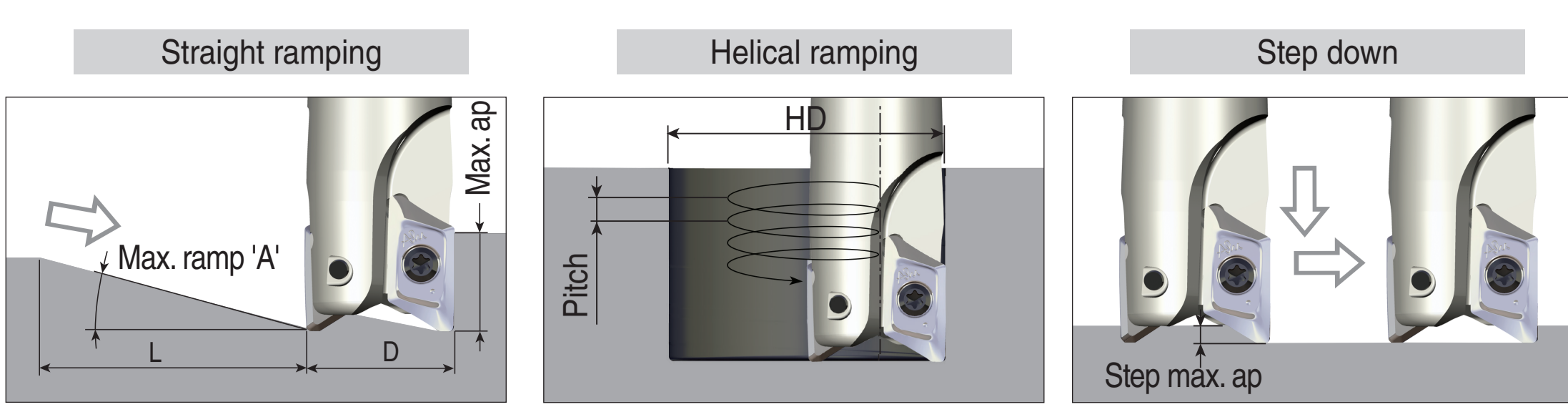


# Ramping Data



## XEVT 16: 0.4R-1.6R

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø25	20.5	16	43	29.1	50	4.1	4
						13.6	4
Ø32	17.5	16	51	43.1	64	9.3	4
						13.6	4
Ø40	11.0	16	82	59.1	80	9.9	4
						13.6	4
Ø50	8.5	16	107	79.1	100	11.6	4
						13.6	4
Ø63	5.5	16	166	105.1	126	10.8	4
						13.6	4
Ø80	4.3	16	213	139.1	160	11.9	4
						13.6	4
Ø100	3.3	16	278	179.1	200	12.2	4
						13.6	4
Ø125	2.5	16	367	229.1	250	12.1	4
						13.6	4
Ø160	1.9	16	483	299.1	320	12.3	4
						13.6	4
Ø200	1.5	16	611	379.1	400	12.5	4
						13.6	4

## XEVT 16: 2.0R-2.4R

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø25	19.5	15.5	44	29.1	50	3.9	3.5
						13.2	3.5
Ø32	16.5	15.5	52	43.1	64	8.8	3.5
						13.2	3.5
Ø40	10.5	15.5	84	59.1	80	9.4	3.5
						13.2	3.5
Ø50	8.0	15.5	110	79.1	100	10.9	3.5
						13.2	3.5
Ø63	5.0	15.5	177	105.1	126	9.8	3.5
						13.2	3.5
Ø80	3.9	15.5	227	139.1	160	10.7	3.5
						13.2	3.5
Ø100	3.0	15.5	296	179.1	200	11.1	3.5
						13.2	3.5
Ø125	2.3	15.5	386	229.1	250	11.2	3.5
						13.2	3.5
Ø160	1.7	15.5	523	299.1	320	11.0	3.5
						12.7	3.5
Ø200	1.3	15.5	683	379.1	400	10.8	3.5
						12.1	3.5

## XEVT 16: 3.0R-3.2R

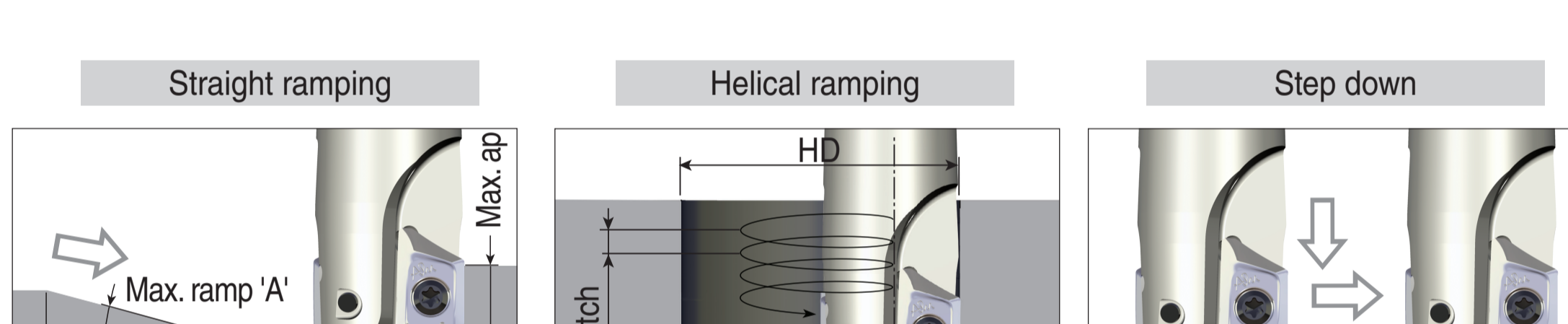
(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø25	18.5	14.5	43	29.1	50	3.7	2.8
						12.3	2.8
Ø32	16.0	14.5	51	43.1	64	8.5	2.8
						12.3	2.8
Ø40	9.5	14.5	87	59.1	80	8.5	2.8
						12.3	2.8
Ø50	7.0	14.5	118	79.1	100	9.5	2.8
						12.3	2.8
Ø63	5.0	14.5	166	105.1	126	9.8	2.8
						12.3	2.8
Ø80	3.7	14.5	224	139.1	160	10.2	2.8
						12.3	2.8
Ø100	2.8	14.5	297	179.1	200	10.3	2.8
						12.3	2.8
Ø125	2.1	14.5	396	229.1	250	10.2	2.8
						12.2	2.8
Ø160	1.5	14.5	554	299.1	320	9.7	2.8
						11.2	2.8
Ø200	1.2	14.5	693	379.1	400	10.0	2.8
						11.2	2.8

