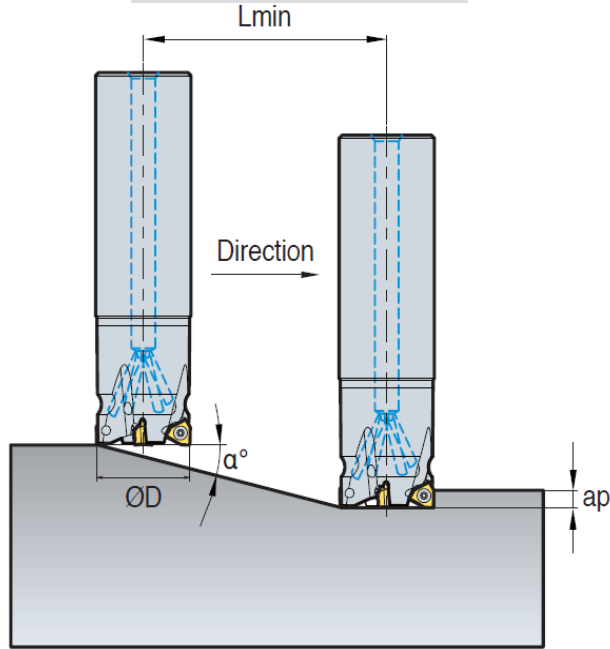


Technical Details

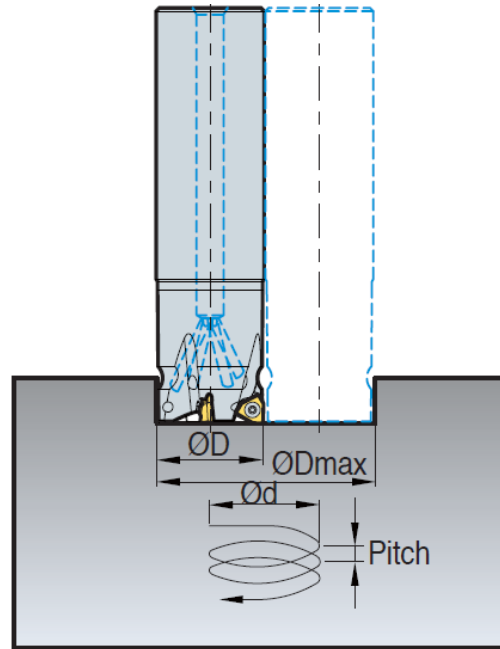


1. Ramping

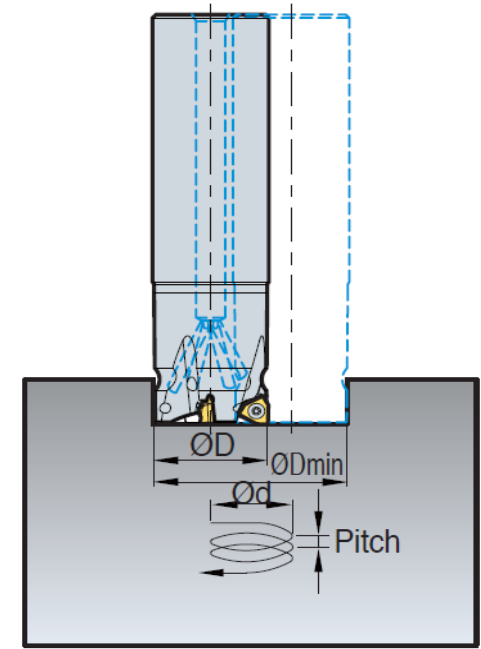


* In ramping and helical machining, use coolant and air. $L_{min} = \frac{ap}{\tan(\alpha^\circ)}$

2. Helical Cutting Blind Holes



3. Helical Cutting Through Holes



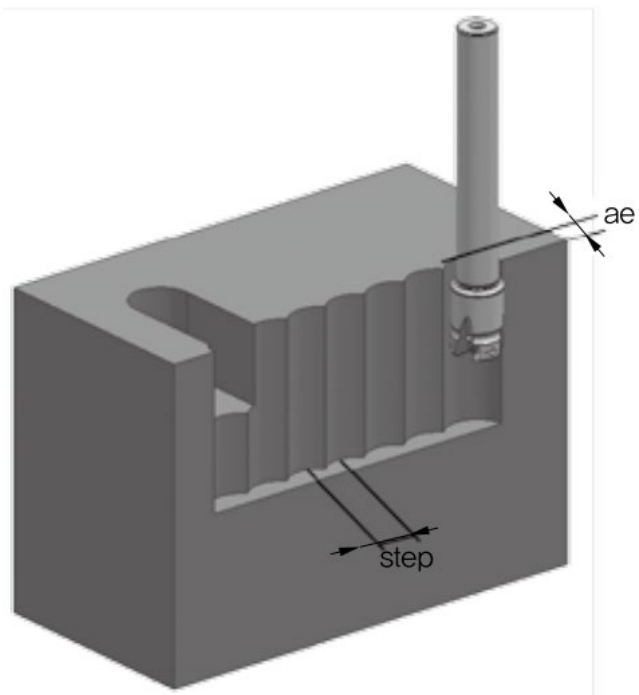
Part #	Tool Diameter OD	ap	1. Ramping		2. Helical Cutting for Blind Holes				3. Helical Cutting for Through Holes	
			Max. Rake Angle α°	L min	Min Machining Dia. OD_{min}	Maximum Pitch	Max Machining Dia. OD_{max}	Maximum Pitch	Min Machining Dia.	Maximum Pitch
01-0156	0.75	0.217	17.5	0.708	1.4	0.217	1.44	0.217	1.212	0.22
01-0157	1	0.217	9.5	1.294	1.9	0.217	1.94	0.217	1.712	0.22
01-0158	1.25	0.217	6.5	1.901	2.4	0.217	2.44	0.217	2.212	0.22



Technical Details



4. Plunging



Max. ae	ae	Cutter Diameter (Ø)		
		Ø0.75	Ø1	Ø1.25
		Max Step		
0.098	0.039	0.335	0.389	0.437
	0.079	0.46	0.539	0.607

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
HS		-	✓ HP25	-	✓ HP25	✓	✓ HU30	✓	✓ HU30	-	-
		-	HU30	-	HU30	-	HU40	-	HU40	-	-
MHS		✓	✓ HP25	✓	✓ HP25	-	-	-	-	-	-
		-	HU30	-	HU30	-	-	-	✓ HU30	-	-