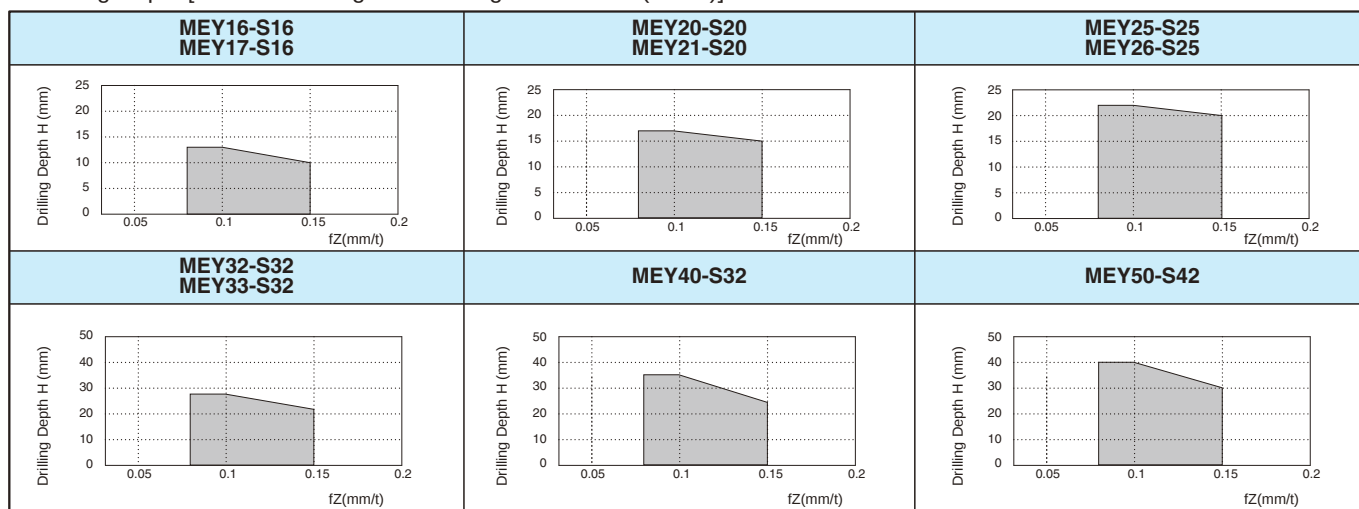


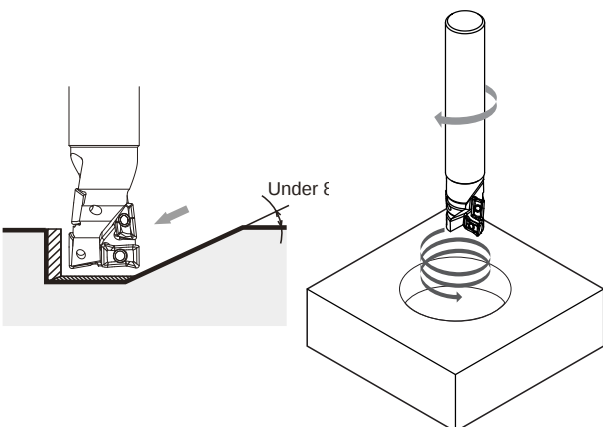
Drilling Depth [Standard / Long Head / Long Shank: C50 (S50C)]



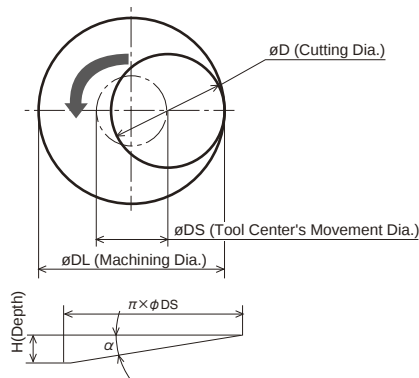
How to Use MEY Effectively

Ramping / Helical Milling

- Ramping angle is recommended to be under 8°.
- Plunge depth per revolution of helical milling should be set under 1/2 of the tool diameter.



Helical Milling Factors



How to Find "φDS"

$$\phi DS = \phi DL - \phi D$$

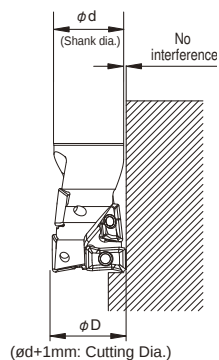
How to Find "h"

$$H = \phi DS \times \tan \alpha$$

(α should be under 8°)

Endmilling

- Tools with 1mm larger cutting diameter than shank diameter are available.
- High wall shouldering is possible
- Lineup



M



Milling