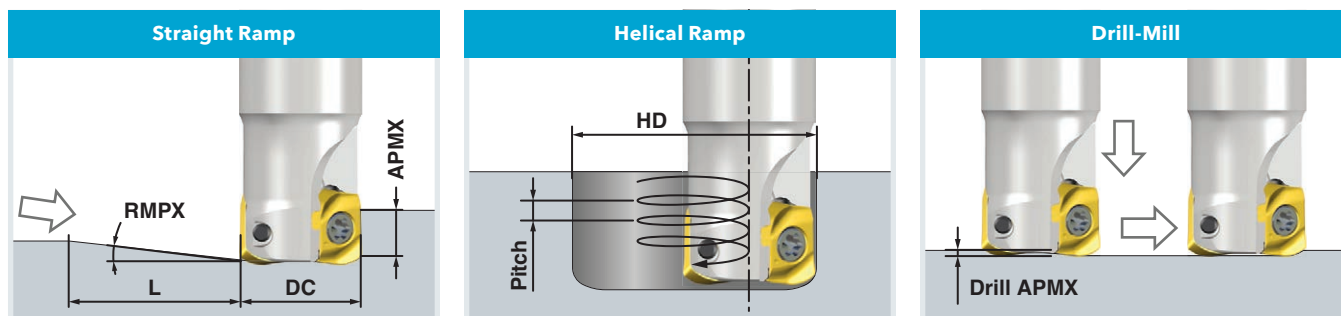


## Ramp Data Using Series XEVT10-HF • Hi-Feed



| DC<br>Cutter Diameter | Straight Ramp           |                           |                       | Helical Ramp         |                      |            | Drill-Mill |
|-----------------------|-------------------------|---------------------------|-----------------------|----------------------|----------------------|------------|------------|
|                       | RMPX<br>Ramp Angle Max. | APMX<br>Depth of Cut Max. | L<br>Ramp Length Max. | HD<br>Hole Dia. Min. | HD<br>Hole Dia. Max. | Pitch Max. | Drill APMX |
| 0.625                 | 7.6                     | 0.03                      | 0.2                   | 0.80                 |                      | 0.075      |            |
|                       |                         |                           |                       |                      | 1.25                 | 0.263      | 0.03       |
| 0.750                 | 4.2                     | 0.04                      | 0.5                   | 1.05                 |                      | 0.078      |            |
|                       |                         |                           |                       |                      | 1.50                 | 0.180      | 0.04       |
| 1.000                 | 2.6                     | 0.05                      | 1.1                   | 1.55                 |                      | 0.075      |            |
|                       |                         |                           |                       |                      | 2.00                 | 0.140      | 0.05       |
| 1.250                 | 1.7                     | 0.05                      | 1.6                   | 2.05                 |                      | 0.075      |            |
|                       |                         |                           |                       |                      | 2.50                 | 0.120      | 0.05       |
| 1.500                 | 1.2                     | 0.05                      | 2.3                   | 2.55                 |                      | 0.075      |            |
|                       |                         |                           |                       |                      | 3.00                 | 0.100      | 0.05       |
| 2.000                 | 0.9                     | 0.05                      | 3.1                   | 3.55                 |                      | 0.075      |            |
|                       |                         |                           |                       |                      | 4.00                 | 0.095      | 0.05       |
| 3.000                 | 0.4                     | 0.05                      | 7.1                   | 5.55                 |                      | 0.075      |            |
|                       |                         |                           |                       |                      | 6.00                 | 0.085      | 0.05       |

| Programming<br>Technical Data | Part<br>Number | R<br>Program | A<br>Overcut | B<br>Unmachined |
|-------------------------------|----------------|--------------|--------------|-----------------|
|                               | XEVT1004TR-HF  | 0.067        | 0.0000       | 0.019           |
|                               |                | 0.075        | 0.0000       | 0.017           |
|                               |                | 0.078        | 0.0004       | 0.016           |
|                               |                | 0.100        | 0.0050       | 0.009           |
|                               |                | 0.120        | 0.0120       | 0.004           |

= Recommended program "R"