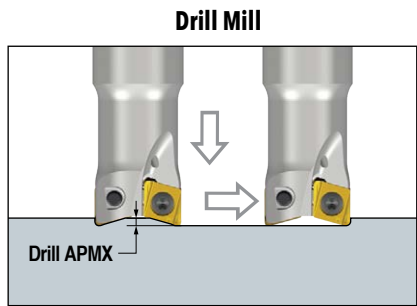
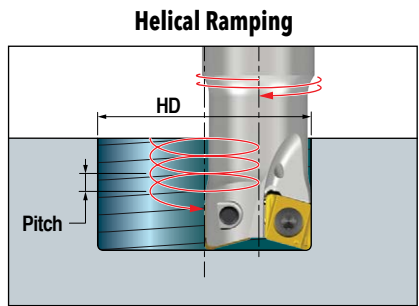
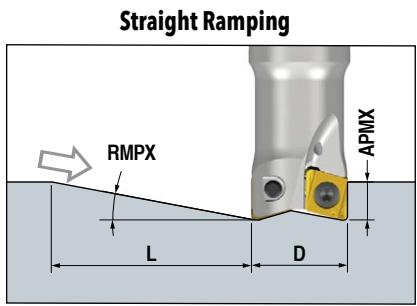




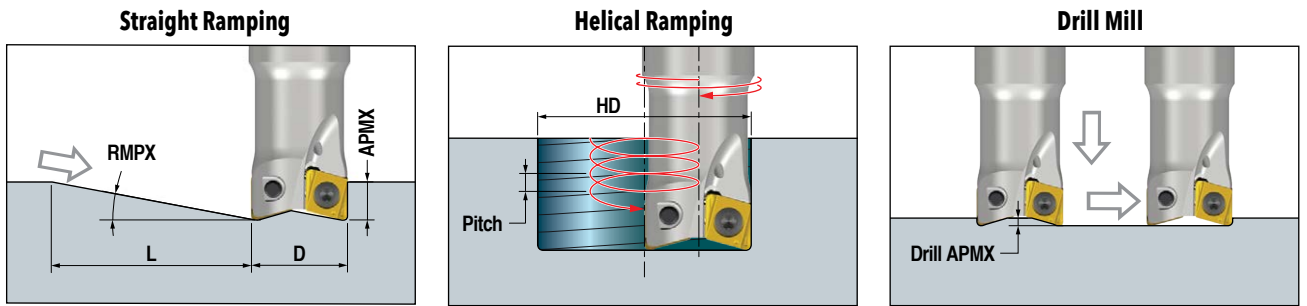
DIPOSDUO™ 06 RAMPING DATA USING MN_U06



USING MN_U06 (R.015")

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.
.625	2.9	0.24	4.7	0.84	1.25	0.027	0.015
						0.086	
.750	3.8	0.24	3.6	1.09	1.50	0.066	0.015
						0.137	
.875	4.0	0.24	3.4	1.34	1.75	0.078	0.015
						0.153	
1.000	3.8	0.24	3.6	1.59	2.00	0.106	0.015
						0.181	
1.250	2.8	0.24	4.9	2.09	2.50	0.110	0.015
						0.165	
1.500	2.3	0.24	5.9	2.59	3.00	0.114	0.015
						0.161	
2.000	1.6	0.24	8.5	3.59	4.00	0.118	0.015
						0.149	
2.500	1.2	0.24	11.4	4.59	5.00	0.122	0.015
						0.145	
3.000	0.8	0.24	17.0	5.59	6.00	0.128	0.015
						0.141	

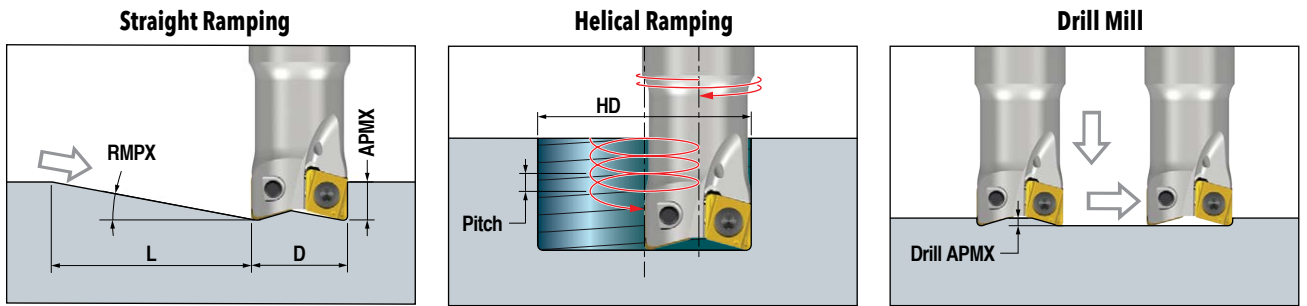
DIPOSDUO™ 06 RAMPING DATA USING MN_U06



USING MN_U06 (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.
.625	2.9	0.24	4.7	0.84	1.25	0.027	0.015
						0.086	
.750	3.8	0.24	3.6	1.09	1.50	0.066	0.015
						0.137	
.875	4.0	0.24	3.4	1.34	1.75	0.078	0.015
						0.153	
1.000	4.1	0.24	3.6	1.59	2.00	0.106	0.015
						0.181	
1.250	2.8	0.24	4.9	2.09	2.50	0.110	0.015
						0.165	
1.500	2.3	0.24	5.9	2.59	3.00	0.114	0.015
						0.161	
2.000	1.6	0.24	8.5	3.59	4.00	0.118	0.015
						0.149	
2.500	1.2	0.24	11.4	4.59	5.00	0.122	0.015
						0.145	
3.000	0.8	0.24	17.0	5.59	6.00	0.128	0.015
						0.141	

