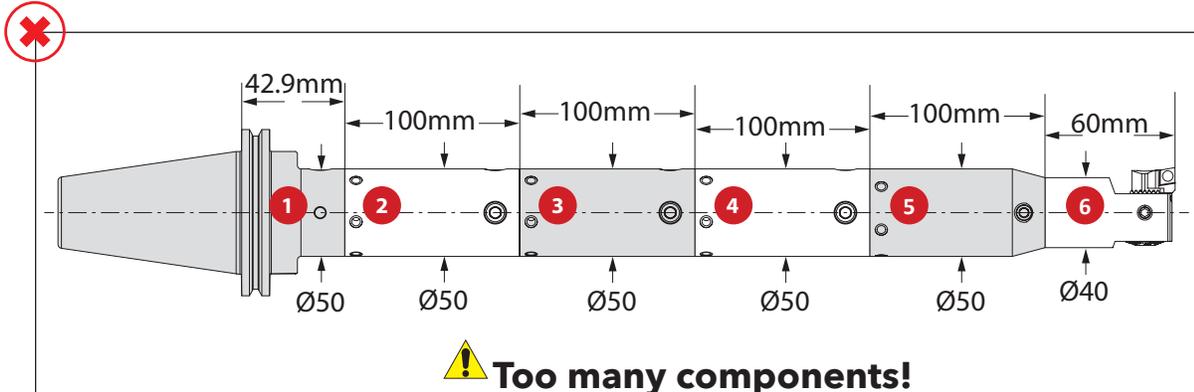


Guidelines for not Exceeding Recommended Length to Diameter Ratio

To calculate, see graphics below:



NOTE: Length to diameter ratio is calculated using body diameters, not cutting diameter.
NOTE: Do not exceed recommended 10xD length to diameter ratio or exceed 4 total components (including shank)

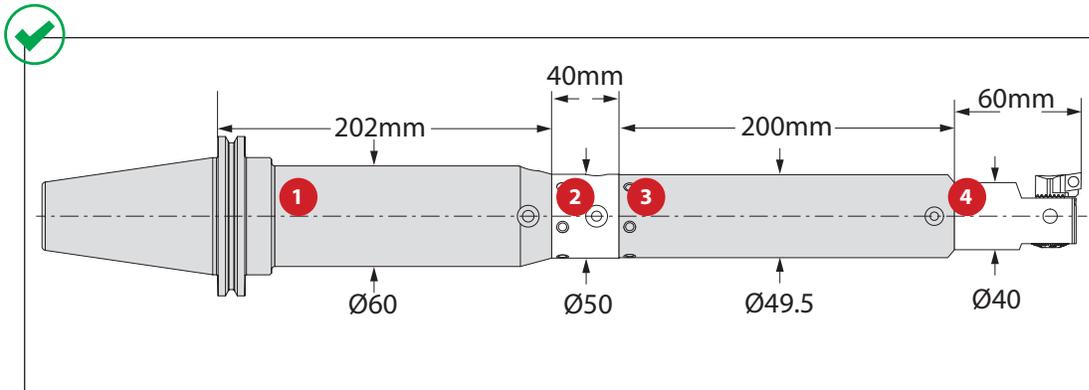
Step 1: Find L : D by component

- 1 0.9 = 42.9/50
- 2 2.0 = 100/50
- 3 2.0 = 100/50
- 4 2.0 = 100/50
- 5 2.0 = 100/50
- 6 1.5 = 60/40

Step 2: Add each L : D Average

- 0.9
- 2.0
- 2.0
- 2.0
- 2.0
- 2.0
- + 1.5
- 10.4 = L : D ratio

Too long with too many components!



NOTE: Length to diameter ratio is calculated using body diameters, not cutting diameter.
NOTE: Do not exceed recommended 10xD length to diameter ratio or exceed 4 total components (including shank)

Step 1: Find L : D by component

- 1 3.2 = 202/60
- 2 0.8 = 40/50
- 3 4.0 = 200/49.5
- 4 1.5 = 60/40

Step 2: Add each L : D average

- 3.2
- 0.8
- 4.0
- + 1.5
- 9.5 = L : D ratio

! WARNING Tool failure can cause serious injury. To prevent:

-Do not exceed recommended 10xD length to diameter ratio or exceed 4 total components (including shank)

Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com