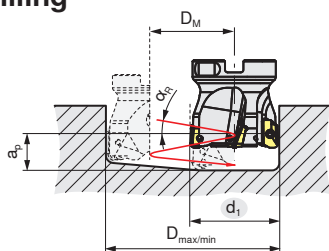


Helical plunge milling

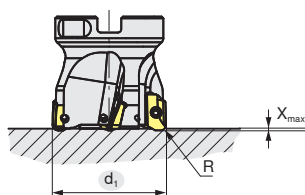


D_{max} [mm] = maximum diameter for flat bottom ground
 D_{min} [mm] = minimum hole diameter
 $D_M = D_{max} - d_1$ or $D_{min} - d_1$

d_1 [mm]	$D_{max} / r_{0,8}$ [mm]	D_{min} [mm]	$\alpha_{R\ max}$ [°]
63	124	107	2,2
80	158	143	1,7
100	198	183	1,3

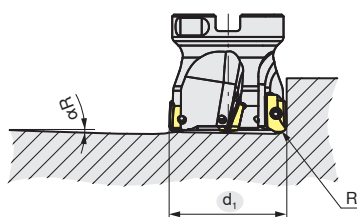
$$a_p \text{ [mm]} = D_M \times \pi \times \tan \alpha_R$$

Axial plunging



d_1 [mm]	X_{max} [mm]
63	2,0
80	2,0
100	2,0

Angled ramping



d_1 [mm]	α_R [°]
63	2,2
80	1,7
100	1,3