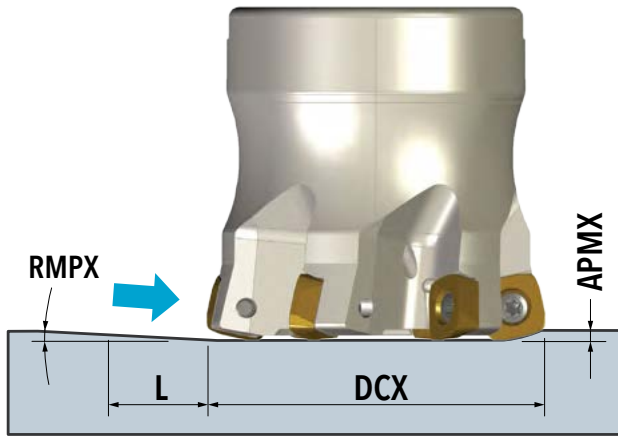


19 mm (MDR Inserts) • Straight Ramping

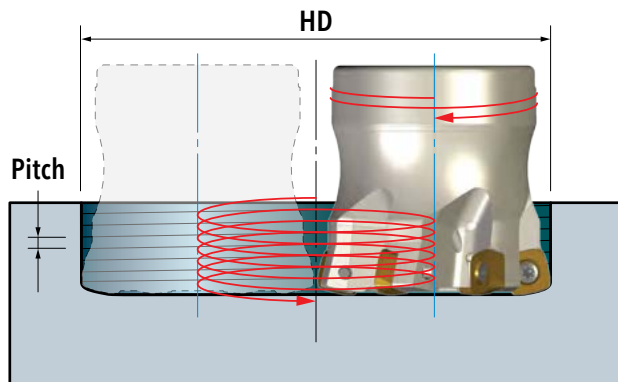


Using Inserts SDES1906MDR-MR, SDMS1906MDR-PH

DCX Cutting Dia. Max.	RMPX Ramp Angle Max.	L*	APMX Depth of Cut Max.
3.000	2.70	2.505	0.118
4.000	1.70	3.978	0.118
5.000	1.70	3.978	0.118
6.000	1.30	5.201	0.118
7.000	1.02	6.629	0.118

* L in this table is the length the cutter travels to reach the maximum depth of cut (.118") while traveling at the maximum ramp angle listed for the cutter.

19 mm (MDR Inserts) • Helical Ramping



Using Inserts SDES1906MDR-MR, SDMS1906MDR-PH

DCX Cutting Dia. Max.	HD Hole Dia. Min.	HD Hole Dia. Max.	HD Hole Dia. Max. w/o Cusp	Max. Pitch Per Revolution
3.000	4.518	6.000	4.766	0.118
4.000	6.520	8.000	6.769	0.118
5.000	8.520	10.000	8.759	0.118
6.000	10.520	12.000	10.757	0.118
7.000	12.521	14.000	12.755	0.118

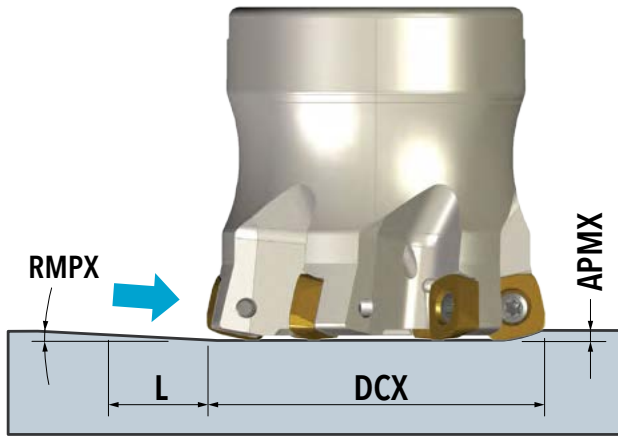
PITCH

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 **3.000"** diameter cutter can interpolate from solid is **4.518"** (leaving a raised cusp).
- » The maximum hole diameter that the **3.000"** diameter cutter can interpolate from solid is **6.000"** (leaving a raised cusp).
- » The maximum hole diameter that the **3.000"** diameter cutter can interpolate from solid while leaving a flat-bottom is **4.766"** (leaving no raised cusp).

19 mm (MPR Inserts) • Straight Ramping

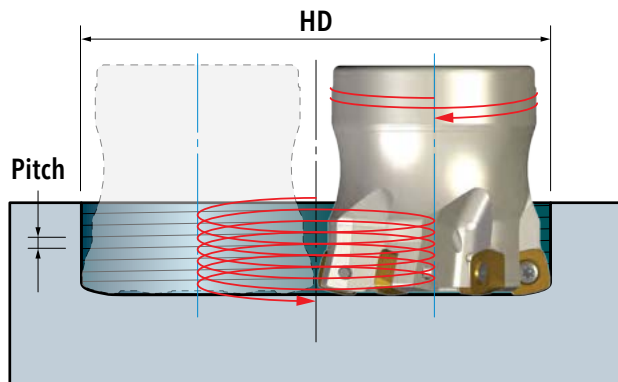


Using Inserts SDES1906MPR-MR, SDES1906MPR-MR1, SDXS1906MPR-MR, & SDXS1906MPR-MR1

DCX Cutting Dia. Max.	RMPX Ramp Angle Max.	L*	APMX Depth of Cut Max.
2.960	1.90	4.373	0.145
3.960	1.20	6.924	0.145
4.961	1.40	5.935	0.145
5.961	1.10	7.553	0.145
6.961	1.02	8.145	0.145

* L in this table is the length the cutter travels to reach the maximum depth of cut (.145") while traveling at the maximum ramp angle listed for the cutter.

19 mm (MPR Inserts) • Helical Ramping



Using Inserts SDES1906MPR-MR, SDES1906MPR-MR1, SDXS1906MPR-MR, & SDXS1906MPR-MR1

DCX Cutting Dia. Max.	HD Hole Dia. Min.	HD Hole Dia. Max.	HD Hole Dia. Max. w/o Cusp	Max. Pitch Per Revolution
2.960	4.526	5.920	4.863	0.145
3.960	6.528	7.920	6.866	0.145
4.961	8.528	9.922	8.858	0.145
5.961	10.528	11.922	10.857	0.145
6.961	12.530	13.922	12.895	0.145

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 **2.960"** diameter cutter can interpolate from solid is **4.526"** (leaving a raised cusp).
- » The maximum hole diameter that the **2.960"** diameter cutter can interpolate from solid is **5.920"** (leaving a raised cusp).
- » The maximum hole diameter that the **2.960"** diameter cutter can interpolate from solid while leaving a flat-bottom is **4.863"** (leaving no raised cusp).