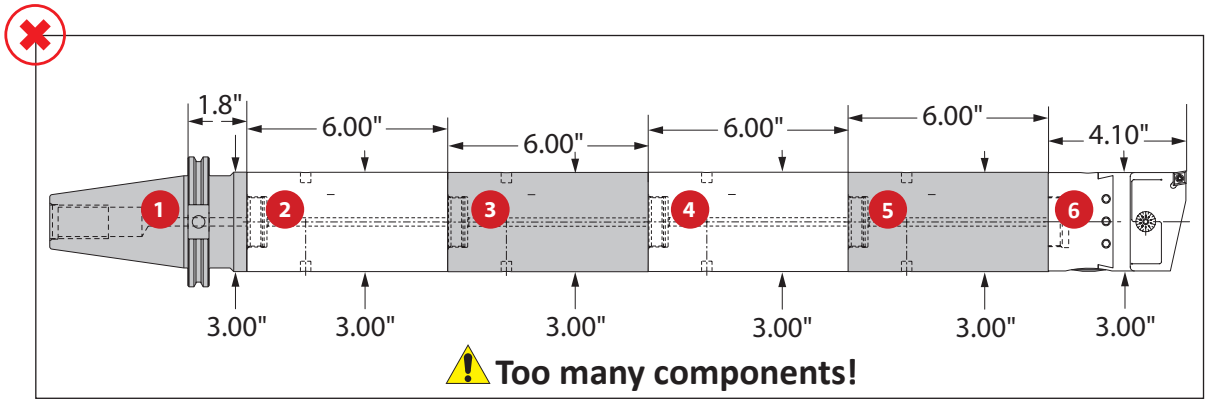
ALLIED MACHINE & ENGINEERING | CRITERION®

Guidelines for not Exceeding Recommended Length to Diameter Ratio

To calculate, see graphics below:



*Length to diameter ratio is calculated using body diameters, not cutting diameter.

Step 1: Find L : D by component

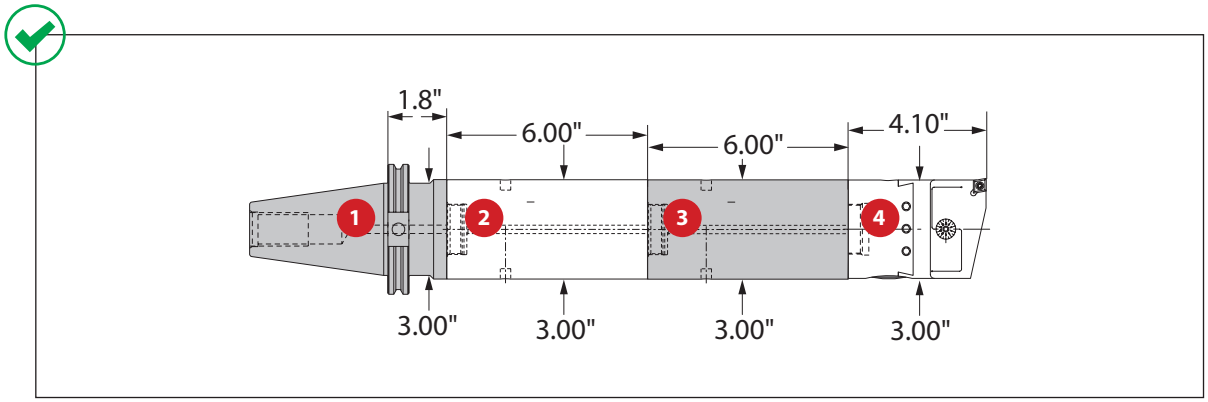
1. 0.6 = 1.88/3.00
2. 2.0 = 6.00/3.00
3. 2.0 = 6.00/3.00
4. 2.0 = 6.00/3.00
5. 2.0 = 6.00/3.00
6. 1.4 = 4.10/3.00

Step 2: Add each L : D Average

0.6
2.0
2.0
2.0
2.0
+ 1.4

10.0 = L : D ratio

Too Long!



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Step 1: Find L : D by component

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Step 2: Add each L : D Average

0.6
2.0
2.0
+ 1.4

6.0 = L : D ratio

WARNING **Tool failure can cause serious injury. To prevent:**

- Do not exceed recommended 9xD length to diameter ratio or exceed 4 total components (including shank)

Factory technical assistance is available for your specific applications through our Application Engineering department. *ext:* **7611** | *email:* **appeng@alliedmachine.com**