## XEVT 16: 4.0R-5.0R

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø25	17.5	14.5	46	29.1	50	3.4	2.5
						12.3	2.5
Ø32	15.0	14.5	54	43.1	64	7.9	2.5
						12.3	2.5
Ø40	8.5	14.5	97	59.1	80	7.6	2.5
						12.3	2.5
Ø50	6.5	14.5	127	79.1	100	8.8	2.5
						12.3	2.5
Ø63	4.5	14.5	184	105.1	126	8.8	2.5
						12.3	2.5
Ø80	3.3	14.5	252	139.1	160	9.1	2.5
						12.3	2.5
Ø100	2.4	14.5	346	179.1	200	8.8	2.5
						11.2	2.5
Ø125	1.8	14.5	462	229.1	250	8.7	2.5
						10.5	2.5
Ø160	1.4	14.5	594	299.1	320	9.1	2.5
						10.4	2.5
Ø200	1.1	14.5	756	379.1	400	9.2	2.5
						10.2	2.5



## XEVT 22: 0.5R-0.8R

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø32	21.0	21.2	55	38.5	64	6.7	5.5
						18.0	5.5
Ø40	14.0	21.0	84	54.5	80	9.6	5.5
						17.9	5.5
Ø50	9.5	21.0	126	74.5	100	10.9	5.5
						17.9	5.5
Ø63	7.0	21.0	171	100.5	126	12.3	5.5
						17.9	5.5
Ø80	5.0	20.9	239	134.5	160	12.7	5.5
						17.8	5.5
Ø100	3.7	20.9	323	174.5	200	12.9	5.5
						17.3	5.5
Ø125	2.6	20.9	460	224.5	250	12.1	5.5
						15.1	5.5
Ø200	1.6	20.9	749	374.5	400	13.0	5.5
						14.9	5.5

## XEVT 22: 1.6R-2.0R

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø32	20.5	21.0	56	38.5	64	6.5	5.0
						17.9	5.0
Ø40	13.5	20.9	87	54.5	80	9.3	5.0
						17.8	5.0
Ø50	9.5	20.9	125	74.5	100	10.9	5.0
						17.8	5.0
Ø63	6.7	20.9	178	100.5	126	11.8	5.0
						17.8	5.0
Ø80	4.7	20.8	253	134.5	160	12.0	5.0
						17.5	5.0
Ø100	3.5	20.8	340	174.5	200	12.2	5.0
						16.3	5.0
Ø125	2.5	20.8	477	224.5	250	11.6	5.0
						14.6	5.0
Ø200	1.5	20.8	795	374.5	400	12.2	5.0
						14.0	5.0

## XEVT 22: 3.0R-4.0R

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø32	20.0	20.0	55	38.5	64	6.3	4.0
						17.0	4.0
Ø40	12.3	19.9	91	54.5	80	8.4	4.0
						16.9	4.0
Ø50	8.5	19.9	133	74.5	100	9.8	4.0
						16.9	4.0
Ø63	5.5	19.9	207	100.5	126	9.6	4.0
						16.2	4.0
Ø80	4.0	19.8	283	134.5	160	10.2	4.0
						14.9	4.0
Ø100	3.0	19.8	378	174.5	200	10.4	4.0
						14.0	4.0
Ø125	2.0	19.8	567	224.5	250	9.3	4.0
						11.6	4.0
Ø200	1.0	19.8	1135	374.5	400	8.1	4.0
						9.3	4.0

## XEVT 22: 5.0R

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø32	19.0	19.5	57	38.5	64	6.0	3.5
						16.6	3.5
Ø40	11.4	19.4	96	54.5	80	7.8	3.5
						16.5	3.5
Ø50	7.5	19.4	147	74.5	100	8.6	3.5
						16.5	3.5
Ø63	5.0	19.4	222	100.5	126	8.8	3.5
						14.7	3.5
Ø80	3.5	19.3	316	134.5	160	8.9	3.5
						13.1	3.5
Ø100	2.5	19.3	442	174.5	200	8.7	3.5
						11.6	3.5
Ø125	1.7	19.3	651	224.5	250	7.9	3.5
						9.9	3.5
Ø200	0.8	19.3	1383	374.5	400	6.5	3.5
						7.4	3.5

## XEVT 22: 6.4R

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø32	18.0	18.8	58	38.5	64	5.6	3.0
						16.0	3.0
Ø40	10.0	18.7	106	54.5	80	6.8	3.0
						15.9	3.0
Ø50	6.5	18.7	164	74.5	100	7.4	3.0
						15.2	3.0