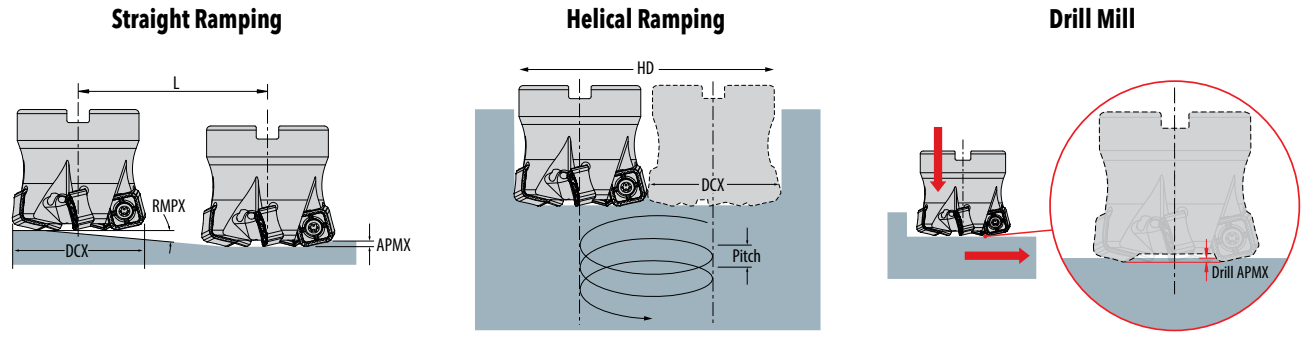


ISOPPLUS™ SERIES 1DD1H/DD6H RAMPING DATA



DC Cutter Diameter	Straight Ramp			Helical Ramp			Drill Mill
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Min.	HD Hole Dia. Min.	HD Hole Dia. Max.	Pitch Max.	Drill APMX Depth of Cut Max.
1.500	-	-	-	-	-	-	-
2.000	1.14	0.065	3.2	3.10	4.00	0.024	0.024
2.500	0.86	0.065	4.3	4.10	5.00	0.024	0.024
3.000	0.66	0.065	5.6	5.10	6.00	0.024	0.024
4.000	0.45	0.065	8.2	7.10	8.00	0.024	0.024
5.000	0.34	0.065	10.9	9.10	10.00	0.024	0.024
6.000	0.27	0.065	13.7	11.10	12.00	0.024	0.024