



# PCD Diamond Stock Inserts

Standard PCD edge for all stock inserts is 0.125" unless indicated

Max D.O.C. = **.075**



STYLE	GRADE PCD13	PRICE	GRADE PCD15	PRICE
CCMW 21.51	60000	\$XX.XX	60004	\$XX.XX
CCMW 21.52	60050	\$XX.XX	60054	\$XX.XX
CCMW 32.51	60100	\$XX.XX	60104	\$XX.XX
CCMW 32.52	60150	\$XX.XX	60154	\$XX.XX
CDCD 51*	-	-	60254	\$XX.XX
CNGA 431	60300	\$XX.XX	60304	\$XX.XX
CNGA 432	60450	\$XX.XX	60454	\$XX.XX
CPMW 21.51	61200	\$XX.XX	61204	\$XX.XX
CPMW 21.52	61250	\$XX.XX	61254	\$XX.XX
CPMW 32.51	61300	\$XX.XX	61304	\$XX.XX
CPMW 32.52	61350	\$XX.XX	61354	\$XX.XX
DCMW 21.51	61400	\$XX.XX	61404	\$XX.XX
DCMW 32.52	61450	\$XX.XX	61454	\$XX.XX
DNGA 431	61500	\$XX.XX	61504	\$XX.XX
DNGA 432	61650	\$XX.XX	61654	\$XX.XX
DPMW 21.51	61950	\$XX.XX	61954	\$XX.XX
DPMW 32.52	62150	\$XX.XX	62154	\$XX.XX



STYLE	GRADE PCD13	PRICE	GRADE PCD15	PRICE
SPG 321	-	-	63404	\$XX.XX
SPG 322	-	-	63454	\$XX.XX
SPG 421	-	-	63604	\$XX.XX
SPG 422	-	-	63654	\$XX.XX
TCMW 21.51	64000	\$XX.XX	64004	\$XX.XX
TNG 321	-	-	64504	\$XX.XX
TNG 322	-	-	64554	\$XX.XX
TPG 221	-	-	65154	\$XX.XX
TPG 222	-	-	65204	\$XX.XX
TPG 321	65250	\$XX.XX	65254	\$XX.XX
TPG 322	65300	\$XX.XX	65304	\$XX.XX
TPG 431	-	-	65604	\$XX.XX
TPG 432	-	-	65654	\$XX.XX
TPMW 21.51	-	-	66054	\$XX.XX
VNGA 331	-	-	66754	\$XX.XX
VNGA 332	66900	\$XX.XX	66904	\$XX.XX

\*.060" PCD edge

Non-standard grades, PCD edge lengths, insert styles and sizes will be quoted on request.

NOTE: Minimum PCD edge for all stock inserts is 0.125". (Except for TPG-221 and TPG-222, which have minimum PCD edges of 0.095" and 0.085" respectively.)

## Application Guidelines

**PCD 13** General Purpose Applications  
 Aluminums <12% Silicon  
 Copper Alloys

**PCD 15** Interrupted Cuts  
**PCD 18** Aluminums >12% Silicon  
 Composite Graphite Epoxy  
 Metal Matrix Composites

**Rough Turning: >.025" D.O.C.;**  
**Finish Turning: <.025" D.O.C.**

WARNING: PCD depth of cut should not exceed 60% of total cutting edge available

MATERIAL	OPERATION	GRADE PCD	SURFACE SPEED FT/MIN	FEED RATE IN/REV
Aluminum/Alum. Alloys <12% Silicon	Rough Turning	13	2000-6000	.005 -.020
Aluminum/ Alum. Alloys <12% Silicon	Finish Turning	15 or 18	2000-6000	.003 -.008
Aluminum/Alum. Alloys >12% Silicon	Rough Turning	15 or 18	1000-2000	.005 -.015
Aluminum/Alum. Alloys >12% Silicon	Finish Turning	15 or 18	1000-3000	.003 -.008
Copper/Copper Alloys/Zinc	Rough Turning	13	800-1200	.005 -.010
Copper/Copper Alloys/Zinc	Finish Turning	13	1000-2000	.004 -.010
Plastics/Composites	Rough Turning	13 or 15	650-2600	.004 -.016
Plastics/Composites	Finish Turning	13	1000-5000	.004 -.016
Sintered Tungsten Carbide <16 Cobalt	Finish Turning	15	50-100	.004 -.010

