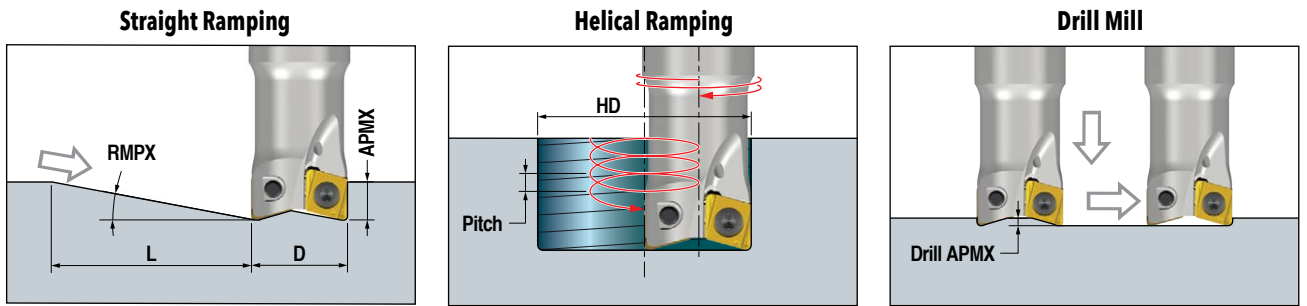




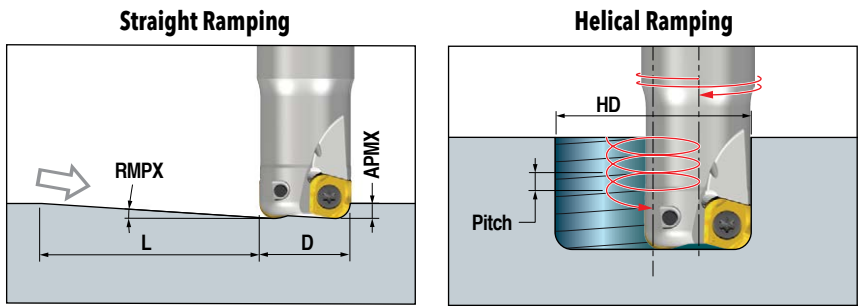
DIPOSDUO™ 11 RAMPING DATA USING MN_U11



USING MN_U11 (R.031")

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	4.0	0.41	5.8	1.27	2.00	0.047 0.185	0.043
1.250	4.3	0.41	5.4	1.77	2.50	0.106 0.255	0.039
1.500	4.5	0.41	5.2	2.27	3.00	0.177 0.330	0.035
2.000	3.2	0.41	7.3	3.27	4.00	0.185 0.295	0.035
2.500	2.4	0.41	9.7	4.27	5.00	0.196 0.275	0.035
3.000	1.8	0.41	13.0	5.27	6.00	0.204 0.263	0.035
4.000	1.0	0.41	23.4	7.27	8.00	0.213 0.249	0.035

DIPOSDUO™ 11 RAMPING DATA USING UNHU11



USING UNHU11 (HI-FEED)

DC Cutter Diameter	Straight Ramp			Helical Ramp		
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.
1.000	0.8	0.078	5.5	1.25	2.00	0.008
						0.035
1.250	2.0	0.078	2.2	1.75	2.50	0.047
						0.078
1.500	3.4	0.078	1.3	2.25	3.00	0.078
						0.078
2.000	2.4	0.078	1.8	3.25	4.00	0.078
						0.078
2.500	1.8	0.078	2.4	4.25	5.00	0.078
						0.078
3.000	1.3	0.078	3.4	5.25	6.00	0.078
						0.078
4.000	0.6	0.078	7.4	7.25	8.00	0.078
						0.078