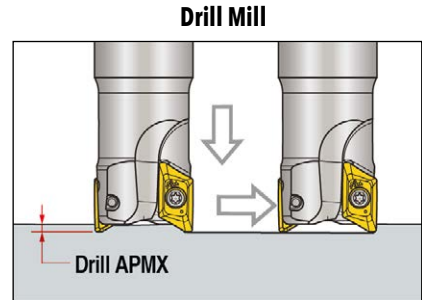
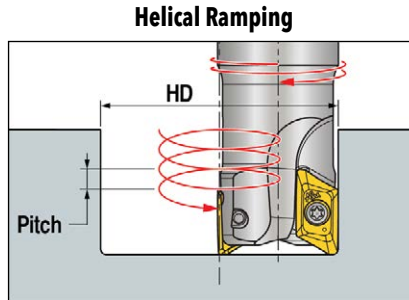
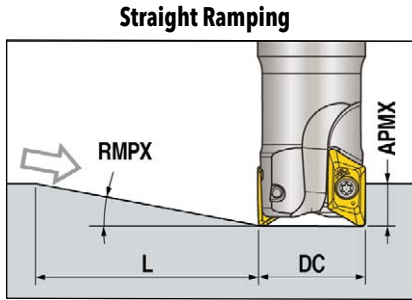


22MM RAMPING DATA



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.
1.250	21.5	0.83	2.1	1.736	2.50	0.83	0.225
1.500	18.6	0.83	2.5	2.236	3.00	0.83	0.300
2.000	9.1	0.83	5.2	3.236	4.00	0.83	0.225
2.500	6.7	0.83	7.1	4.236	5.00	0.83	0.225
3.000	5.4	0.83	8.8	5.236	6.00	0.83	0.225
4.000	3.8	0.83	12.5	7.236	8.00	0.83	0.225
6.000	2.4	0.83	19.8	11.236	12.00	0.83	0.225

Ramp angles are calculated using XEVT220608FR-P insert