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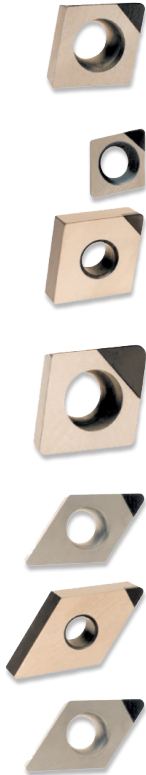
SALES SUPPORT & SERVICE
(740) 392-0330

PCD Diamond Stock Inserts

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

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

STYLE	GRADE PCD13	LIST	GRADE PCD15	LIST
CCMW 21.51	60000	\$35.30	60004	\$35.30
CCMW 21.52	60050	\$35.30	60054	\$35.30
CCMW 32.51	60100	\$36.80	60104	\$36.80
CCMW 32.52	60150	\$36.80	60154	\$36.80
CDCD 51*	-	-	60254	\$46.35
CNGA 431	60300	\$31.45	60304	\$31.45
CNGA 432	60450	\$31.45	60454	\$31.45
CPMW 21.51	61200	\$35.30	61204	\$35.30
CPMW 21.52	61250	\$35.30	61254	\$35.30
CPMW 32.51	61300	\$36.80	61304	\$36.80
CPMW 32.52	61350	\$36.80	61354	\$36.80
DCMW 21.51	61400	\$35.30	61404	\$35.30
DCMW 32.52	61450	\$36.80	61454	\$36.80
DNGA 431	61500	\$32.87	61504	\$32.87
DNGA 432	61650	\$32.87	61654	\$32.87
DPMW 21.51	61950	\$35.30	61954	\$35.30
DPMW 32.52	62150	\$36.80	62154	\$36.80



STYLE	GRADE PCD13	LIST	GRADE PCD15	LIST
SPG 321	-	-	63404	\$31.92
SPG 322	-	-	63454	\$31.92
SPG 421	-	-	63604	\$32.76
SPG 422	-	-	63654	\$32.76
TCMW 21.51	64000	\$35.70	64004	\$35.70
TNG 321	-	-	64504	\$33.13
TNG 322	-	-	64554	\$33.13
TPG 221	-	-	65154	\$28.88
TPG 222	-	-	65204	\$28.88
TPG 321	65250	\$33.76	65254	\$33.76
TPG 322	65300	\$33.76	65304	\$33.76
TPG 431	-	-	65604	\$35.81
TPG 432	-	-	65654	\$35.81
TPMW 21.51	-	-	66054	\$35.70
VNGA 331	-	-	66754	\$34.34
VNGA 332	66900	\$34.34	66904	\$34.34

*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 15/18 Interrupted Cuts
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	15/18	2000-6000	.003 -.008
Aluminum/Alum. Alloys >12% Silicon	Rough Turning	15/18	1000-2000	.005 -.015
Aluminum/Alum. Alloys >12% Silicon	Finish Turning	15/18	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
Plast cs/Composites	Rough Turning	13/15	650-2600	.004 -.016
Plast cs/Composites	Finish Turning	13	1000-5000	.004 -.016
Sintered Tungsten Carbide <16 Cobalt	Finish Turning	15	50-100	.004 -.010

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