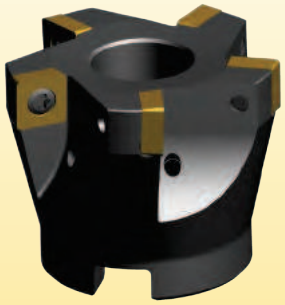
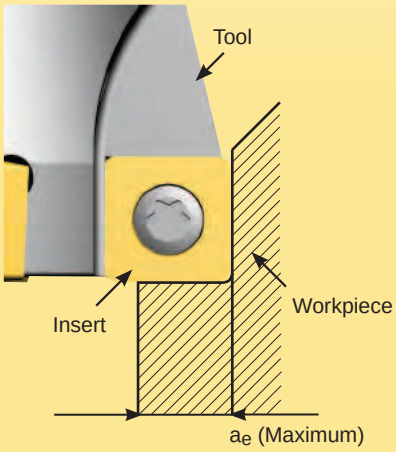
STELLRAM

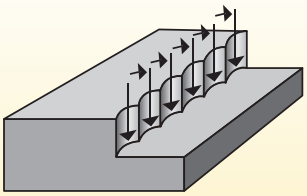
Tool Definition

Scallop height and step over - Dimensions (mm)				
Diameter	25	32	40	50
Insert size	9	9	9	9
a_e max	8,00	8,00	8,00	8,00
Scallop height	Step over (mm)			
0,25	4,97	5,63	6,30	7,05
0,50	7,00	7,94	8,89	9,95
0,75	8,53	9,68	10,85	12,16
1,00	9,80	11,14	12,49	14,00
2,00	13,56	15,49	17,44	19,60
3,00	16,25	18,65	21,07	23,75
4,00	18,33	21,17	24,00	27,13
5,00	20,00	23,24	26,46	30,00
6,00	21,35	24,98	28,57	32,50
7,00	-	-	30,40	34,70
8,00	-	-	32,00	36,66

The scallop height is calculated in relation with the step over.

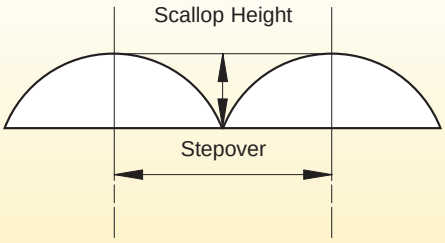






The maximum radial engagement is directly in relation with insert cutting edge length.

For insert type: **SC...09 the a_e, max is 8mm.**



The cutting edge should not be in contact with the material face after machining to maintain the cutting edge quality.