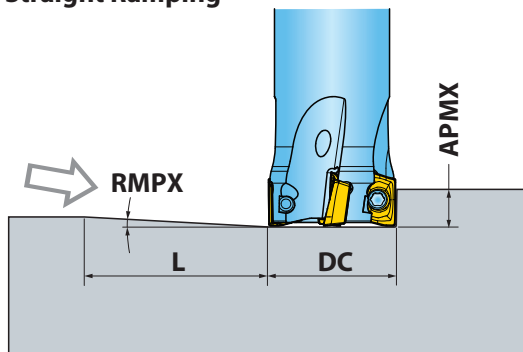
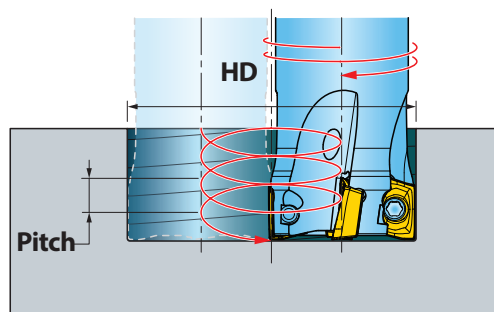


**HI-POS™ RAMPING DATA**

**Straight Ramping**



**Helical Ramping**



**Ramp Data - 90° Inserts (AOMT06)**

| DC<br>Cutter<br>Diameter | Straight Ramp           |                           |                       | Helical Ramp         |                      |               |
|--------------------------|-------------------------|---------------------------|-----------------------|----------------------|----------------------|---------------|
|                          | RMPX<br>Ramp Angle Max. | APMX<br>Depth of Cut Max. | L<br>Ramp Length Min. | HD<br>Hole Dia. Min. | HD<br>Hole Dia. Max. | Pitch<br>Max. |
| 0.375                    | 10.5                    | 0.22                      | 1.2                   | 0.43                 | 0.75                 | 0.035         |
| 0.500                    | 5.5                     | 0.22                      | 2.3                   | 0.75                 | 1.00                 | 0.059         |
| 0.625                    | 4.0                     | 0.22                      | 3.1                   | 0.95                 | 1.25                 | 0.062         |
| 0.750                    | 2.6                     | 0.22                      | 4.8                   | 1.18                 | 1.50                 | 0.062         |
| 1.000                    | 2.0                     | 0.22                      | 6.3                   | 1.65                 | 2.00                 | 0.067         |
|                          |                         |                           |                       |                      |                      | 0.137         |

**Ramp Data - Hi-Feed Insert (UOMT06)**

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