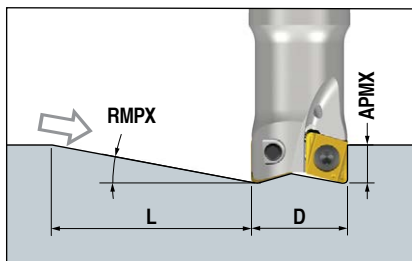
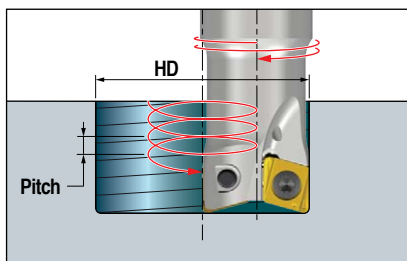


## DIPOSDUO™ 04 RAMPING DATA USING MN\_U04

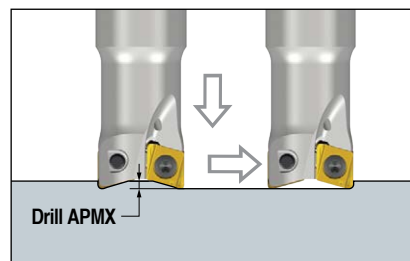
**Straight Ramping**



**Helical Ramping**



**Drill Mill**



### USING MN\_U04 (R.008")

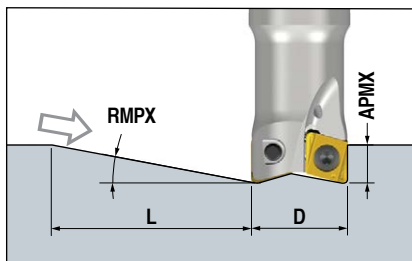
| DC<br>Cutter<br>Diameter | Straight Ramp           |                           |                       | Helical Ramp         |                      |                | Drill Mill                      |
|--------------------------|-------------------------|---------------------------|-----------------------|----------------------|----------------------|----------------|---------------------------------|
|                          | RMPX<br>Ramp Angle Max. | APMX<br>Depth of Cut Max. | L<br>Ramp Length Min. | HD<br>Hole Dia. Min. | HD<br>Hole Dia. Max. | Pitch<br>Max.  | Drill APMX<br>Depth of Cut Max. |
| .500                     | 5.1                     | 0.13                      | 1.4                   | 0.76                 | 1.00                 | 0.062<br>0.122 | 0.027                           |
| .625                     | 4.4                     | 0.13                      | 1.6                   | 1.21                 | 1.25                 | 0.078<br>0.118 | 0.027                           |
| .750                     | 3.3                     | 0.13                      | 2.2                   | 1.26                 | 1.50                 | 0.082<br>0.122 | 0.023                           |
| .875                     | 2.8                     | 0.13                      | 2.6                   | 1.51                 | 1.75                 | 0.084<br>0.119 | 0.023                           |
| 1.000                    | 2.5                     | 0.13                      | 2.9                   | 1.76                 | 2.00                 | 0.086<br>0.114 | 0.023                           |
| 1.250                    | 1.9                     | 0.13                      | 3.9                   | 2.26                 | 2.50                 | 0.090<br>0.110 | 0.023                           |
| 1.500                    | 1.4                     | 0.13                      | 5.3                   | 2.76                 | 3.00                 | 0.090<br>0.106 | 0.023                           |

### USING MN\_U04 (R.015")

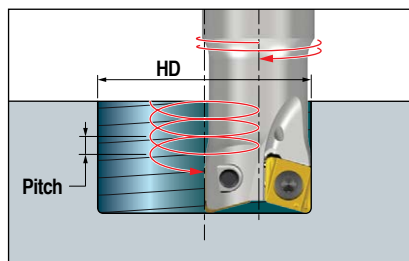
| DC<br>Cutter<br>Diameter | Straight Ramp           |                           |                       | Helical Ramp         |                      |                | Drill Mill                      |
|--------------------------|-------------------------|---------------------------|-----------------------|----------------------|----------------------|----------------|---------------------------------|
|                          | RMPX<br>Ramp Angle Max. | APMX<br>Depth of Cut Max. | L<br>Ramp Length Min. | HD<br>Hole Dia. Min. | HD<br>Hole Dia. Max. | Pitch<br>Max.  | Drill APMX<br>Depth of Cut Max. |
| .500                     | 4.7                     | 0.13                      | 1.5                   | 0.76                 | 1.00                 | 0.059<br>0.114 | 0.023                           |
| .625                     | 4.1                     | 0.13                      | 1.8                   | 1.21                 | 1.25                 | 0.074<br>0.122 | 0.023                           |
| .750                     | 3.1                     | 0.13                      | 2.4                   | 1.26                 | 1.50                 | 0.078<br>0.114 | 0.019                           |
| .875                     | 2.6                     | 0.13                      | 2.8                   | 1.51                 | 1.75                 | 0.080<br>0.110 | 0.019                           |
| 1.000                    | 2.3                     | 0.13                      | 3.2                   | 1.76                 | 2.00                 | 0.082<br>0.106 | 0.019                           |
| 1.250                    | 1.7                     | 0.13                      | 4.3                   | 2.26                 | 2.50                 | 0.082<br>0.102 | 0.019                           |
| 1.500                    | 1.3                     | 0.13                      | 5.7                   | 2.76                 | 3.00                 | 0.082<br>0.098 | 0.019                           |

