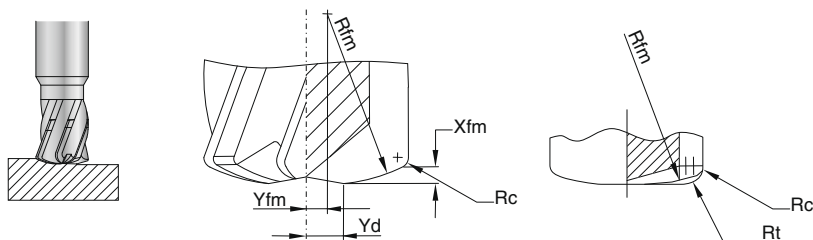


Ramping / Arc Machining

Details of 6PDRS cutting edge shape



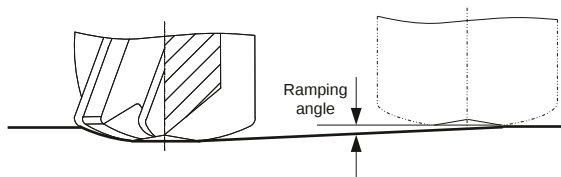
Xfm : Max. Depth of Cut
 Yfm : Distance between center line of tool and center line of Rfm
 Yd : Distance between center line of tool and start position of cutting edge
 Rfm : Radius of tool tip
 Rc : Corner R
 Rt : Virtual radius in program

Description	Outside Dia.	Max. Depth of Cut (mm)	Radius of tool tip	Corner R	Distance between center line of tool and center line of Rfm	Distance between center line of tool and start position of cutting edge	Virtual radius in program
	ϕDc	Xfm	Rfm	Rc	Yfm	Yd	Rt
6PDRS060-045-06	6	0.32	6	0.62	0.75	1.32	0.62
6PDRS080-060-08	8	0.42	8	0.83	1.00	1.76	0.83
6PDRS100-075-10	10	0.53	10	1.04	1.25	2.20	1.04
6PDRS120-090-12	12	0.63	12	1.24	1.50	2.64	1.24

- We do not recommend machining with a cut amount exceeding the Xfm value.

About Ramping

During ramping, please reduce the table feed rate with the ratio of the chart on the right.



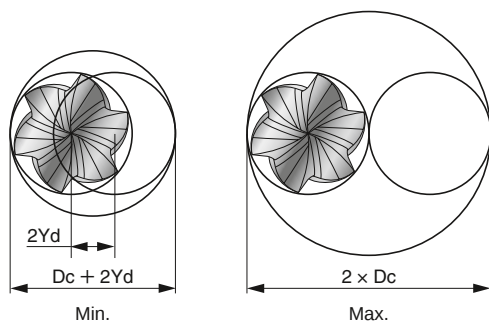
Ramping angle	1°	2°	3°	4°	5°
Feed rate when ramping	100%	70%	50%	30%	10%

* Please refer to page L32 for standard cutting conditions.

- During pocket machining, set the recess angle at 0.5 degrees.
- We do not recommend vertical milling.

About Arc Machining

Please use the range of the chart on the right, for one pass of machining hole diameter.



Description	Min.	Max.
6PDRS060-045-06	8.64	12.00
6PDRS080-060-08	11.52	16.00
6PDRS100-075-10	14.40	20.00
6PDRS120-090-12	17.28	24.00

