Guide for Drilling

[Drilling Depth]

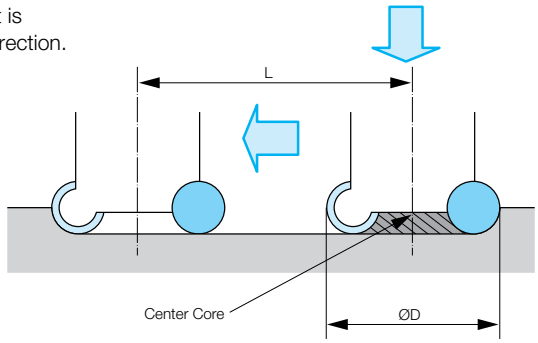
Refer to Max. Cutting Depth **(Pd)** value in Toolholder Dimension table on **page** ➔ **J22-J23**.

[Traversing After Drilling]

Caution when Traversing right after Drilling

① Reduce the table feed by 50% of the recommended conditions until the center core part is completely cut off. The internal cutting edge's radial rake angle is large in the negative direction.

② Min cutting length **(L)** for flat bottom face in table below.



Insert Part Number	L (mm)
RDMT08T2M0-H	ØD-7
RPMT10T3M0	ØD-9
RPMT1204M0	ØD-11
RPMT1204M0-H	
RPMT1606M0-H	ØD-15

Guide for Ramping

- Ramping angle should be under ***α* Max.** (maximum ramping angle) in table below
- Feed rate should be under 70% of the cutting conditions on **page** ➔ **J24**

Part Number		α Max. (°)	tan α Max.
MRP	012-S16-08(-160)	Ramping is not available	
	016-S16-08(-160)	4°	0.070
	020-S20-08(-180)	14°	0.249
MRP	025-S25-10-3T(-180)	14°	0.249
	032-S32-10-4T(-200)	8°	0.141
MRP	032-S25-12(-300)	15°	0.268
	040-S32-12(-300)	10°	0.176
	040-S32-12-4T(-200)	9°	0.158
	050-S42-12(-300)	7°	0.123
MRP	040-S32-16(-300)	20°	0.364
	050-S42-16(-300)	13°	0.231
	063-S42-16(-300)	8°	0.141
MRP	050R-10-6T	4°	0.070
	063R-10-7T	3°	0.052
MRP	050R-12	7°	0.123
	063R-12	5°	0.087
	080R-12	3°	0.052
	080R-12-7T	3°	0.052
MRP	080R-16	6°	0.105
	100R-16	4°	0.070
	100R-16-7T	3°	0.052
	125R-16	3°	0.052
	125R-16-8T	2°	0.035
MRP	080R-20	8°	0.141
	100R-20	6°	0.105

* Above is the value considering the clearance 1mm between the tool body and the workpiece.

Formula for Max. Cutting Length "L" at Max. Ramping Angle

$$L = \frac{D.O.C.}{\tan \alpha \text{ Max.}}$$