



## RAMP DATA USING SERIES ENHU (90°)

DC Cutting Dia.	Straight Ramp			Helical Ramp			PD Plunge Depth
	RMPX Ramp Angle	L	APMX	Min. Dia. Milled Hole	Max. Dia. Milled Hole	APMX / Rev	
0.50	6.9	1.5	0.18	0.61	-	0.041	0.027
				-	1.00	0.180	
0.62	4.4	2.3	0.18	0.86	-	0.057	0.027
				-	1.25	0.150	
0.75	3.3	3.1	0.18	1.11	-	0.065	0.027
				-	1.50	0.135	
1.00	2.2	4.7	0.18	1.60	-	0.072	0.027
				-	2.00	0.120	
1.50	1.3	7.9	0.18	2.60	-	0.078	0.027
				-	3.00	0.180	
2.00	0.9	11.5	0.18	3.60	-	0.078	0.027
				-	4.00	0.098	

## RAMP DATA USING SERIES UNHU (HI-FEED)

DC Cutting Dia.	Straight Ramp			Helical Ramp			PD Plunge Depth
	RMPX Ramp Angle	L	APMX	Min. Dia. Milled Hole	Max. Dia. Milled Hole	APMX / Rev	
0.50	5.0	0.2	0.019	0.77	-	0.019	0.015
				-	1.00	0.019	
0.62	2.7	0.4	0.019	1.02	-	0.019	0.015
				-	1.25	0.019	
0.75	1.7	0.6	0.019	1.27	-	0.019	0.015
				-	1.50	0.019	
1.00	1.2	0.9	0.019	1.77	-	0.019	0.015
				-	2.00	0.019	
1.50	0.6	1.8	0.019	2.77	-	0.019	0.015
				-	3.00	0.019	
2.00	0.2	5.4	0.019	3.77	-	0.019	0.015
				-	4.00	0.019	