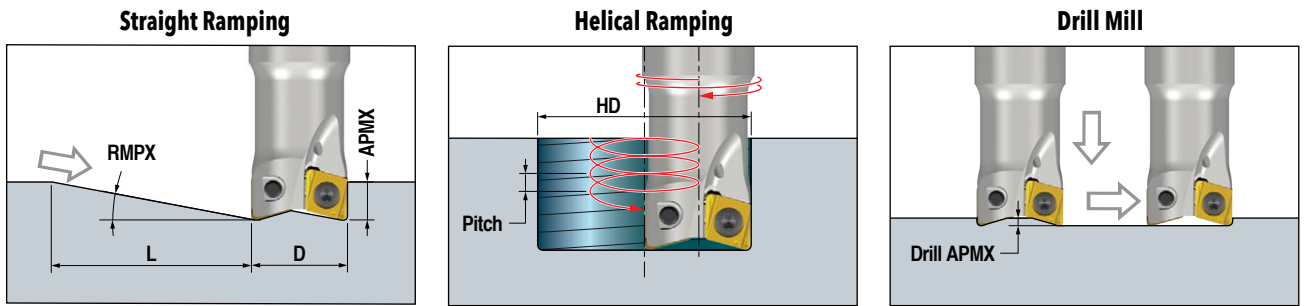
DIPOSDUO™ 06 RAMPING DATA USING MN_U06



USING MN_U06 (R.039")

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.
.625	2.7	0.24	5.0	0.84	1.25	0.027	0.017
						0.082	
.750	3.6	0.24	3.8	1.09	1.50	0.062	0.017
						0.133	
.875	3.8	0.24	3.6	1.34	1.75	0.074	0.017
						0.145	
1.000	4.4	0.24	3.1	1.59	2.00	0.118	0.017
						0.200	
1.250	3.1	0.24	4.4	2.09	2.50	0.122	0.017
						0.181	
1.500	2.5	0.24	5.4	2.59	3.00	0.125	0.017
						0.173	
2.000	1.8	0.24	7.6	3.59	4.00	0.129	0.017
						0.165	
2.500	1.4	0.24	9.8	4.59	5.00	0.133	0.017
						0.161	
3.000	0.9	0.24	15.2	5.59	6.00	0.139	0.017
						0.157	

DIPOSDUO™ 06 RAMPING DATA USING MN_U06

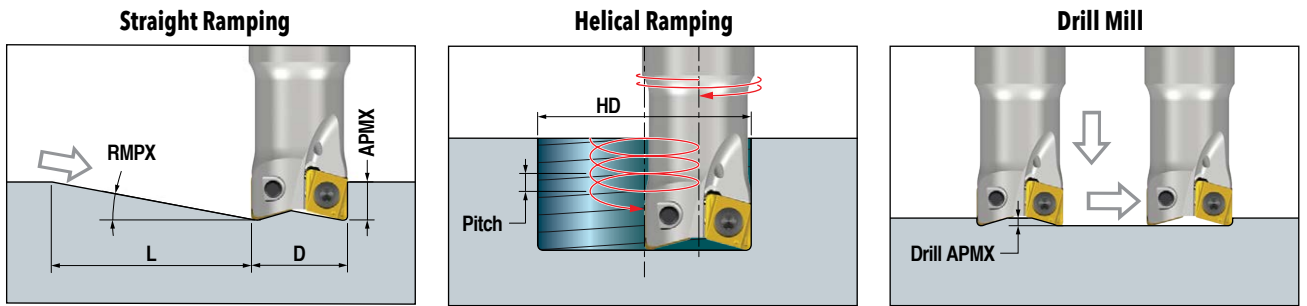


USING MN_U06 (R.047")

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.
.625	3.0	0.24	4.5	0.84	1.25	0.031 0.086	0.015
.750	3.9	0.24	3.5	1.09	1.50	0.066 0.141	0.015
.875	4.1	0.24	3.3	1.34	1.75	0.078 0.157	0.015
1.000	4.2	0.24	3.2	1.59	2.00	0.110 0.192	0.015
1.250	2.9	0.24	4.7	2.09	2.50	0.114 0.169	0.015
1.500	2.3	0.24	5.9	2.59	3.00	0.118 0.165	0.015
2.000	1.7	0.24	8.0	3.59	4.00	0.122 0.157	0.015
2.500	1.3	0.24	10.5	4.59	5.00	0.125 0.149	0.015
3.000	0.9	0.24	15.2	5.59	6.00	0.129 0.143	0.015



