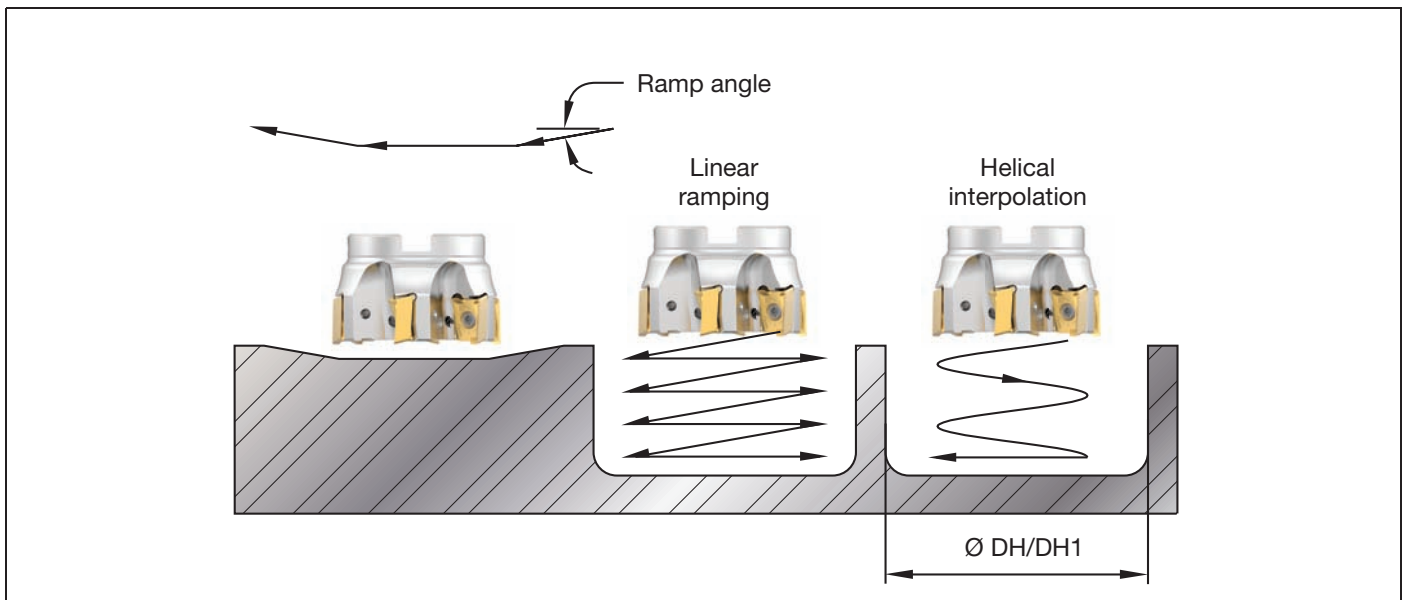


MILL 4-15™ APPLICATION GUIDELINES



SGE-R geometry for ramping and helical interpolation.



cutter dia.	max. ramp angle	DH min	DH1 max	max. dia.
25	2,63°	44.77	47.16	50
32	2,38°	58.64	60.81	64
35	2,12°	64.61	66.75	70
40	1,80°	74.57	76.82	80
50	1,38°	94.53	96.72	100
63	1,06°	120.52	122.72	126
80	0,82°	154.52	156.73	160
100	0,64°	194.52	196.73	200
125	0,51°	244.51	246.73	250
160	0,39°	314.51	316.74	320

DH min = Minimum hole diameter with helical interpolation

DH1 max = Maximum flat bottomed hole diameter with helical interpolation