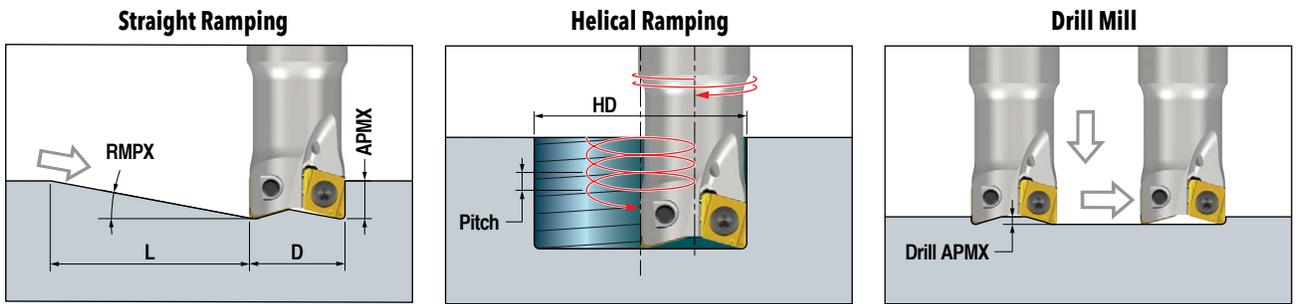




**DIPOSDUO™ 09 RAMPING DATA USING MN\_U09**



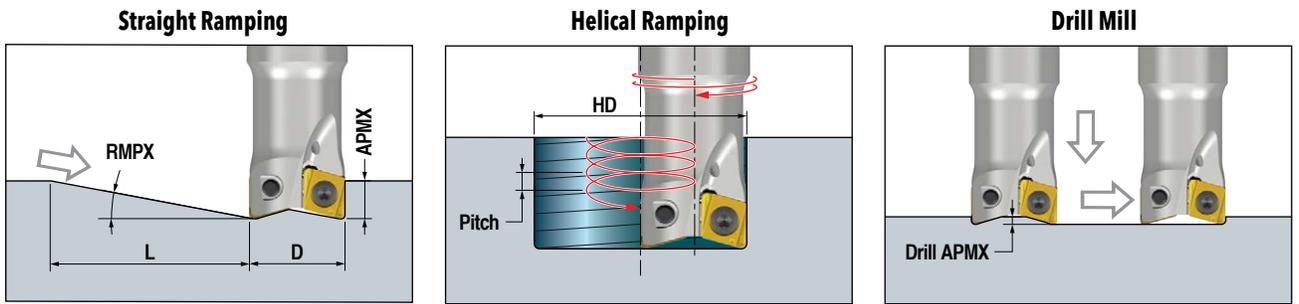
**USING MN\_U09 (R.015")**

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.
1.000	4.3	0.32	4.2	1.43	2.00	0.082 0.200	0.035
1.250	4.5	0.32	4.0	1.93	2.50	0.145 0.263	0.035
1.500	3.2	0.32	5.7	2.43	3.00	0.150 0.236	0.035
2.000	2.4	0.32	7.6	3.43	4.00	0.157 0.220	0.035
2.500	1.8	0.32	10.0	4.43	5.00	0.161 0.210	0.035
3.000	1.3	0.32	14.0	5.43	6.00	0.161 0.200	0.035
4.000	0.8	0.32	22.0	7.43	8.00	0.154 0.183	0.035

**USING MN\_U09 (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	4.3	0.32	4.2	1.43	2.00	0.082 0.200	0.023
1.250	4.5	0.32	4.0	1.93	2.50	0.145 0.263	0.023
1.500	3.2	0.32	5.7	2.43	3.00	0.150 0.236	0.023
2.000	2.4	0.32	7.6	3.43	4.00	0.157 0.220	0.023
2.500	1.8	0.32	10.0	4.43	5.00	0.161 0.210	0.023
3.000	1.3	0.32	14.0	5.43	6.00	0.161 0.200	0.023
4.000	0.8	0.32	22.0	7.43	8.00	0.154 0.183	0.023

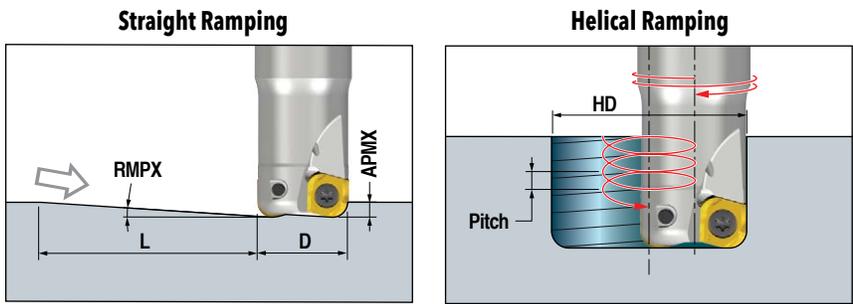
**DIPOSDUO™ 09 RAMPING DATA USING MN\_U09**



**USING MN\_U09 (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.
1.000	4.1	0.32	4.4	1.43	2.00	0.078 0.180	0.023
1.250	4.4	0.32	4.1	1.93	2.50	0.140 0.260	0.023
1.500	3.1	0.32	5.6	2.43	3.00	0.145 0.228	0.023
2.000	2.3	0.32	7.5	3.43	4.00	0.153 0.216	0.023
2.500	1.8	0.32	10.0	4.43	5.00	0.161 0.208	0.023
3.000	1.3	0.32	13.3	5.43	6.00	0.161 0.196	0.023
4.000	0.8	0.32	22.0	7.43	8.00	0.154 0.183	0.023

**DIPOSDUO™ 09 RAMPING DATA USING UNHU09**



**USING UNHU09 (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	1.2	0.059	2.8	1.41	2.00	0.023 0.059
1.250	2.4	0.059	1.4	1.91	2.50	0.059 0.059
1.500	2.3	0.059	1.4	2.41	3.00	0.059 0.059
2.000	1.7	0.059	1.9	3.41	4.00	0.059 0.059
2.500	1.3	0.059	2.6	4.41	5.00	0.059 0.059
3.000	1.0	0.059	3.3	5.41	6.00	0.059 0.059
4.000	0.5	0.059	6.7	7.41	8.00	0.059 0.059