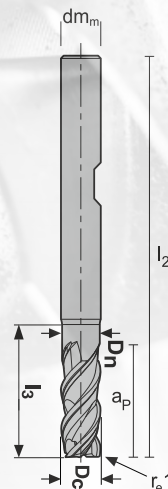


Measurement drawing should be read as follows:

- dm_m = Shank diameter
- D_c = Milling cutting diameter
- m = Minimum clamping length
- l_2 = Total length
- l_3 = Maximum milling cutter depth
- a_p = Effective cutting length
- r_{e1} = Corner radius
- r_{e2} = Radius behind the cutting edge
- e = OD reduction per side
- D_n = Neck reduction

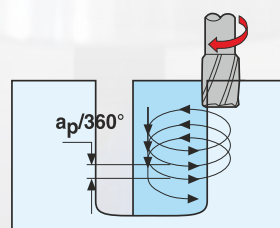


Ramping

The table below shows the feed rate percentage to use at certain ramping angles

Recommended diameter of hole for helical interpolation ramping

Diameter of end mill D_c	Diameter of hole
1-2,5	$1,4 \times D_c$
3-6	$1,3 \times D_c$
8-12	$1,2 \times D_c$
16-32	$1,15 \times D_c$



Trochoidal method

The figure below shows a method often called the trochoidal method for milling slots

Recommendation of width of slot

Diameter of end mill D_c	Slot width
1-2,5	$1,8 \times D_c$
3-6	$1,6 \times D_c$
8-12	$1,4 \times D_c$
16-32	$1,2 \times D_c$

