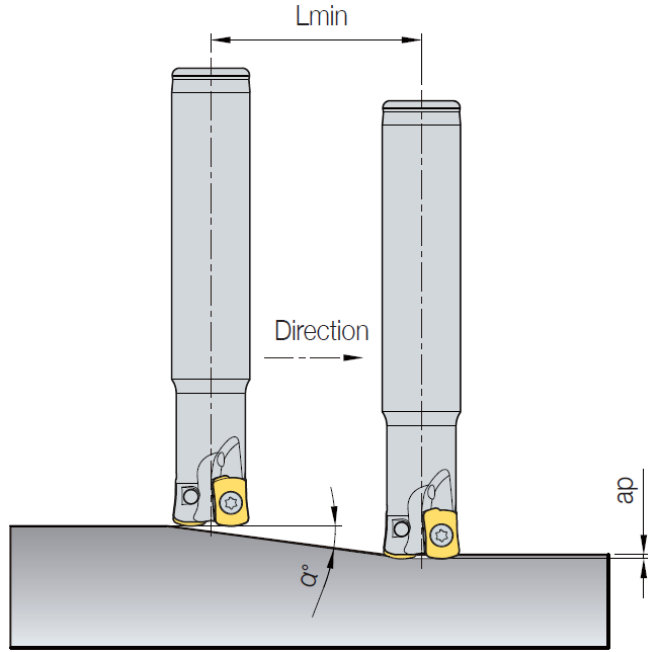


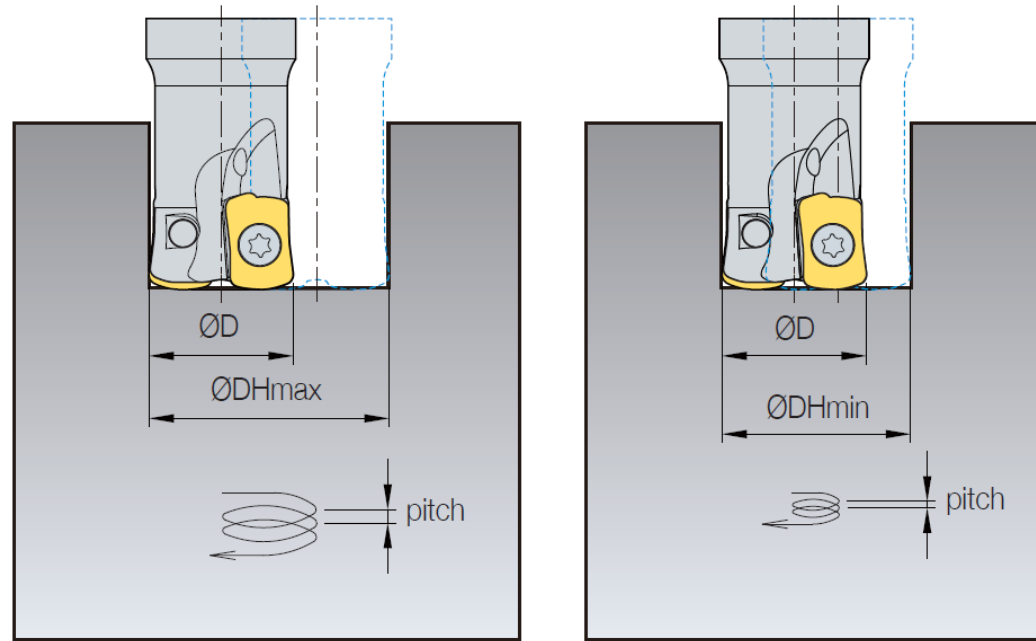
Technical Details



Ramping



Helical Interpolation



* In ramping and helical machining, use coolant and air. $L_{min} = \frac{ap}{\tan(\alpha^\circ)}$



(mm)

Tool Part #	Tool Diameter $\varnothing D$	Depth of Cut [ap]	Radial Depth of Cut [ap,R]	Ramping	Profiling		Helical Interpolation			Enlarge Hole
				Max. Rake Angle α°	Programmed Corner Radius	Uncut Chip Thickness	Min Machining Dia. $\varnothing D_{min}$	Max Machining Dia. $\varnothing D_{max}$	Helical Interpolation Pitch	Enlarge Width
01-0472	16	0.9	3.5	3.6	2.0	0.30	21	30	0.9	12.5
01-0473	20	1.0	3.7	3.3			29	38		1.0
01-0474	25			2.2			39	48	21.3	
01-0475	32			1.5			53	62	28.3	



Technical Details



Insert Part #	Recommended chip breaker and grade by work piece material (✓ 1st recommendation)						
	Chip Breaker	P	M	K	S	H	
		Steels	Stainless Steels	Cast Iron	High-Temp Alloys	Hardened Materials	
02-0659	General		✓	✓	✓	-	-
02-0660	Reinforced Edge		✓	-	✓	-	✓