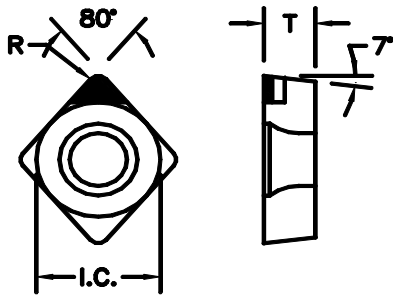
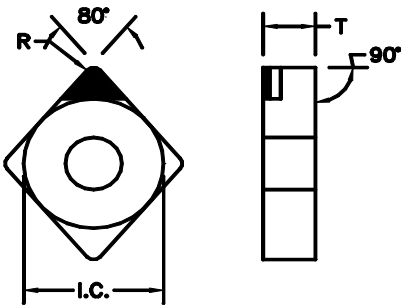


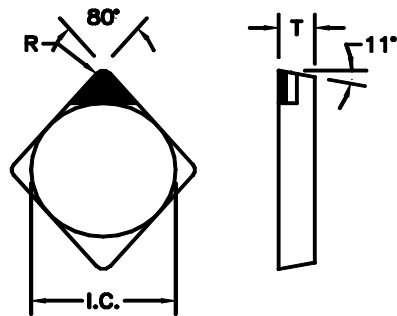
PCD OR CBN



<b>CCMW</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
CCMW-32.51	.375	.156	.015
CCMW-32.52	.375	.156	.031
CCMW-432	.500	.187	.031

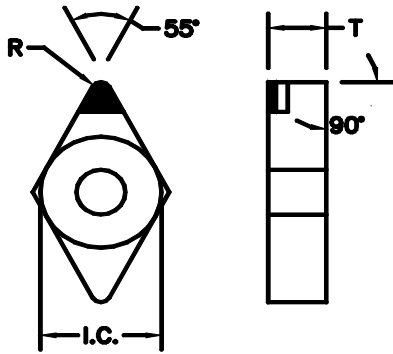


<b>CNGA</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
CNGA-432	.500	.187	.031
CNGA-433	.500	.187	.046
CNGA-543	.625	.250	.046

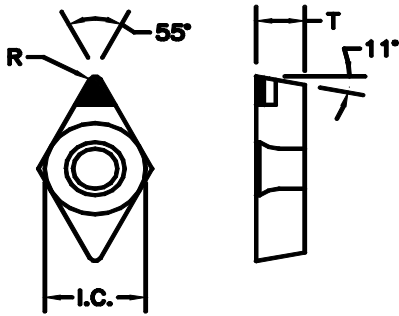


<b>CPG</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
CPG-422	.500	.125	.031
CPG-423	.500	.125	.046
CPG-424	.500	.125	.062

PCD OR CBN

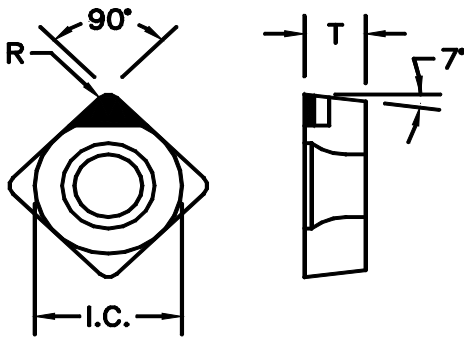


<b>DNGA</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
DNGA-432	.500	.187	.031
DNGA-433	.500	.187	.046
DNGA-543	.625	.250	.046

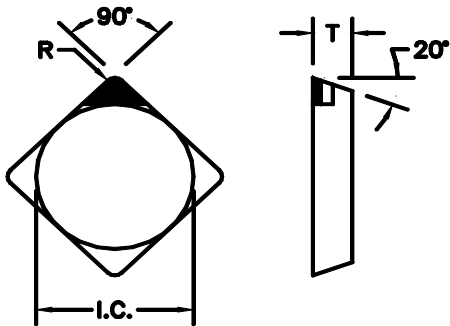


<b>DPMW</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
DPMW-21.51	.250	.094	.015
DPMW-32.51	.375	.156	.015
DPMW-32.52	.375	.156	.031

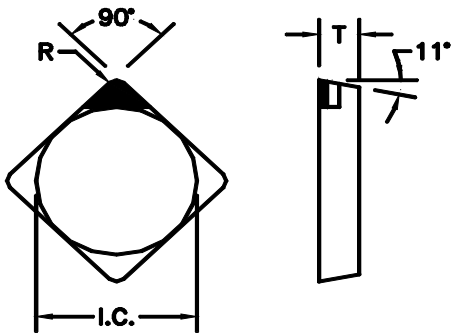
PCD OR CBN



<b>SCMW</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
SCMW-21.51	.250	.094	.015
SCMW-32.51	.375	.156	.015
SCMW-32.52	.375	.156	.031

