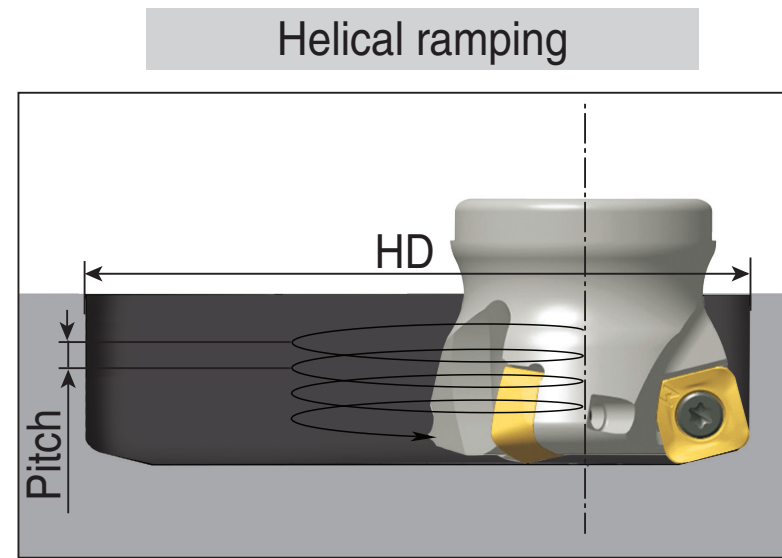
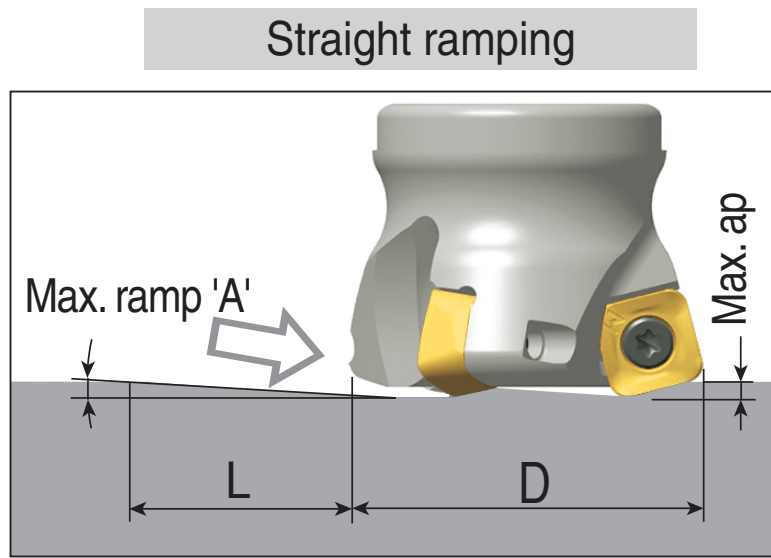


Ramping Data

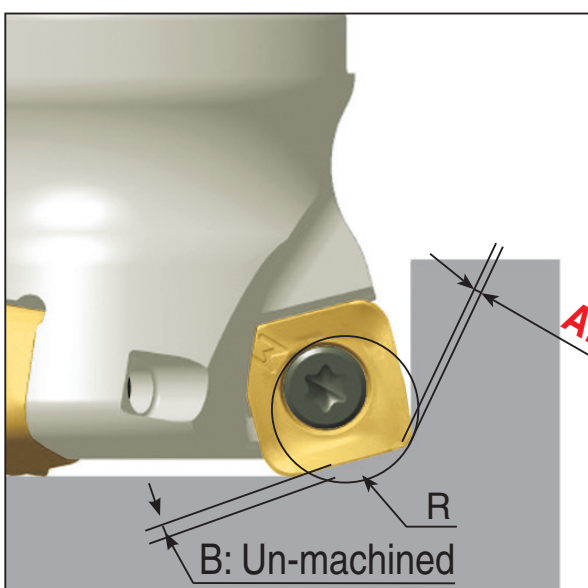


SBMT 06

(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	2.2	1.0	25.5	22.8		0.7
					32	1.0
Ø17	2.4	1.0	23.4	24.8		0.9
					34	1.0
Ø20	3.2	1.0	17.9	30.8		1.0
					40	1.0
Ø21	3.1	1.0	18.5	32.8		1.0
					42	1.0
Ø25	2.4	1.0	23.4	40.8		1.0
					50	1.0
Ø32	1.8	1.0	31.8	54.8		1.0
					64	1.0
Ø40	1.3	1.0	42.5	70.8		1.0
					80	1.0
Ø50	1.0	1.0	57.3	90.8		1.0
					100	1.0
Ø63	0.7	1.0	76.4	116.8		1.0
					126	1.0

Programming technical data



	R Program	A Over cut	B Un-machined
SBMT 06	1.8	0	0.81
	2.0	0	0.77
	2.2	0.01	0.73

:Recommended program 'R'