## DIPOSDUO™ 04 RAMPING DATA USING MN\_U04

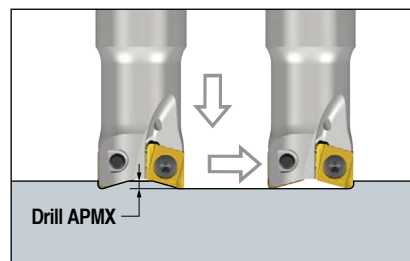
**Straight Ramping**



**Helical Ramping**



**Drill Mill**

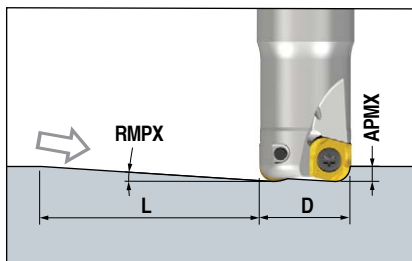


### USING MN\_U04 (R.031")

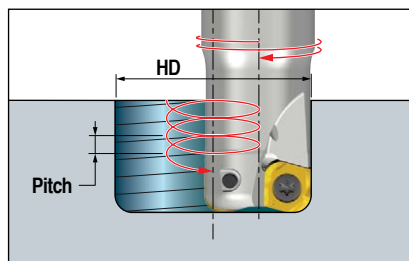
| DC<br>Cutter<br>Diameter | Straight Ramp           |                           |                       | Helical Ramp         |                      |                | Drill Mill                      |
|--------------------------|-------------------------|---------------------------|-----------------------|----------------------|----------------------|----------------|---------------------------------|
|                          | RMPX<br>Ramp Angle Max. | APMX<br>Depth of Cut Max. | L<br>Ramp Length Min. | HD<br>Hole Dia. Min. | HD<br>Hole Dia. Max. | Pitch<br>Max.  | Drill APMX<br>Depth of Cut Max. |
| .500                     | 3.9                     | 0.13                      | 1.9                   | 0.76                 | 1.00                 | 0.051<br>0.094 | 0.015                           |
| .625                     | 3.5                     | 0.13                      | 2.1                   | 1.21                 | 1.25                 | 0.062<br>0.102 | 0.015                           |
| .750                     | 2.6                     | 0.13                      | 2.8                   | 1.26                 | 1.50                 | 0.066<br>0.094 | 0.012                           |
| .875                     | 2.3                     | 0.13                      | 3.2                   | 1.51                 | 1.75                 | 0.066<br>0.092 | 0.012                           |
| 1.000                    | 1.9                     | 0.13                      | 3.9                   | 1.76                 | 2.00                 | 0.066<br>0.090 | 0.012                           |
| 1.250                    | 1.5                     | 0.13                      | 4.9                   | 2.26                 | 2.50                 | 0.070<br>0.085 | 0.012                           |
| 1.500                    | 1.1                     | 0.13                      | 6.7                   | 2.76                 | 3.00                 | 0.070<br>0.082 | 0.012                           |

## DIPOSDUO™ 04 RAMPING DATA USING UNHU04

**Straight Ramping**



**Helical Ramping**



### USING UNHU04 (HI-FEED)

| DC<br>Cutter<br>Diameter | Straight Ramp           |                           |                       | Helical Ramp         |                      |               |
|--------------------------|-------------------------|---------------------------|-----------------------|----------------------|----------------------|---------------|
|                          | RMPX<br>Ramp Angle Max. | APMX<br>Depth of Cut Max. | L<br>Ramp Length Min. | HD<br>Hole Dia. Min. | HD<br>Hole Dia. Max. | Pitch<br>Max. |
| .500                     | 2.0                     | 0.019                     | 0.5                   | 0.76                 | 1.00                 | 0.019         |
| .625                     | 1.9                     | 0.019                     | 0.6                   | 1.21                 | 1.25                 | 0.019         |
| .750                     | 2.2                     | 0.019                     | 0.5                   | 1.26                 | 1.50                 | 0.019         |
| .875                     | 2.0                     | 0.019                     | 0.4                   | 1.51                 | 1.75                 | 0.019         |
| 1.000                    | 1.7                     | 0.019                     | 0.6                   | 1.76                 | 2.00                 | 0.019         |
| 1.250                    | 1.3                     | 0.019                     | 0.9                   | 2.26                 | 2.50                 | 0.019         |
| 1.500                    | 1.0                     | 0.019                     | 1.1                   | 2.76                 | 3.00                 | 0.019         |