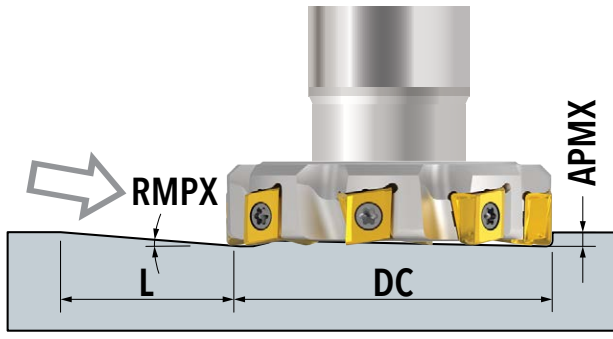


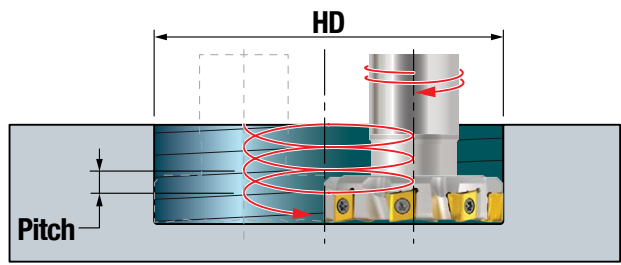
MAXSPEED™ 05 (MULTI-SURFER) STRAIGHT RAMPING



DCX Cutter Diameter	RMPX Ramp Angle Max.	L	APMX Depth of Cut Max.
1.000	0.60	17.30	0.185
1.250	0.40	26.00	0.185
1.500	0.30	34.60	0.185

L in this table is the length the cutter travels to reach the max. depth of cut (.185") while traveling at the max ramp angle listed for the cutter.

MAXSPEED™ 05 (MULTI-SURFER) HELICAL RAMPING



Pitch:
The max. pitch is determined to not exceed the max. depth of cut (APMX) and to not exceed the max. ramp angle (RMPX).

All ramping data is calculated with CGM101R001-ML inserts installed.

DCX Cutter Diameter	HD Min.	HD Max.	HD Max. w/o Cusp	Max Pitch Per Revolution
1.000	1.90	-	0.970	0.0010
-	-	2.00	-	0.0011
1.250	2.40	-	1.470	0.0214
-	-	2.50	-	0.0233
1.500	2.90	-	1.970	0.0196
-	-	3.00	-	0.0210

Example:

1. The min. hole dia. that the 1.000" dia. cutter can interpolate from solid is 1.90" (leaving a raised cusp).
2. The max. hole dia. that the 1.000" dia. cutter can interpolate from solid is 2.00".
3. The max. hole dia. that the 1.000" dia. cutter can interpolate from solid while leaving a flat-bottom is .970" (leaving no raised cusp).