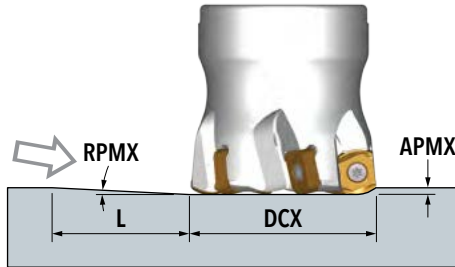
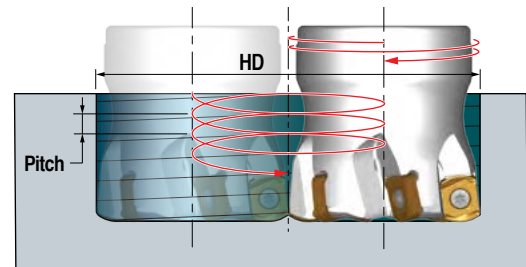


Recommended Ramping Angle

Straight Ramping



Helical Milling



DCX Cutting Dia. Max.	Straight Ramp Down			Helical Ramp Down		
	RPMX Ramp Angle Max.	APMX Depth of Cut Max.	L Min. Length	HD Min. Dia.	HD Max. Dia.	Max. Pitch / Rev.
0.625	5.100	0.028	0.31	1.018		.027
					1.250	.027
0.750	2.700	0.039	0.84	1.224		.039
					1.500	.039
0.875	2.400	0.039	0.94	1.474		.039
					1.750	.039
1.000	2.400	0.039	0.94	1.724		.039
					2.000	.039
1.250	1.450	0.039	1.56	2.224		.039
					2.500	.039
1.500	1.150	0.039	1.96	2.724		.039
					3.000	.039
2.000	0.800	0.039	2.82	3.724		.039
					4.000	.039