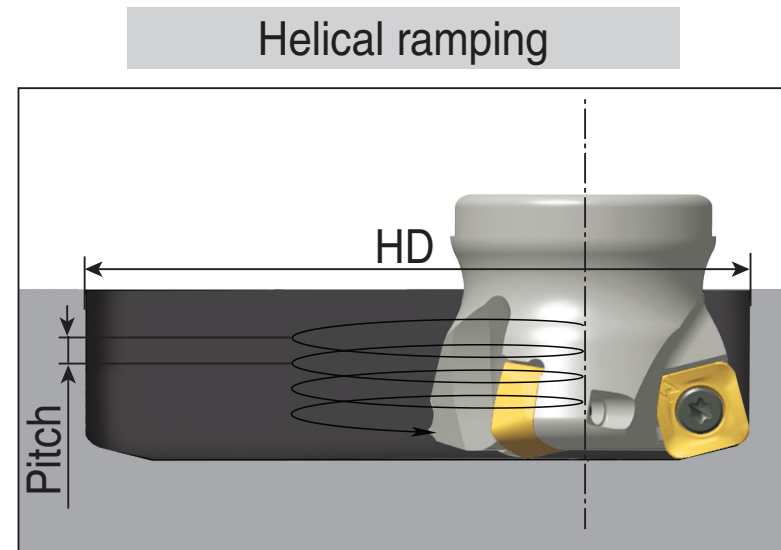
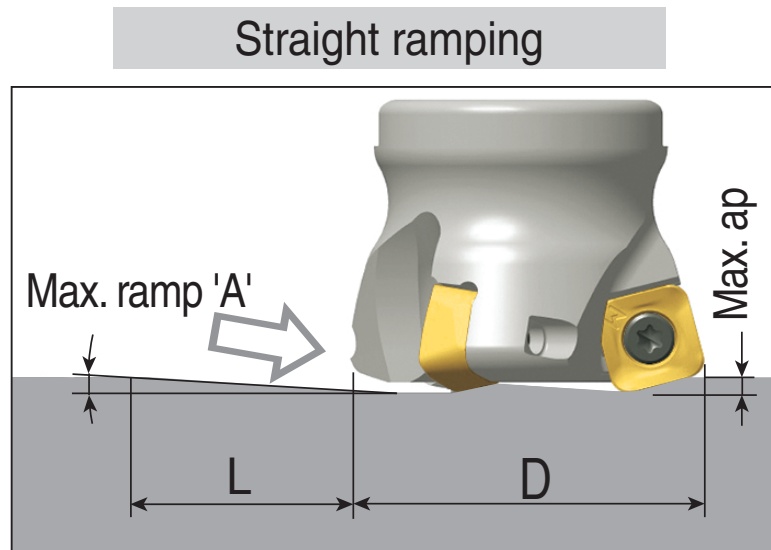


# Ramping Data

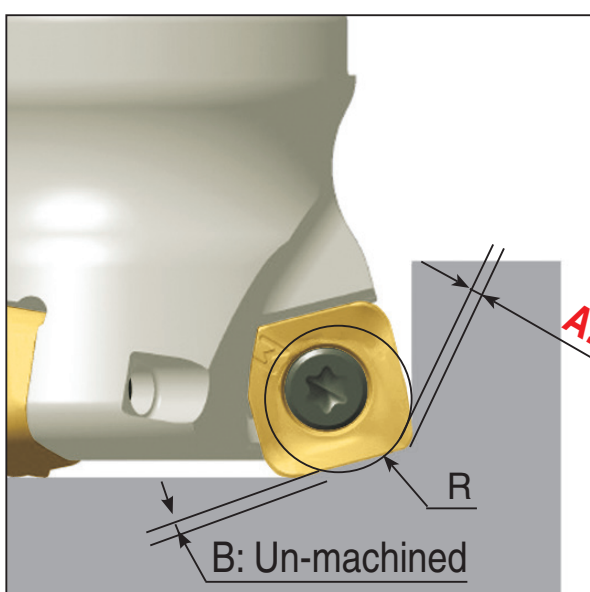


## SBMT 13

(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	7.0	2.0	16	47		2.0
					64	2.0
Ø33	6.9	2.0	17	49		2.0
					66	2.0
Ø35	6.4	2.0	18	53		2.0
					70	2.0
Ø40	5.3	2.0	22	63		2.0
					80	2.0
Ø42	4.4	2.0	26	67		2.0
					84	2.0
Ø50	4.3	2.0	27	83		2.0
					100	2.0
Ø52	4.0	2.0	29	87		2.0
					104	2.0
Ø63	2.9	2.0	40	109		2.0
					126	2.0
Ø80	2.0	2.0	57	143		2.0
					160	2.0
Ø100	1.5	2.0	76	183		2.0
					200	2.0
Ø125	1.1	2.0	104	233		2.0
					250	2.0
Ø160	0.8	2.0	104	303		2.0
					320	2.0
Ø200	0.6	2.0	127	383		2.0
					400	2.0
Ø250	0.5	2.0	164	483		2.0
					500	2.0

## Programming technical data



	R Program	A Over cut	B Un-machined
SBMT 13	4.0	0	1.62
	4.5	0	1.51
	5.0	0.04	1.4
	5.5	0.14	1.29
	6.0	0.28	1.18

:Recommended program 'R'