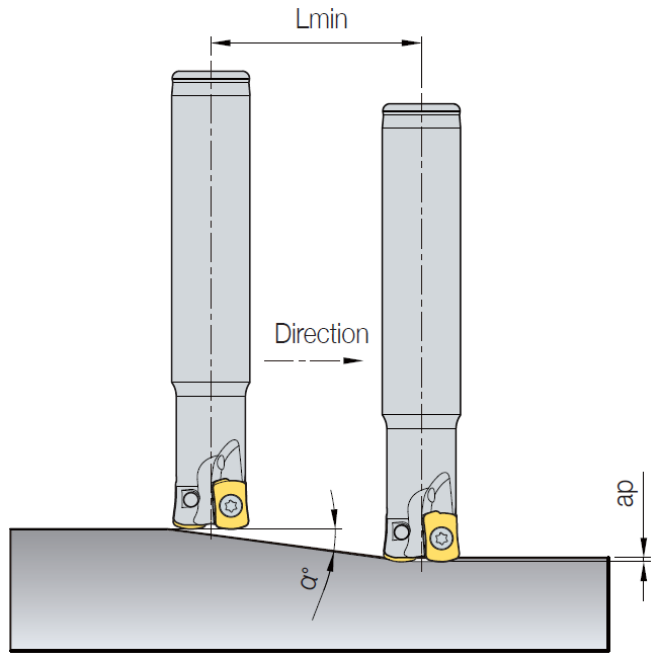


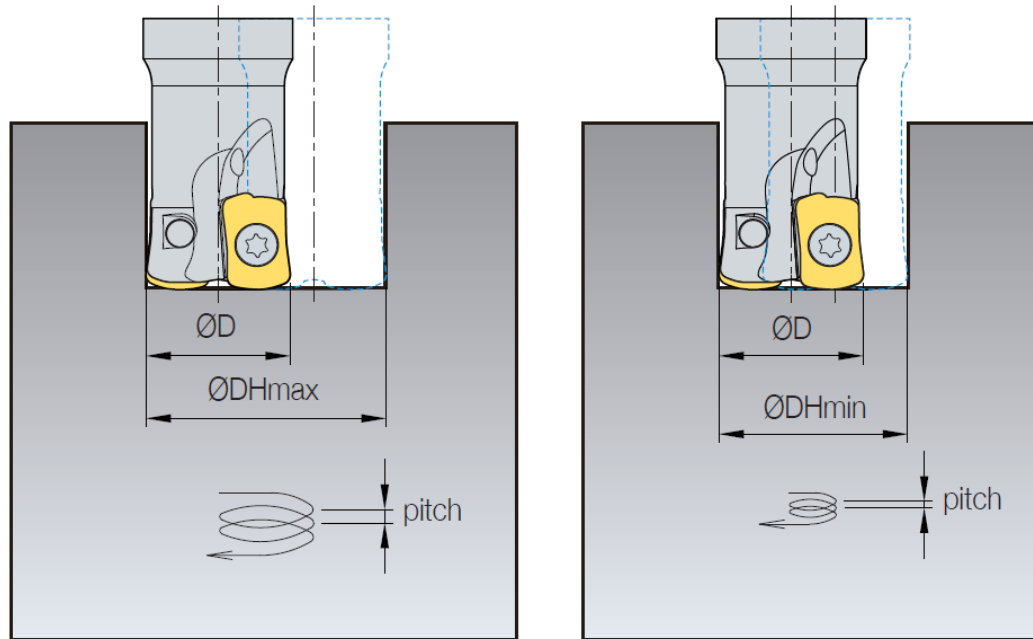
# Technical Details



## Ramping



## Helical Interpolation



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



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 $\alpha^\circ$	Programmed Corner Radius	Uncut Chip Thickness	Min Machining Dia. $\varnothing D_{min}$	Max Machining Dia. $\varnothing D_{max}$	Helical Interpolation Pitch	Enlarge Width
01-0277	0.625	0.035	0.137	3.40	0.79	0.011	0.817	1.171	0.035	0.487
01-0278	0.750			2.00		0.012	1.067	1.421	0.039	0.604
01-0279	1.000			1.20		0.012	1.567	1.921	0.039	0.854
01-0280	1.250			0.90		0.012	2.067	2.421	0.039	1.104

\*Units in Inch



# 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		✓	-	✓	-	✓