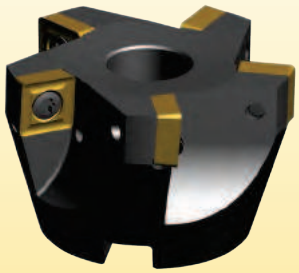
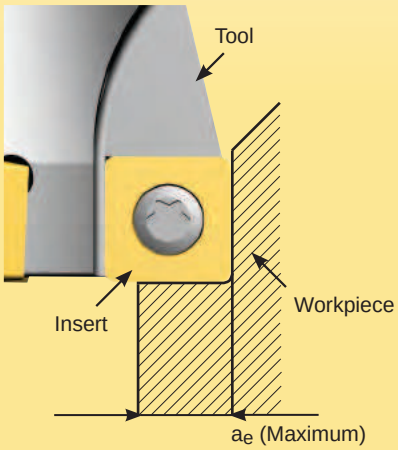
STELLRAM

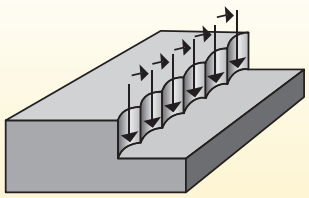
Tool Definition

Scallop height and step over - Dimensions (mm)		
Diameter	63	80
Insert size	12	12
a_e max	11,00	11,00
Scallop height	Step over (mm)	
0,25	7,92	8,93
0,50	11,18	12,61
0,75	13,67	15,42
1,00	15,75	17,78
2,00	22,09	24,98
3,00	26,83	30,40
4,00	30,72	34,87
5,00	34,06	38,73
6,00	36,99	42,14
7,00	39,60	45,21
8,00	41,95	48,00
9,00	44,09	50,56
10,00	46,04	52,92
11,00	47,83	55,10

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

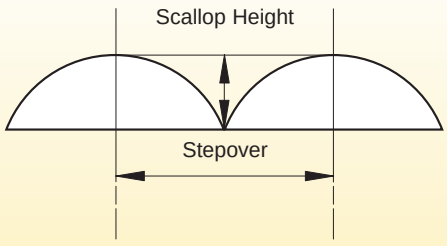






The maximum radial engagement is directly in relation with insert cutting edge length.

For insert type: **SC...12 the a_e, max is 11mm.**



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