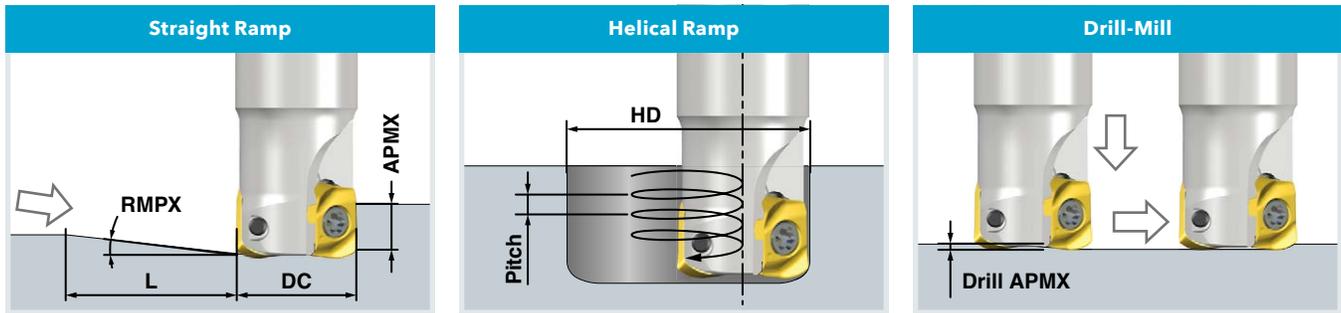


Ramp Data Using Series XEVT10-HF • Hi-Feed



DC Cutter Diameter	Straight Ramp			Helical Ramp			Drill-Mill
	RMPX Ramp Angle Max.	APMX Depth of Cut Max.	L Ramp Length Max.	HD Hole Dia. Min.	HD 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 Technical Data	Part Number	R Program	A Overcut	B 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"