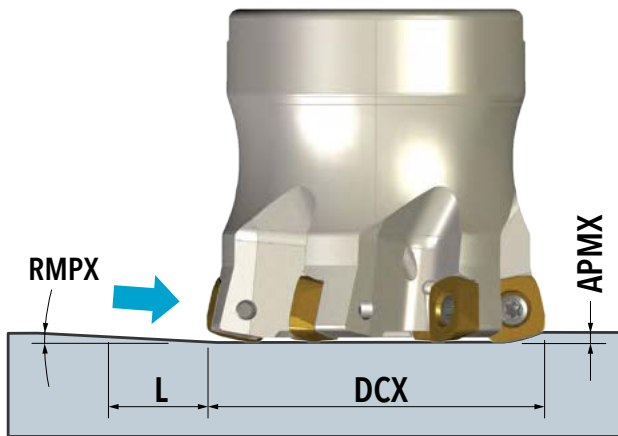


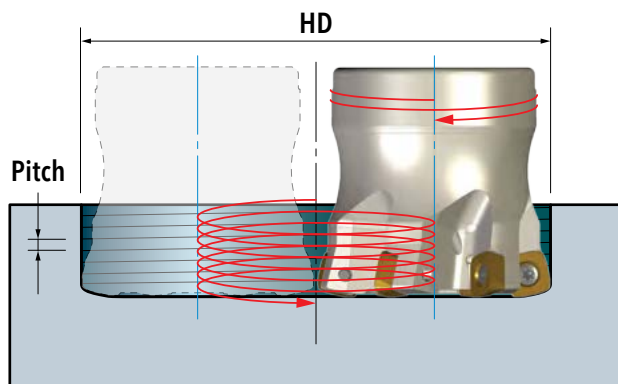
## 6 mm • Straight Ramping **NEW**



| DCX<br>Cutting Dia.<br>Max. | RMPX<br>Ramp Angle<br>Max. | L*    | APMX<br>Depth of Cut<br>Max. |
|-----------------------------|----------------------------|-------|------------------------------|
| 0.625                       | 2.500                      | 0.916 | 0.040                        |
| 0.750                       | 3.500                      | 0.653 | 0.040                        |
| 0.875                       | 3.000                      | 0.763 | 0.040                        |
| 1.000                       | 2.500                      | 0.916 | 0.040                        |
| 1.250                       | 2.000                      | 1.145 | 0.040                        |
| 1.500                       | 1.600                      | 1.432 | 0.040                        |
| 2.000                       | 1.000                      | 2.291 | 0.040                        |

\* L in this table is the length the cutter travels to reach the maximum depth of cut (.040") while traveling at the maximum ramp angle listed for the cutter.

## 6 mm • Helical Ramping **NEW**



| DCX<br>Cutting Dia.<br>Max. | HD<br>Hole Dia.<br>Min. | HD<br>Hole Dia.<br>Max. | HD<br>Hole Dia.<br>Max. w/o<br>Cusp | Max.<br>Pitch Per<br>Revolution |
|-----------------------------|-------------------------|-------------------------|-------------------------------------|---------------------------------|
| 0.625                       | 0.812                   | 1.250                   | 0.939                               | 0.040                           |
| 0.750                       | 1.044                   | 1.500                   | 1.188                               | 0.040                           |
| 0.875                       | 1.288                   | 1.750                   | 1.437                               | 0.040                           |
| 1.000                       | 1.538                   | 2.000                   | 1.686                               | 0.040                           |
| 1.250                       | 2.032                   | 2.500                   | 2.186                               | 0.040                           |
| 1.500                       | 2.534                   | 3.000                   | 2.686                               | 0.040                           |
| 2.000                       | 3.534                   | 4.000                   | 3.686                               | 0.040                           |

### PITCH

The maximum pitch is determined to not exceed the maximum depth of cut (APMX) and to not exceed the maximum ramp angle (RMPX).

### EXAMPLE

- » The minimum hole diameter that the **.625"** diameter cutter can interpolate from solid is **.812"** (leaving a raised cusp).
- » The maximum hole diameter that the **.625"** diameter cutter can interpolate from solid is **1.250"**.
- » The maximum hole diameter that the **.625"** diameter cutter can interpolate from solid while leaving a flat-bottom is **.939"** (leaving no raised cusp).
- » The maximum pitch for this series matches the insert's radial wiper length of **.040"**.