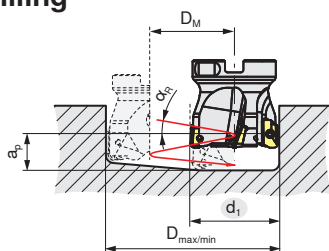
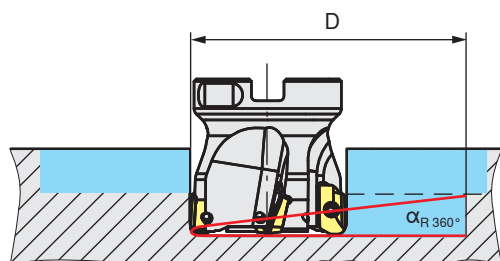


Helical plunge milling



D_{max} [mm] = maximum diameter for flat bottom ground
 D_{min} [mm] = minimum hole diameter
 $D_M = D_{max} - d_1$ or $D_{min} - d_1$

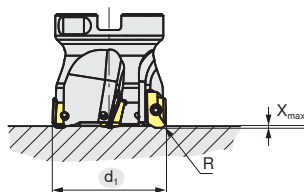


d_1 [mm]	$D_{max} / r 0,8$ [mm]	D_{min} [mm]	$\alpha_{R max}$ [°]
12	21	14	16,0
16	29	18	9,5
20	37	30	7,0
25	47	40	4,5
32	61	53	3,2
40	77	72	2,2
50	98	93	1,7
63	123	118	1,5
80	157	152	1,0
100	197	191	0,8
125	247	242	0,6
160	317	312	0,4

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

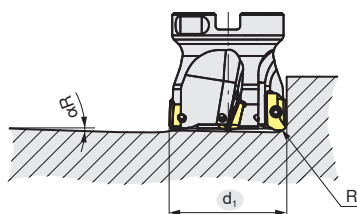
d_1 [mm]	D [mm]	$\alpha_{R max 360^\circ}$ [°]
12	14	16,0
16	18	9,5
20	30	7,0
25	40	4,5
32	53	3,2
40	72	2,2
50	93	1,7
63	118	1,5
80	152	1,0
100	191	0,8
125	242	0,6
160	312	0,4

Axial plunging



d_1 [mm]	X_{max} [mm]
12	1,3
16	1,5
20	2,0
25	2,0
32	1,8
40	1,6
50	1,6
63	1,6
80	1,6
100	1,6
125	1,6
160	1,6

Angled ramping



d_1 [mm]	α_R [°]
12	18,0
16	10,8
20	9,8
25	7,5
32	4,8
40	2,9
50	2,2
63	1,8
80	1,4
100	1,1
125	0,8
160	0,65