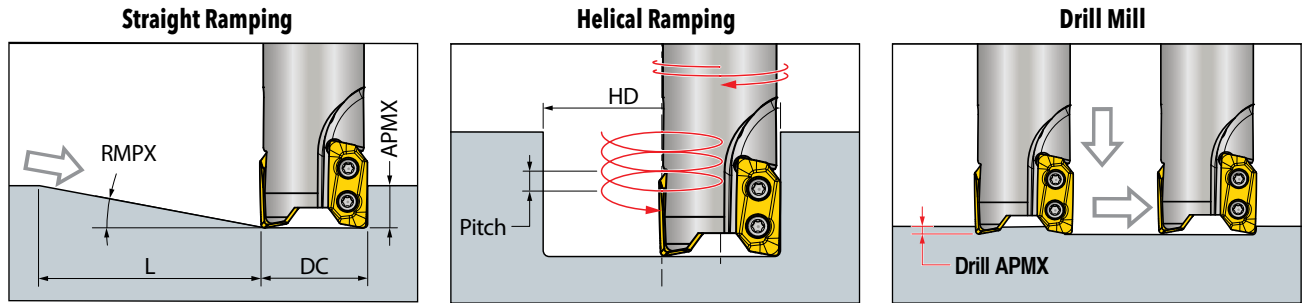


OPERATING GUIDELINES - 25MM RAMPING DATA



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.
1.000	26.3	0.82	1.7	1.24	2.00	0.82	0.18
1.250	25.2	0.82	1.7	1.74	2.50	0.82	0.18
1.500	13.5	0.82	3.4	2.24	3.00	0.82	0.18
2.000	10.5	0.82	4.4	3.24	4.00	0.82	0.18
2.500	7.5	0.82	6.2	4.24	5.00	0.82	0.18
3.000	5.9	0.82	7.9	5.24	6.00	0.82	0.18
4.000	4.1	0.82	11.4	7.24	8.00	0.82	0.18
5.000	3.1	0.82	15.1	9.24	10.00	0.82	0.18
6.000	2.5	0.82	18.8	11.24	12.00	0.82	0.18

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