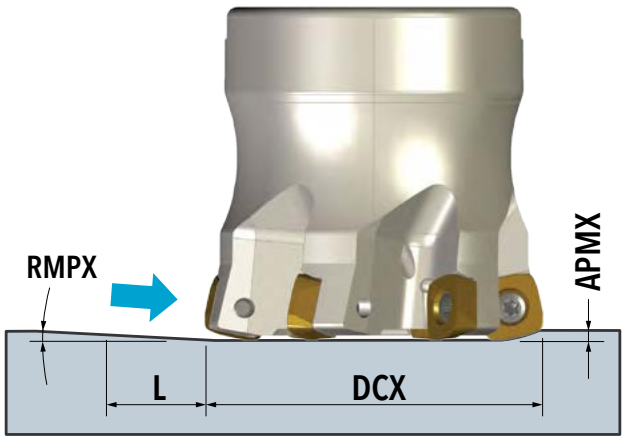
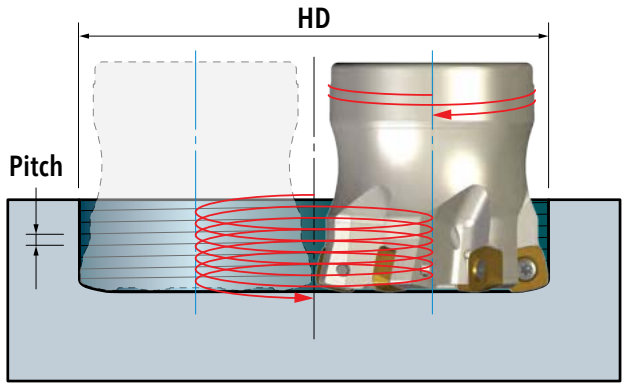
4 mm • Straight Ramping



DCX Cutting Dia. Max.	RMPX Ramp Angle Max.	L*	APMX Depth of Cut Max.
0.375	1.80	0.763	0.024
0.500	4.70	0.279	0.024
0.625	3.00	0.438	0.024
0.750	2.20	0.598	0.024

* L in this table is the length the cutter travels to reach the maximum depth of cut **(.024")** while traveling at the maximum ramp angle listed for the cutter.

4 mm • Helical Ramping



PITCH

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

DCX Cutting Dia. Max.	HD Hole Dia. Min.	HD Hole Dia. Max.	HD Hole Dia. Max. w/o Cusp	Max. Pitch Per Revolution
0.375	0.476	0.750	0.542	0.024
0.500	0.704	1.000	0.791	0.024
0.625	0.952	1.250	1.040	0.024
0.750	1.202	1.500	1.290	0.024

EXAMPLE

» The minimum hole diameter that the **.375"** diameter cutter can interpolate from solid is **.476"** (leaving a raised cusp).

» The maximum hole diameter that the **.375"** diameter cutter can interpolate from solid is **.750"**.

» The maximum hole diameter that the **.375"** diameter cutter can interpolate from solid while leaving a flat-bottom is **.542"** (leaving no raised cusp).

» The maximum pitch for this series matches the insert's radial wiper length of **.024"**.