

MRP Radius Mill

Guide for Drilling

【Depth of Drilling】

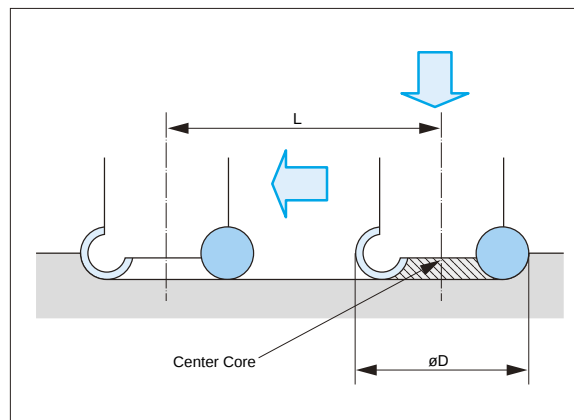
- See Pd value of Toolholder Dimension Table in page M127, M128.
(Pd Shows the maximum plunge depth.)

【Traversing after Drilling】

When Traversing after Drilling

- ① Reduce the table feed by 50% until the center core part (remainder of grinding) is completely cut off.
(The internal cutting edge's radial rake angle is larger in the negative direction)
- ② The Min. transfer length “L” to make the flat face is as follows.

Insert	L (mm)
RDMT08T2M0-H	$\phi D-7$
RPMT10T3M0	$\phi D-9$
RPMT1204M0	$\phi D-11$
RPMT1204M0-H	$\phi D-11$
RPMT1606M0-H	$\phi D-15$



Guide for Ramping (Slant Milling)

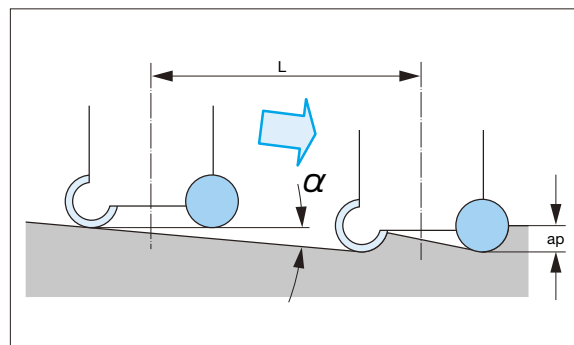
The transfer length “L” at the maximum slant angle α in the ramping operation depends on the a_p .

Toolholder	Angle α (°)	$\tan \alpha$
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 of the Transfer Length “L” at Max. Slant Angle

$$L = \frac{a_p}{\tan \alpha}$$



M



Milling