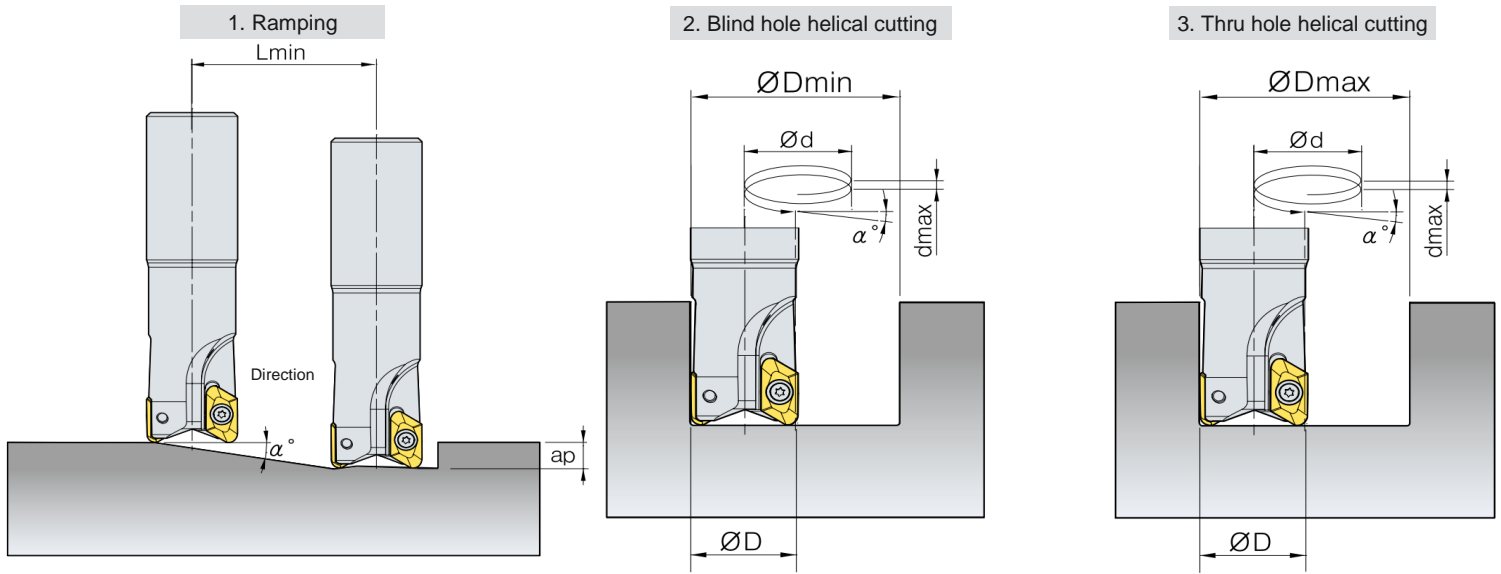


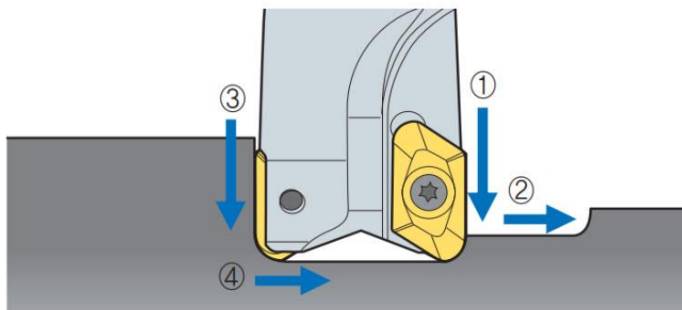
Technical Details



(mm)

Tool	Tool Diameter $\varnothing D$	1. Ramping		2. Helical Cutting for Blind Hole				3. Helical Cutting for Through Holes	
		Max. Rake Angle α°	L min.	Min. Machining Dia. $\varnothing D_{min}$	Max. Pitch d_{max}	Min. Machining Dia. $\varnothing D_{max}$	Max. Pitch d_{max}	Min. Machining Dia. $\varnothing D_{min}$	Max. Pitch d_{max}
01-0530	25	13.2	43	42	0.36	44	0.38	34	0.30
01-0531	32	9.5	60	56	0.36	58	0.36	48	0.30
01-0529	50	5.4	105	92	0.33	94	0.33	84	0.30
01-0528	80	3.2	180	152	0.33	154	0.33	144	0.30

Plunging, slotting, drilling technical data



* Maximum depth per plunge is 4.0mm

1. When drilling and grooving, machining sequence is

① → ② → ③ → ④

2. When drilling and grooving, decrease the feed and cutting speed 30% to 50% from recommended data