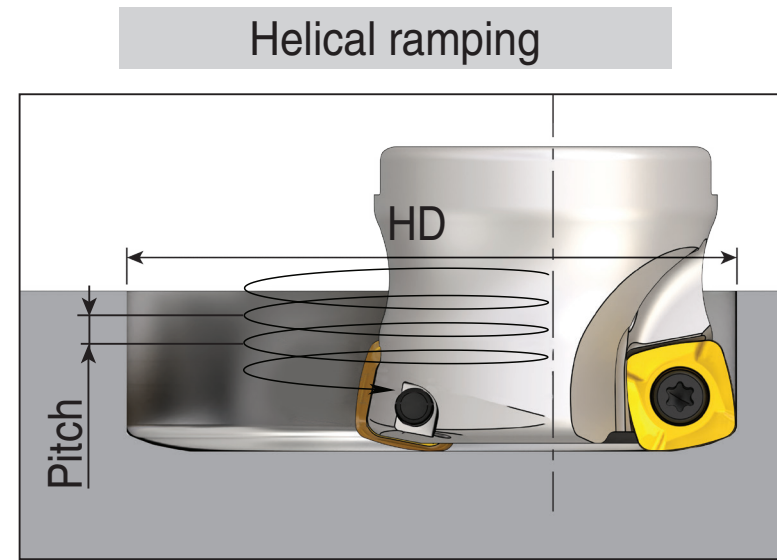
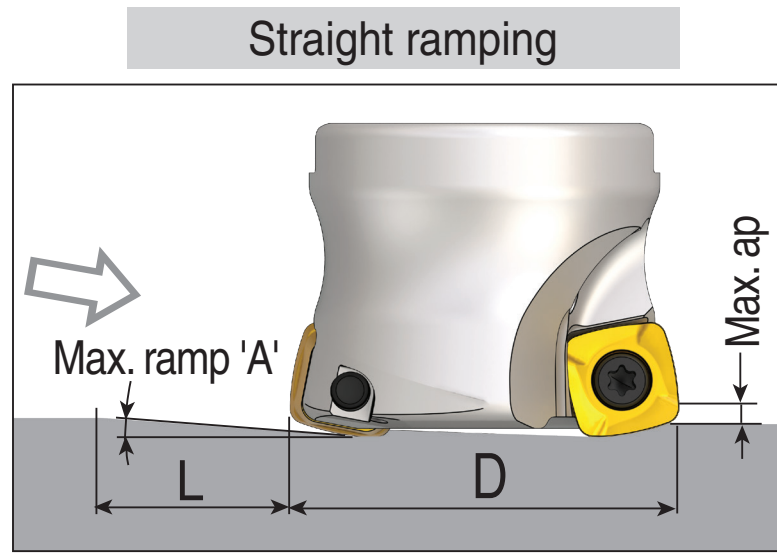


Ramping Data

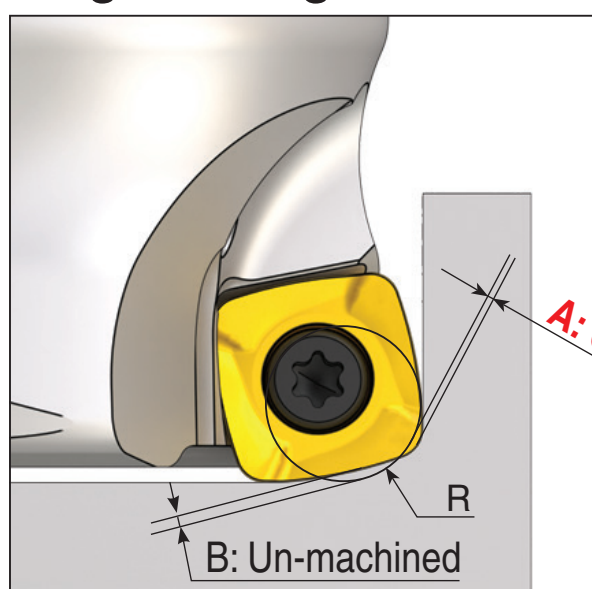


SRMT 14

(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	1.0	2.0	107	45		0.7
					64	1.8
Ø33	1.2	2.0	92	46.8		0.9
					66	2.0
Ø35	1.6	2.0	71	50.8		1.3
					70	2.0
Ø40	2.5	2.0	44	60.8		2.0
					80	2.0
Ø42	3.4	2.0	33	64.8		2.0
					84	2.0
Ø50	5.5	2.0	20	80.8		2.0
					100	2.0
Ø52	5.1	2.0	22	84.6		2.0
					104	2.0
Ø63	2.9	2.0	39	106.8		2.0
					126	2.0
Ø66	2.6	2.0	44	112.6		2.0
					132	2.0
Ø80	2.0	2.0	57	140.6		2.0
					160	2.0
Ø100	1.4	2.0	81	180.6		2.0
					200	2.0
Ø125	1.1	2.0	104	230.6		2.0
					250	2.0
Ø160	1.0	2.0	114	300.6		2.0
					320	2.0
Ø200	0.8	2.0	143	380.6		2.0
					400	2.0

Programming technical data



	R Program	A Over cut	B Un-machined
SRMT 14	3.0	0	1.31
	3.5	0	1.18
	3.6	0	1.15
	3.7	0.01	1.13
	4.0	0.03	1.05

:Recommended program 'R'