# CBN Carbide Stock Inserts

Standard CBN edge for all stock inserts is 0.125" unless indicated

Max D.O.C. = **.075**

	STYLE	GRADE CBN6	PRICE	GRADE CBN8	PRICE
	CCMW 21.51	60012	\$XX.XX	60028	\$XX.XX
	CCMW 21.52	60062	\$XX.XX	60078	\$XX.XX
	CCMW 32.51	60112	\$XX.XX	60128	\$XX.XX
	CCMW 32.52	60162	\$XX.XX	60178	\$XX.XX
	CDCD 505*	60250	\$XX.XX	60278	\$XX.XX
	CDCD 51*	-	-	60254	\$XX.XX
	CNGA 431	60312	\$XX.XX	60328	\$XX.XX
	CNGA 432	60462	\$XX.XX	60478	\$XX.XX
	CNGA 433	60612	\$XX.XX	-	-
	CPMW 21.51	61212	\$XX.XX	61228	\$XX.XX
	CPMW 21.52	61262	\$XX.XX	61278	\$XX.XX
	CPMW 32.51	61312	\$XX.XX	61328	\$XX.XX
	CPMW 32.52	61362	\$XX.XX	61378	\$XX.XX
	DNGA 431	61512	\$XX.XX	61528	\$XX.XX
	DNGA 432	61662	\$XX.XX	61678	\$XX.XX
	RNG 32	62362	\$XX.XX	62378	\$XX.XX
	RNG 42	62412	\$XX.XX	62428	\$XX.XX
	SNG 432 FULL TOP	62862	\$XX.XX	62878	\$XX.XX
	SNG 433 FULL TOP	62912	\$XX.XX	62928	\$XX.XX

	STYLE	GRADE CBN6	PRICE	GRADE CBN8	PRICE
	SNG 432	63012	-	63028	\$XX.XX
	TCMW 21.51	64012	\$XX.XX	64028	\$XX.XX
	TCMW 21.52	64062	\$XX.XX	64078	\$XX.XX
	TCMW 32.51	64112	\$XX.XX	64128	\$XX.XX
	TCMW 32.52	64162	\$XX.XX	64178	\$XX.XX
	TNG 432	64612	\$XX.XX	64628	\$XX.XX
	TNGA 431	64712	\$XX.XX	64728	\$XX.XX
	TNGA 432	64762	\$XX.XX	64778	\$XX.XX
	TPG 221	65162	\$XX.XX	65178	\$XX.XX
	TPG 222	65212	\$XX.XX	65228	\$XX.XX
	TPG 321	65262	\$XX.XX	65278	\$XX.XX
	TPG 322	65312	\$XX.XX	65328	\$XX.XX
	TPG 431	-	-	65628	\$XX.XX
	TPG 432	65662	\$XX.XX	65678	\$XX.XX
	TPMW 21.51	66062	\$XX.XX	66078	\$XX.XX
	VNGA 331	66762	\$XX.XX	66778	\$XX.XX
	VNGA 332	66912	\$XX.XX	66928	\$XX.XX
	VNGA 333	67062	\$XX.XX	-	-

\*.060" CBN edge

Custom or other CBN options available upon request.

NOTE: All stock CBN inserts have a T-land of .20" x .004. Interrupted cut may require an additional hone. If applicable, please indicate when ordering.

## Application Guidelines

**CBN 6** Interrupted and Roughing Cuts  
 Pearlitic Gray Cast Iron  
 Tool and Die Steels  
 Hard Facing Alloys  
 Powder Metals  
 Finishing of Ni- and Co- based Superalloys

**CBN 8** Best for Hard Turning of  
**CBN 30** Hardened Steels >45 HRC

**Rough Turning: >.025" D.O.C.;**  
**Finish Turning: <.025" D.O.C.**

WARNING: CBN depth of cut should not exceed 35% of total cutting edge available

MATERIAL	OPERATION	GRADE CBN	SURFACE SPEED FT/MIN	FEED RATE IN/REV
Hardened High Carbon Steel	Rough Turning	8	300-450	.004-.012
Hardened High Carbon Steel	Finish Turning	8 or 30	400-600	.004-.008
Hardened Alloy Steels	Rough Turning	8	300-400	.004-.012
Hardened Alloy Steels	Finish Turning	8 or 30	400-500	.004-.008
Hardened Tool and Die Steels	Rough Turning	8	200-300	.004-.008
Hardened Tool and Die Steels	Finish Turning	8 or 30	250-350	.004-.008
Pearlitic Gray Cast Iron <240HBN	Rough/Finish Turning	6	1500-3500	.010-.020
Pearlitic Gray Cast Iron <240HBN	Rough/Finish Turning	6	1000-2000	.010-.020
White Alloy Cast Iron (Ni-hard, Cr-Mo, HiCr)	Rough/Finish Turning	6	200-400 (R) 300-600 (F)	.010-.030 (B)
Superalloys	Rough/Finish Turning	6	500-1000	.004-.010
Thermal Spray Nickel Based	Rough/Finish Turning	6	200-600 (R) 300-1000 (F)	.003-.008 (B)
Thermal Spray Cobalt Based	Rough/Finish Turning	6	400-700 (R) 500-1000 (F)	.002-.006 (B)
Powder Metal	Rough Turning	6	300-800	.004-.010
Powder Metal	Finish Turning	6	300-1000	.003-.008

(R) Denotes Rough Turning Surface Speed. (F) Denotes Finish Turning Surface Speed. (B) Denotes the feed rate is the same for rough and finish turning.