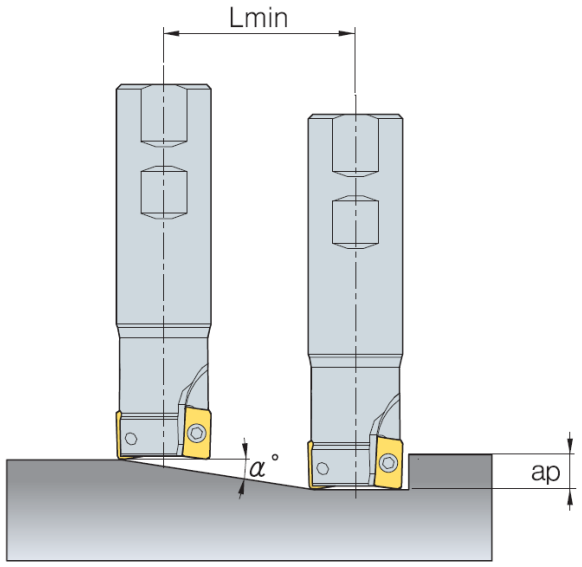
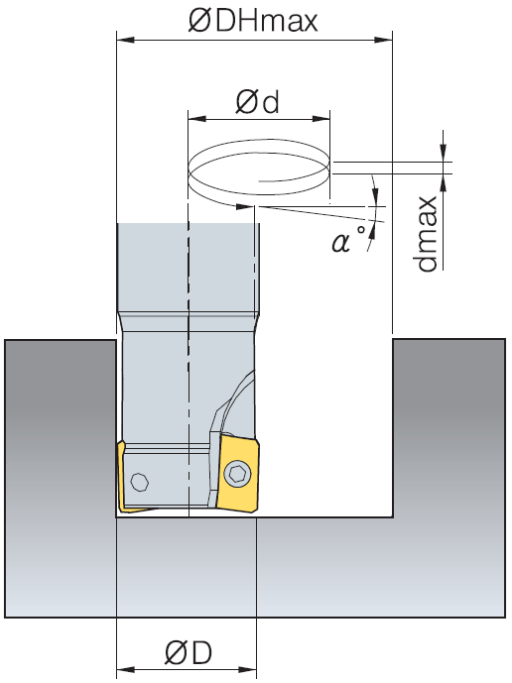
Technical Details

1. Ramping

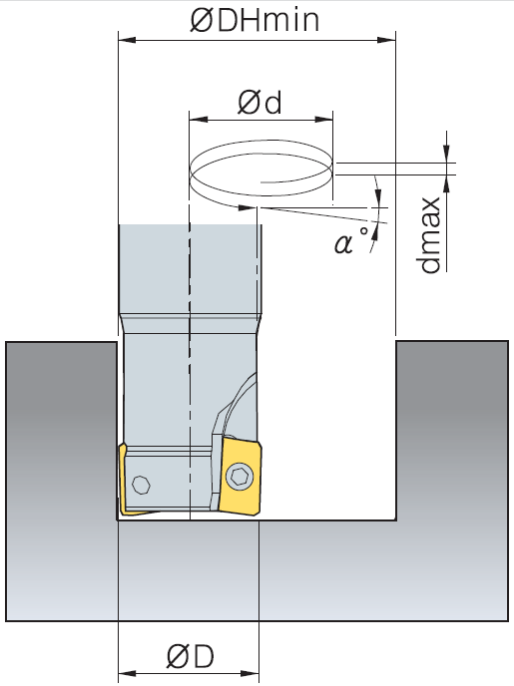


* In ramping and helical machining, use coolant and air. **Lmin = ap/tan (α°)**

2. Helical Cutting Blind Holes



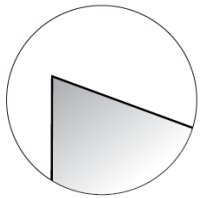
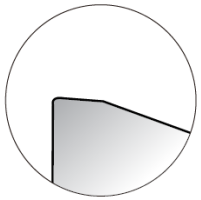
3. Helical Cutting Through Holes



(inch)

Part #	Tool Diameter ØD(min)	ap	1. Ramping		2. Helical Cutting for Blind Holes				3. Helical Cutting for Through Holes	
			Max. Rake Angle α°	L min	Min. Machining Dia. ØDHmin	Max. pitch dmax	Max. Machining Dia. ØDHmax	Max. pitch dmax	Min. Machining Dia. ØDHmin	Max. pitch dmax
01-0292	0.5	0.22	4.52	2.492	0.906	0.072	0.953	0.075	0.724	0.057
01-0293	0.625	0.22	3.33	3.384	1.156	0.067	1.203	0.07	0.974	0.057
01-0294	0.75	0.22	2.64	4.277	1.406	0.065	1.453	0.067	1.224	0.056

Technical Details

Chip Breaker	Cutting Edge Shape	Recommended chip breaker and grade by work piece material (✓ 1st recommendation)									
		P				M		K		N	
		Low carbon steel Mild steel		High Carbon steel Alloy steel		Stainless steel		Cast iron		Non-ferrous metal	
		C.B.	Grades	C.B.	Grades	C.B.	Grades	C.B.	Grades	C.B.	Grades
-		-	-	-	-	-	-	-	-	✓	✓ HN25A
MHS		✓	✓ HU30	✓	✓ HU30	✓	✓ HU30	✓	✓ HU30	-	-