

Holder Type	Diameter D1 (mm)	Insert Corner Radius Re (mm)	Ramping		Helical Milling (Blind Hole, Flat Bottom)				Helical Milling	
			Maximum Ramping Angle α°	Minimum Distance L (mm) ★1	Maximum Hole Diameter DH max. (mm)	Maximum Pitch P max. (mm)	Minimum Hole Diameter DH min. (mm)	Maximum Pitch P max. (mm)	Minimum Hole Diameter DH min. (mm)	Maximum Pitch P max. (mm)
B type	20	4	17.5	47	31.5	10	31.8	10	22	1
		5	16.6	71	29.5	6	31.1	7	22	1
	25	4	15.1	55	41.5	10	41.4	10	32	5
		5	13.7	61	39.5	9	40.6	9	32	5
	28	4	14.1	59	47.5	10	47.2	10	36	6
		5	13	65	45.5	9	46.4	9	36	5
	32	4	12.7	66	55.5	10	55.1	10	46	9
		5	12	70	53.5	9	54.3	9	46	8
	35	4	10.8	78	61.5	10	61	10	50	8
		5	10.2	83	59.5	9	60.2	9	50	8
	40	4	8.8	96	71.1	10	70.9	10	62	10
		5	8.2	103	69.1	9	70.1	9	62	9
	50	4	6.3	135	91.1	10	90.6	10	81	10
		5	5.8	146	89.1	9	89.8	9	81	9
	63	4	4.6	184	117.1	10	116.6	10	107	10
		5	4.2	202	115.1	9	115.7	9	107	9
	80	4	3.4	250	151.1	10	150.5	10	141	10
		5	3.1	274	149.1	9	149.6	9	141	9
	100	4	2.6	326	191.1	10	190.5	10	181	10
		5	2.4	354	189.1	9	189.6	9	181	9
	125	4	2	424	241.1	10	240.5	10	231	10
		5	1.8	471	239.1	9	239.6	9	231	9

(Note) The recommended ramping feed is 0.05mm/tooth or under.

★1) Using the maximum ramping angle, the distance to reach the maximum depth of cut is as follows:

L = (maximum depth of cut ap/tan α°). Maximum depth of cut A type is 15.5mm, B type is 14.8mm.

★2) Corner radius of 1.2mm. For other corner radii, use the following formula. {(cutting edge diameter D1) - (corner radius Re) - 0.25} × 2

★3) Corner radius of 2.4mm. For other corner radii, use the following formula. {(cutting edge diameter D1) - (corner radius Re) - 0.25} × 2

★4) Corner radius of 3.2mm. For other corner radii, use the following formula. {(cutting edge diameter D1) - (corner radius Re) - 0.25} × 2

MAX.DRILLING DEPTH

Type	Insert Corner Radius Re (mm)	Max.Drilling Depth (mm)					
		Cutting Edge Diameter D1					
		φ20	φ25	φ28	φ32	φ35	φ40—φ125
A type	0.4	5.3	5.2	5.2	5.2	5.3	5.3
	0.8	5.3	5.2	5.2	5.2	5.3	5.3
	1.2	5.3	5.2	5.2	5.2	5.3	5.3
	1.6	4.8	4.6	4.7	4.7	4.9	4.8
	2.0	4.8	4.6	4.7	4.7	4.9	4.8
	2.4	4.8	4.6	4.7	4.7	4.9	4.8
	3.0	4.3	3.7	4.2	4.2	4.4	4.4
	3.2	4.3	3.7	4.2	4.2	4.4	4.4
B type	4.0	3.7	2.7	3.7	3.6	3.8	3.8
	5.0	3.4	2.3	3.3	3.3	3.5	3.5

AXD4000 can be effectively used for pocket machining without the need for a prepared hole.

