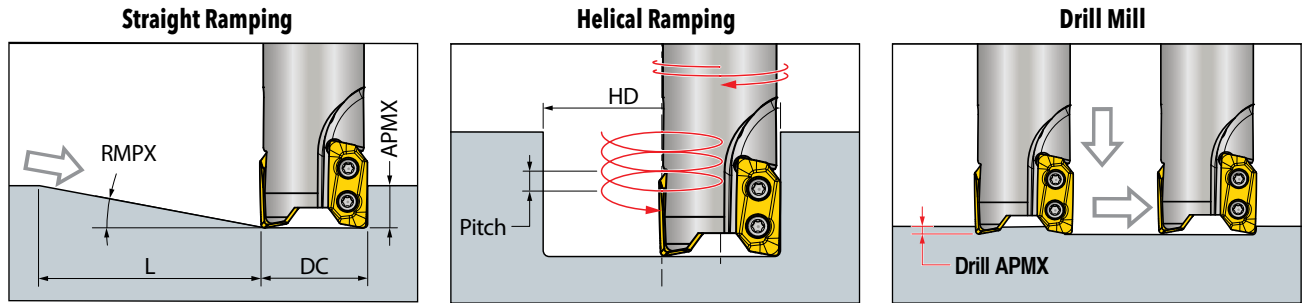


OPERATING GUIDELINES - 14MM RAMPING DATA



DC Cutter Diameter	Straight Ramp			Helical Ramp			Drill Mill
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.	Drill APMX Depth of Cut Max.
0.750	38.8	0.61	0.8	0.75	1.50	0.61	0.16
1.000	21.8	0.61	1.5	1.24	2.00	0.61	0.16
1.250	13.9	0.61	2.5	1.74	2.50	0.61	0.16
1.500	10.7	0.61	3.2	2.24	3.00	0.61	0.16
2.000	6.9	0.61	5.0	3.24	4.00	0.61	0.16
2.500	4.9	0.61	7.1	4.24	5.00	0.61	0.16
3.000	3.9	0.61	8.9	5.24	6.00	0.61	0.16
4.000	3.4	0.61	10.3	7.24	8.00	0.61	0.16
5.000	2.1	0.61	16.6	9.24	10.00	0.61	0.16
6.000	1.7	0.61	20.6	11.24	12.00	0.61	0.16

Ramp angles values were calculated using the -08, 0.031" corner radius insert and will work for general use.