DIPOSDUO™ 06 RAMPING DATA USING MN_U06

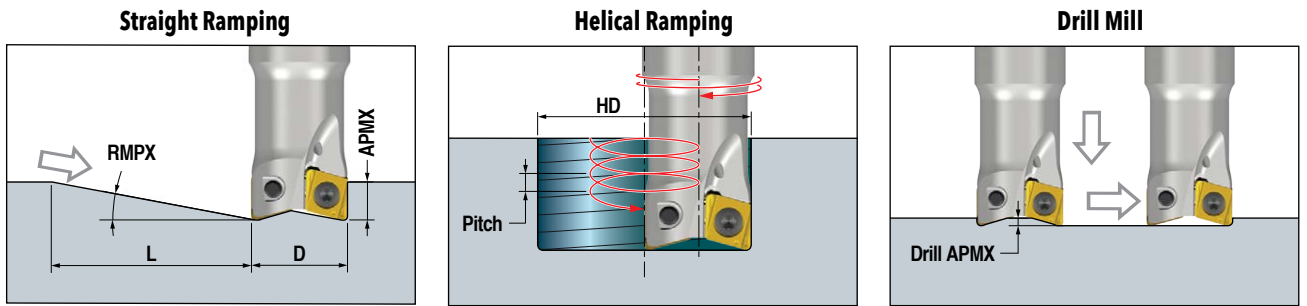


USING MN_U06 (R.062")

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.
.625	2.2	0.24	6.2	0.84	1.25	0.023 0.062	0.008
.750	3.2	0.24	4.2	1.09	1.50	0.055 0.118	0.008
.875	3.4	0.24	4.0	1.34	1.75	0.066 0.130	0.008
1.000	3.4	0.24	4.0	1.59	2.00	0.098 0.161	0.008
1.250	2.5	0.24	5.4	2.09	2.50	0.102 0.149	0.008
1.500	2.0	0.24	6.8	2.59	3.00	0.102 0.141	0.008
2.000	1.5	0.24	9.1	3.59	4.00	0.110 0.137	0.008
2.500	1.1	0.24	12.4	4.59	5.00	0.110 0.133	0.008
3.000	0.5	0.24	28.6	5.59	6.00	0.112 0.129	0.008



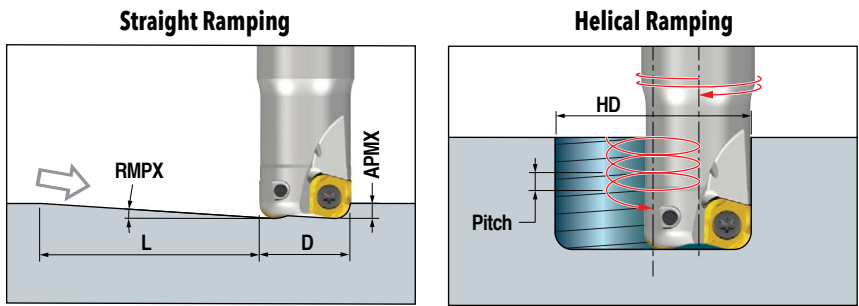
DIPOSDUO™ 06 RAMPING DATA USING MN_U06



USING MN_U06 (R.079")

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.
.625	0.8	0.24	17.1	0.84	1.25	0.007	0.003
						0.023	
.750	2.1	0.24	6.5	1.09	1.50	0.035	0.003
						0.078	
.875	2.3	0.24	5.9	1.34	1.75	0.043	0.003
						0.090	
1.000	3.2	0.24	4.2	1.59	2.00	0.086	0.003
						0.145	
1.250	2.2	0.24	6.2	2.09	2.50	0.090	0.003
						0.133	
1.500	1.8	0.24	7.6	2.59	3.00	0.090	0.003
						0.125	
2.000	1.3	0.24	10.5	3.59	4.00	0.094	0.003
						0.118	
2.500	1.0	0.24	13.7	4.59	5.00	0.094	0.003
						0.114	
3.000	0.4	0.24	34.3	5.59	6.00	0.096	0.003
						0.110	

DIPOSDUO™ 06 RAMPING DATA USING UNHU06



USING UNHU06 (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.
0.625	0.6	0.039	3.7	0.83		0.008
					1.25	0.019
0.750	1.7	0.039	1.3	1.08		0.027
					1.50	0.039
0.875	2.1	0.039	1.1	1.33		0.039
					1.75	0.039
1.000	2.3	0.039	1.0	1.58		0.039
					2.00	0.039
1.250	2.4	0.039	0.9	2.08		0.039
					2.50	0.039
1.500	1.8	0.039	1.2	2.58		0.039
					3.00	0.039
2.000	1.4	0.039	1.6	3.58		0.039
					4.00	0.039
2.500	1.1	0.039	2.0	4.58		0.039
					5.00	0.039
3.000	0.8	0.039	2.8	5.58		0.039
					6.00	0.039