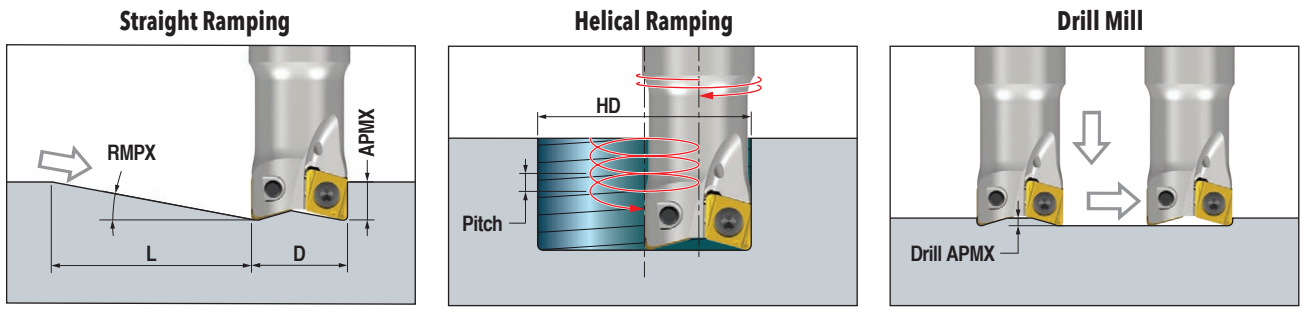




DIPOSDUO™ 04 RAMPING DATA USING MN_U04



USING MN_U04 (R.008")

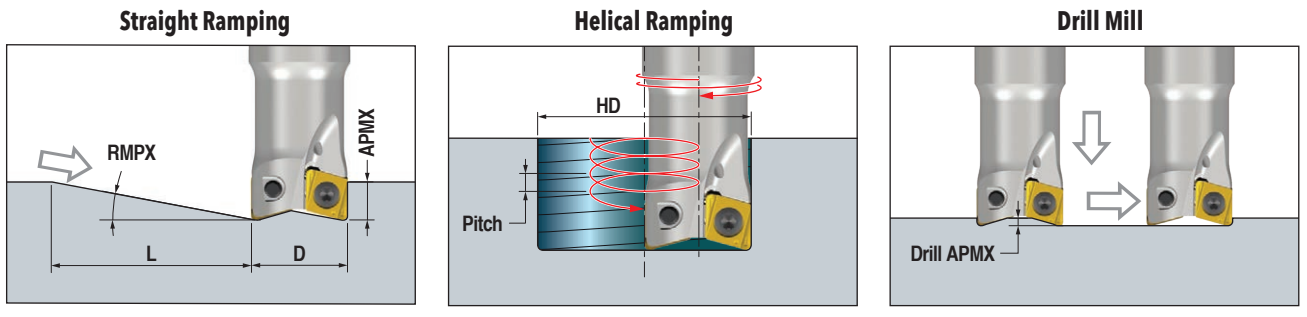
DC Cutter Diameter	Straight Ramp			Helical Ramp			Drill Mill
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.	Drill APMX Depth of Cut Max.
.500	5.1	0.13	1.4	0.76	1.00	0.062	0.027
.625	4.4	0.13	1.6	1.21	1.25	0.078	0.027
.750	3.3	0.13	2.2	1.26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

USING MN_U04 (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.
.500	4.7	0.13	1.5	0.76	1.00	0.059	0.023
.625	4.1	0.13	1.8	1.21	1.25	0.074	0.023
.750	3.1	0.13	2.4	1.26	1.50	0.078	0.019
.875	2.6	0.13	2.8	1.51	1.75	0.080	0.019
1.000	2.3	0.13	3.2	1.76	2.00	0.082	0.019
1.250	1.7	0.13	4.3	2.26	2.50	0.082	0.019
1.500	1.3	0.13	5.7	2.76	3.00	0.082	0.019



DIPOSDUO™ 04 RAMPING DATA USING MN_U04

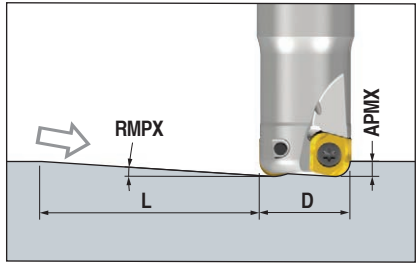


USING MN_U04 (R.031")

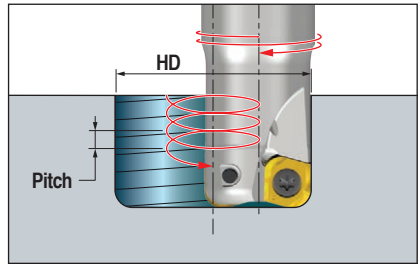
DC Cutter Diameter	Straight Ramp			Helical Ramp			Drill Mill
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.	Drill APMX Depth of Cut Max.
.500	3.9	0.13	1.9	0.76	1.00	0.051	0.015
						0.094	
.625	3.5	0.13	2.1	1.21	1.25	0.062	0.015
						0.102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

DIPOSDUO™ 04 RAMPING DATA USING UNHU04

Straight Ramping



Helical Ramping



USING UNHU04 (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.
.500	2.0	0.019	0.5	0.76	1.00	0.019
						0.019
.625	1.9	0.019	0.6	1.21	1.25	0.019
						0.019
.750	2.2	0.019	0.5	1.26	1.50	0.019
						0.019
.875	2.0	0.019	0.4	1.51	1.75	0.019
						0.019
1.000	1.7	0.019	0.6	1.76	2.00	0.019
						0.019
1.250	1.3	0.019	0.9	2.26	2.50	0.019
						0.019
1.500	1.0	0.019	1.1	2.76	3.00	0.019
						0.019