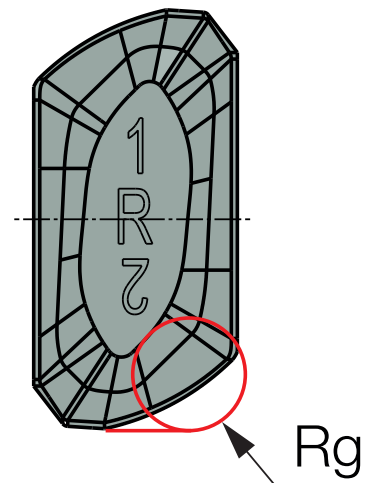


Cutting side Bottom (clamping) side



Ramp Down Application as Function of Cutter Diameter

Tool Diameter		a° - Ramp down angle
mm	inch	
25	1.00"	4.8°
32	1.25"	3.3°
40	1.50"	2.5°
50	2.00"	1.8°
63	2.50"	1.3°
80	3.00"	1.0°
100	4.00"	0.8°



HELITANG

T490 LINE

The cutters can carry inserts T490 LN... PN... with straight cutting edge, T490 LNMT... CS... featuring a cutting edge with chip splitting grooves, and T490 LNMT...FW... with serrated cutting edge.

For mounting instructions refer to the "Related Insert" option, choose a relevant insert in it, and then apply the "More Info" mode.

The recommended maximum width of cut (a_e max) for extended flute cutters carrying T490 LN... inserts is shown in the table below:

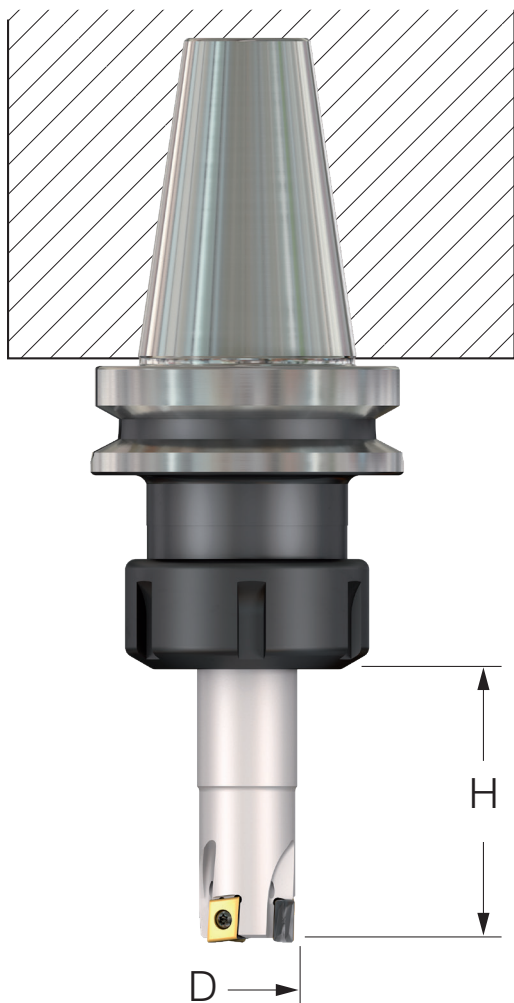
Overhang H	a_e max for insert types		
	PN...	CS	FW
Up to 1×D	0.2×D	0.3×D	0.4×D
Over 1×D to 2×D	0.1×D	0.2×D	0.3×D
Over 2×D to 3×D	-	0.1×D	0.2×D
Over 3×D	-	-	0.1×D

D – The diameter of a cutter

The overhang (H) depends on a cutter configuration.

The following figures illustrates how to estimate the overhang:

For cutters with shanks



For shell mills and integral cutters

