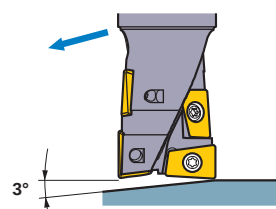


$\phi 32, \phi 33$				$\phi 35$				$\phi 40$				$\phi 50$			
Machining Diameter (mm)	Max. Depth of Cut (mm)	Feed (mm/rev)	DOC/pass (mm/pass)	Machining Diameter (mm)	Max. Depth of Cut (mm)	Feed (mm/rev)	DOC/pass (mm/pass)	Machining Diameter (mm)	Max. Depth of Cut (mm)	Feed (mm/rev)	DOC/pass (mm/pass)	Machining Diameter (mm)	Max. Depth of Cut (mm)	Feed (mm/rev)	DOC/pass (mm/pass)
38	16	0.25	0.66	42	18	0.28	0.77	48	20	0.30	0.88	60	25	0.35	1.10
48	24	0.22	1.76	53	27	0.24	1.97	60	30	0.26	2.19	75	38	0.30	2.74
58	32	0.20	2.85	63	35	0.21	3.07	72	40	0.22	3.51	90	50	0.26	4.39
38	16	0.20	0.49	42	18	0.22	0.58	48	20	0.25	0.66	60	25	0.28	0.82
48	24	0.18	1.32	53	27	0.2	1.48	60	30	0.22	1.65	75	38	0.26	2.06
58	32	0.16	2.14	63	35	0.18	2.3	72	40	0.20	2.63	90	50	0.24	3.29
38	6	0.20	0.33	42	7	0.22	0.38	48	8	0.25	0.44	60	10	0.28	0.55
48	11	0.18	0.88	53	13	0.2	0.99	60	14	0.22	1.10	75	18	0.26	1.37
58	16	0.16	1.43	63	18	0.18	1.53	72	20	0.20	1.75	90	25	0.24	2.19
38	22	0.25	0.82	42	25	0.28	0.95	48	28	0.30	1.10	60	35	0.35	1.37
48	27	0.22	2.19	53	30	0.24	2.47	60	34	0.26	2.74	75	43	0.30	3.43
58	32	0.20	3.57	63	35	0.21	3.84	72	40	0.22	4.39	90	50	0.26	5.49
38	22	0.27	0.66	42	25	0.3	0.77	48	28	0.32	0.88	60	35	0.37	1.10
48	27	0.24	1.76	53	30	0.26	1.97	60	34	0.28	2.19	75	43	0.32	2.74
58	32	0.22	2.85	63	35	0.21	3.07	72	40	0.24	3.51	90	50	0.27	4.39
38	6	0.16	0.33	42	7	0.17	0.38	48	8	0.18	0.44	60	10	0.20	0.55
48	11	0.14	0.88	53	13	0.15	0.99	60	14	0.16	1.10	75	18	0.18	1.37
58	16	0.12	1.43	63	18	0.13	1.53	72	20	0.14	1.75	90	25	0.16	2.19

■ FOR RAMPING



- When machining steel the recommended ramping angle is 3°. If a ramping angle larger than 3° is used, then the chips may not be broken effectively resulting in chips wrapping around the tool.
- When ramping, it is recommended to reduce the feed rate by 40%.

$\phi 32, \phi 33, \phi 35$		$\phi 40$		$\phi 50$	
Feed (mm/rev)	Step (mm)	Feed (mm/rev)	Step (mm)	Feed (mm/rev)	Step (mm)
0.055	0.3	0.06	0.3	0.065	0.3
0.05	0.3	0.055	0.3	0.06	0.3
0.05	0.25	0.055	0.25	0.06	0.25
0.065	0.5	0.07	0.5	0.075	0.5
0.065	0.3	0.07	0.3	0.075	0.3
0.04	0.25	0.045	0.25	0.05	0.25