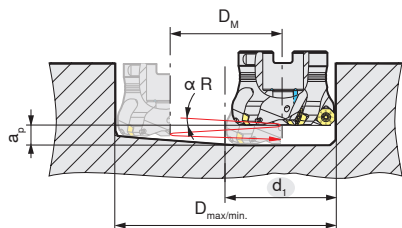


Helical plunge milling

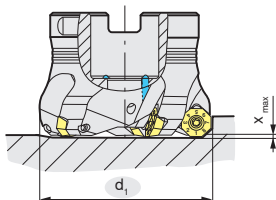


D_{max} [mm] = maximum diameter for flat bottom ground
 D_{min} [mm] = minimum hole diameter
 $D_M = D_{max} - d_i$ or $D_{min} - d_i$

d_i [mm]	$D_{max / r 0,8}$ [mm]	D_{min} [mm]	$\alpha_{R max}$ [°]
32	87	79	1,4
40	107	99	1,1
50	133	125	0,9
63	167	159	0,7
80	207	199	0,5
100	257	249	0,4
125	327	319	0,3

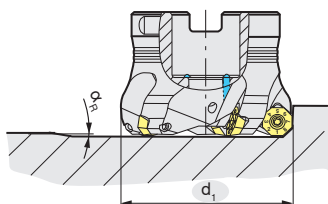
$$a_p \text{ [mm]} = D_M \times \pi \times \tan \alpha_R$$

Axial plunging



d_i [mm]	X_{max} [mm]
32	2,8
40	2,2
50	1,9
63	1,8
80	1,1
100	1,4
125	1,4

Angled ramping



d_i [mm]	α_R [°]
32	5,9
40	3,2
50	2,0
63	1,5
80	0,7
100	0,7
125	0,5