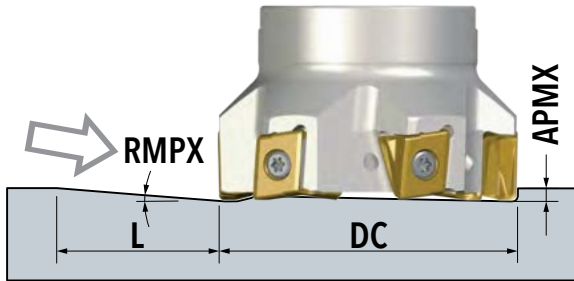


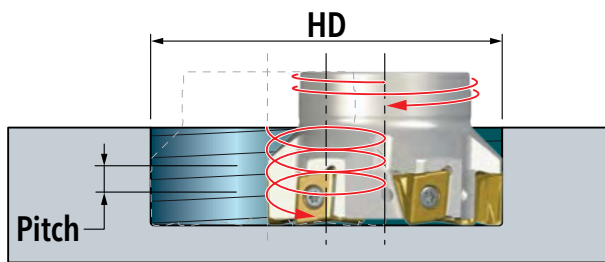
## 13 mm • Straight Ramping



DCX Cutting Dia. Max.	RMPX Ramp Angle Max.	L*	APMX Depth of Cut Max.
2.000	0.98	28.000	0.479
2.500	0.75	36.590	0.479
3.000	0.6	45.740	0.479
4.000	0.44	62.370	0.479
5.000	0.34	80.720	0.479
6.000	0.28	98.020	0.479

\* L in this table is the length the cutter travels to reach the maximum depth of cut (.479") while traveling at the maximum ramp angle listed for the cutter.

## 13 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).

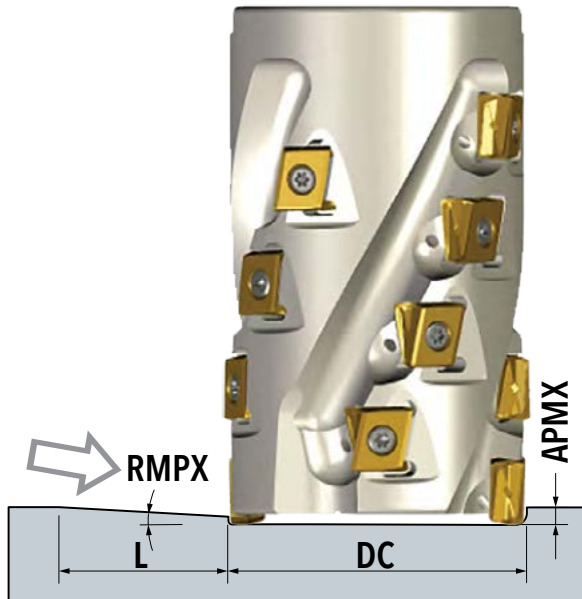
DCX Cutting Dia. Max.	HD Hole Dia. Min.	HD Hole Dia. Max.	HD Hole Dia. Min. w/o Cusp	HD Hole Dia. Max. w/o Cusp	Max. Pitch Per Revolution
2.000	3.470	4.000	3.740	3.938	0.091
2.500	4.470	5.000	4.740	4.938	0.087
3.000	5.470	6.000	5.740	5.938	0.084
4.000	7.470	8.000	7.740	7.938	0.082
5.000	9.470	10.000	9.740	9.938	0.079
6.000	11.470	12.000	11.740	11.938	0.078

All ramping data is calculated with CGM324R001-M inserts installed.

### EXAMPLE

- » The minimum hole diameter that the **2.000"** diameter cutter can interpolate from solid is **3.470"** (leaving a raised cusp).
- » The maximum hole diameter that the **2.000"** diameter cutter can interpolate from solid is **4.000"**.
- » The maximum hole diameter that the **2.000"** diameter cutter can interpolate from solid while leaving a flat-bottom is **3.938"** (leaving no raised cusp).

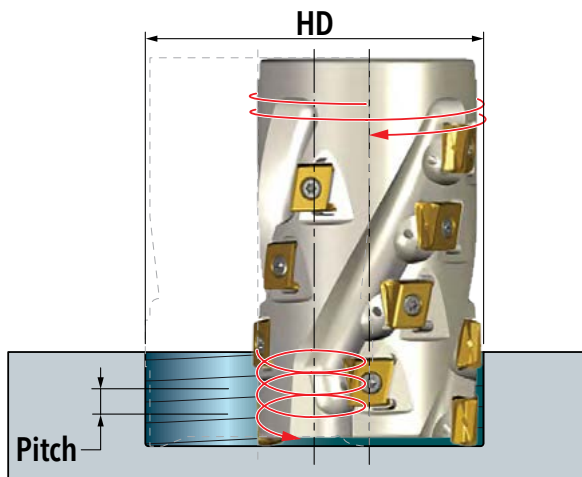
## 13 mm (Extended Flute / Series 2EJ1D) • Straight Ramping NEW



DCX Cutting Dia. Max.	RMPX Ramp Angle Max.	L*
2.000	0.98°	28.000
2.500	0.75°	36.590
3.000	0.60°	45.740
4.000	0.44°	62.370

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

## 13 mm (Extended Flute / Series 2EJ1D) • Helical Ramping NEW



DCX Cutting Dia. Max.	HD Hole Dia. Min.	HD Hole Dia. Max.	HD Hole Dia. Max. w/o Cusp	Max. Pitch Per Revolution
2.000	3.470	4.000	3.938	0.091
2.500	4.470	5.000	4.938	0.087
3.000	5.470	6.000	5.938	0.084
4.000	7.470	8.000	7.938	0.082

### EXAMPLE

- » The minimum hole diameter that the **2.000"** diameter cutter can interpolate from solid is **3.470"** (leaving a raised cusp).
- » The maximum hole diameter that the **2.000"** diameter cutter can interpolate from solid is **4.000"**.
- » The maximum hole diameter that the **2.000"** diameter cutter can interpolate from solid while leaving a flat-bottom is **3.938"** (leaving no raised cusp).

### PITCH

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