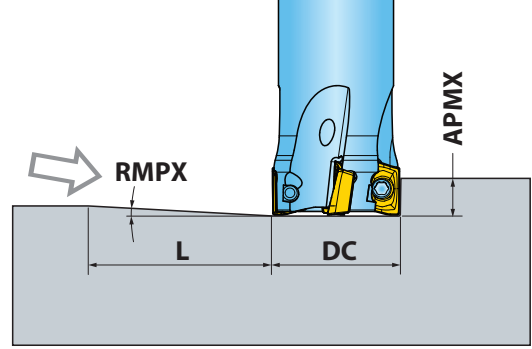
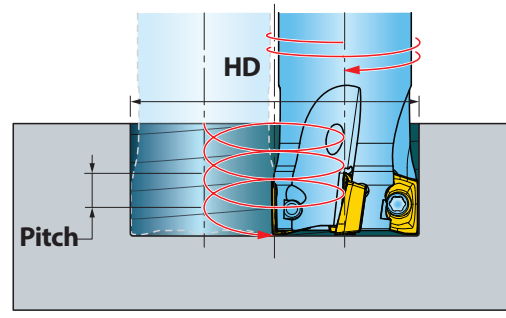


**HI-POS™ RAMPING DATA**

**Straight Ramping**



**Helical Ramping**



Ramp Data - 90° Inserts (AOMT06)						
DC Cutter Diameter	Straight Ramp			Helical Ramp		
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.
0.375	10.5	0.22	1.2	0.43		0.035
					0.75	0.135
0.500	5.5	0.22	2.3	0.75		0.059
					1.00	0.125
0.625	4.0	0.22	3.1	0.95		0.062
					1.25	0.118
0.750	2.6	0.22	4.8	1.18		0.062
					1.50	0.168
1.000	2.0	0.22	6.3	1.65		0.067
					2.00	0.137

Ramp Data - Hi-Feed Insert (UOMT06)						
DC Cutter Diameter	Straight Ramp			Helical Ramp		
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.
0.375	0.5	0.019	2.2	0.55		0.004
					0.75	0.008
0.500	4.5	0.019	0.3	0.70		0.019
					1.00	0.019
0.625	2.8	0.019	0.4	1.02		0.019
					1.25	0.019
0.750	2.2	0.019	0.5	1.02		0.019
					1.50	0.019
1.000	1.4	0.019	0.8	1.73		0.019
					2.00	0.019