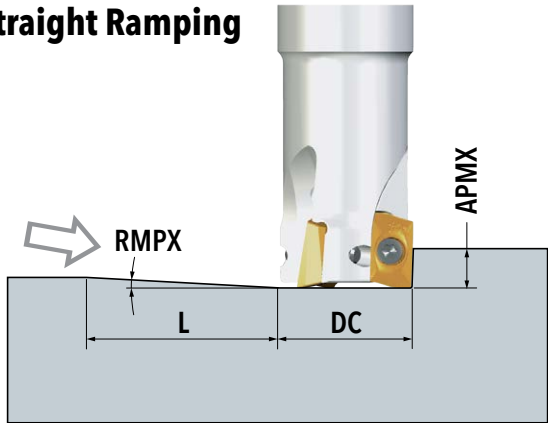
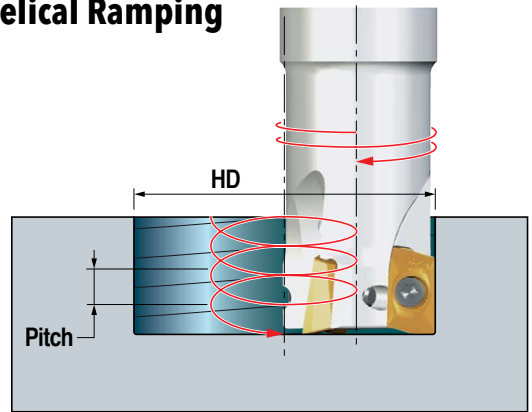


**HIPOST™ 09 RAMPING DATA: SERIES 12J1P, 2J1P & 22J3P**

**Straight Ramping**



**Helical Ramping**



DC Cutter Diameter	Straight Ramp			Helical Ramp		
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Max.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.
0.500	10.0	0.35	1.9	0.62		0.080
					0.96	0.230
0.625	10.0	0.35	1.9	0.78		0.080
					1.21	0.330
0.750	7.0	0.35	2.8	1.02		0.110
					1.46	0.280
0.875	5.5	0.35	3.6	1.27		0.110
					1.71	0.240
1.000	4.4	0.35	4.5	1.52		0.110
					1.96	0.220
1.250	2.8	0.35	7.1	2.02		0.110
					2.46	0.180
1.500	2.4	0.35	8.3	2.52		0.140
					2.96	0.200
2.000	1.3	0.35	15.4	3.52		0.100
					3.96	0.130
2.500	1.0	0.35	20.0	4.52		0.100
					4.96	0.120
3.000	0.7	0.35	28.6	5.52		0.100
					5.96	0.100