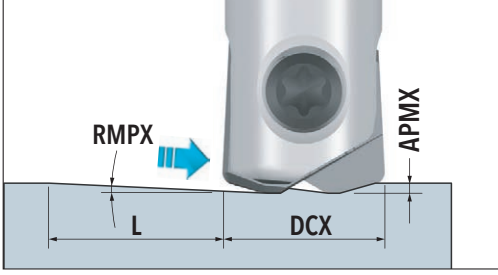
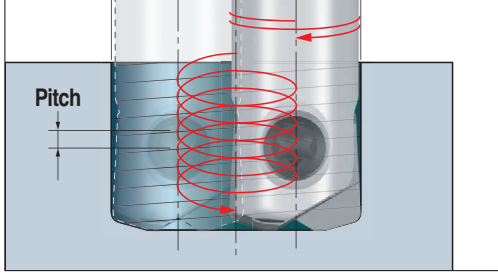


NANOFEED RAMPING DATA

• Straight Ramping

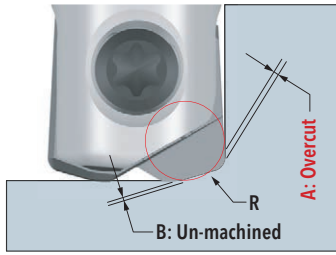


• Helical Milling



Part Number	DCX Cutting Dia. Max.	Straight Ramp Down			Helical Ramp Down		
		RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Max Pitch Per Revolution
WEEM060105R	Ø6	2.0	0.3	9	9.6	-	0.3
					-	11	0.3
WEEM080106R	Ø8	2.5	0.5	11	12	-	0.5
					-	15	0.5

NANOFEED PROGRAMMING TECHNICAL DATA



Part Number	REQ Program Radius	A Over Cut	B Un-Machined
WEEM060105R	.8	0	.21
WEEM080106R	1	0	.32

