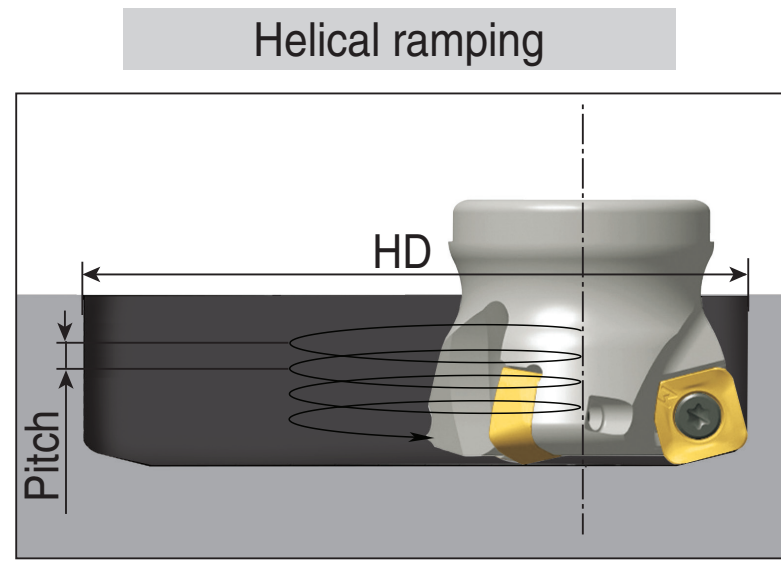
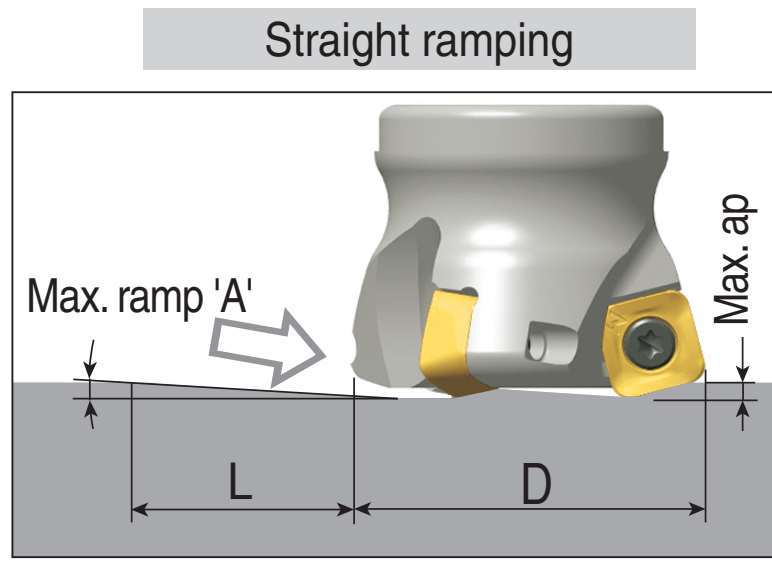


# Ramping Data

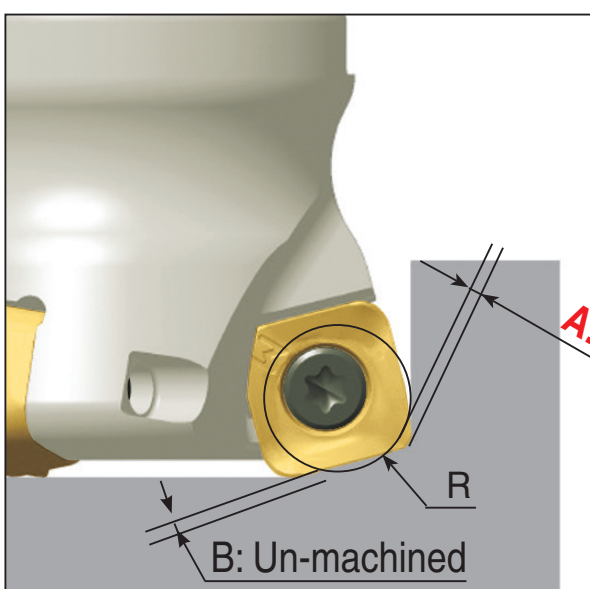


## SBMT 09

(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	1.6	1.2	43	36		1
					50	1.2
Ø26	1.7	1.2	40	38		1.1
					52	1.2
Ø30	3.1	1.2	22	46		1.2
					60	1.2
Ø32	3.9	1.2	18	50		1.2
					64	1.2
Ø33	3.7	1.2	19	52		1.2
					66	1.2
Ø35	3.4	1.2	18	56		1.2
					70	1.2
Ø40	2.8	1.2	25	66		1.2
					80	1.2
Ø42	2.6	1.2	26	70		1.2
					84	1.2
Ø50	2.0	1.2	34	86		1.2
					100	1.2
Ø52	1.9	1.2	38	90		1.2
					104	1.2
Ø63	1.5	1.2	43	112		1.2
					126	1.2
Ø66	1.1	1.2	63	118		1.2
					132	1.2
Ø80	1.2	1.2	63	146		1.2
					160	1.2

## Programming technical data



	R Program	A Over cut	B Un-machined
SBMT 09	3.5	0.1	0.81
	3	0	0.9
	2.5	0	0.98
	2	0	1.1

     :Recommended program 'R'