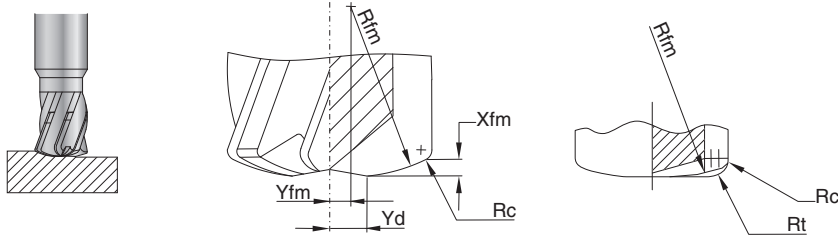


6PDRS Ramping / Arc cutting

Details of 6PDRS cutting edge shape



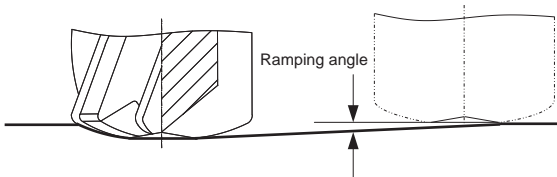
Xfm: Maximum depth of cut
 Yfm: Distance between the center line of tool and the center of Rfm
 Yd: Distance between the center line of tool and the start position of cutting edge
 Rfm: Radius of tool tip
 Rc: Corner-R
 Rt: Virtual radius in program

Description	Outside Dia.	Depth of Cut	Radius of Tool Tip	Corner-R	Distance between the center line of tool and the center of Rfm	Distance between the center line of tool and the 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

- Cutting with cut amount exceeding the Xfm value is not recommended.

Ramping

During ramping, lower the feed rate to the ratio in the chart on the right.

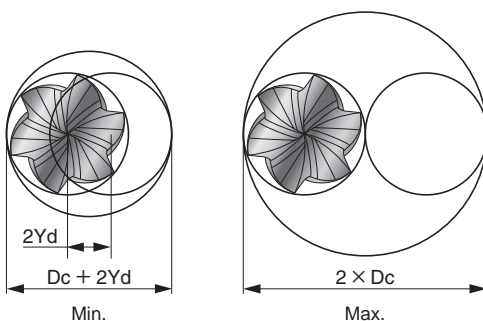


Ramping angle	1°	2°	3°	4°	5°
Ratio of feed rate	100%	70%	50%	30%	10%

- During pocket cutting, set the ramping angle at 0.5°.
- Vertical milling is not recommended.

Circular Interpolation

For arc cutting, hole diameter of each cutting should be within the range in the chart on the right.



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