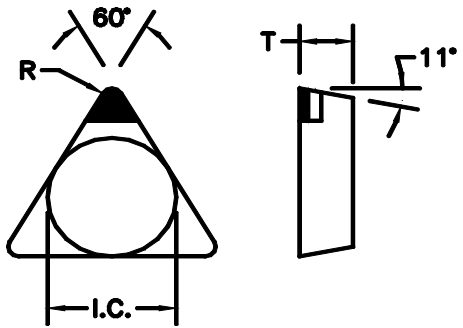


<b>SEC</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
SEC-322	.375	.125	.031
SEC-422	.500	.125	.031
SEC-424	.500	.125	.062
SEC-533	.625	.187	.046

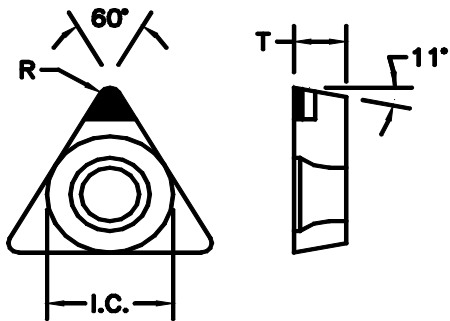


<b>SPG</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
SPG-321	.375	.125	.015
SPG-322	.375	.125	.031
SPG-422	.500	.125	.031
SPG-423	.500	.125	.046
SPG-432	.500	.187	.031
SPG-433	.500	.187	.046

PCD OR CBN

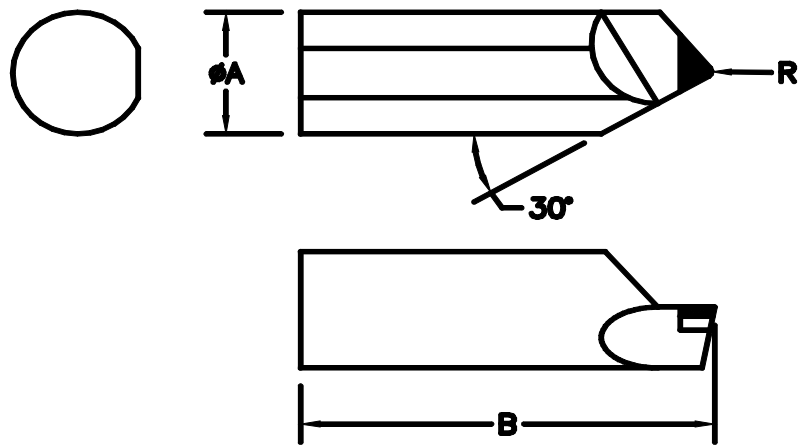


<b>TPG</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
TPG-221	.250	.125	.015
TPG-222	.250	.125	.031
TPG-321	.375	.125	.015
TPG-322	.375	.125	.031
TPG-432	.500	.187	.031
TPG-433	.500	.187	.046

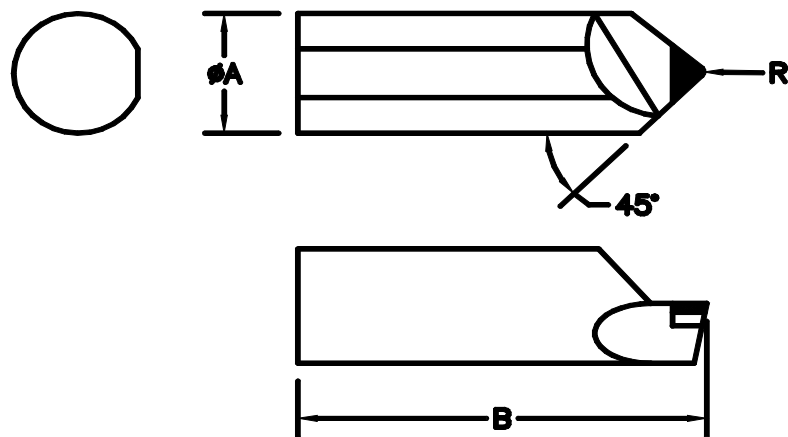


<b>TPMW</b>	<b>I.C.</b>	<b>T</b>	<b>R</b>
TPMW-21.51	.250	.094	.015
TPMW-32.51	.375	.156	.015
TPMW-32.52	.375	.156	.031

PCD OR CBN

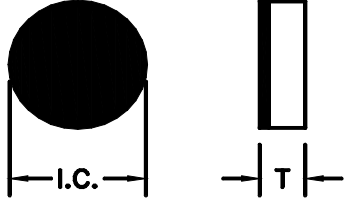


TRC	ØA	B	R
TRC-250	.250	.750	AS REQ'D
TRC-312	.312	1.00	AS REQ'D
TRC-375	.375	1.50	AS REQ'D
TRC-500	.500	2.00	AS REQ'D



TRE	ØA	B	R
TRE-250	.250	.750	AS REQ'D
TRE-312	.312	1.00	AS REQ'D
TRE-375	.375	1.50	AS REQ'D
TRE-500	.500	2.00	AS REQ'D

## CBN ROUNDS



### BRNG

#### FULL TOP

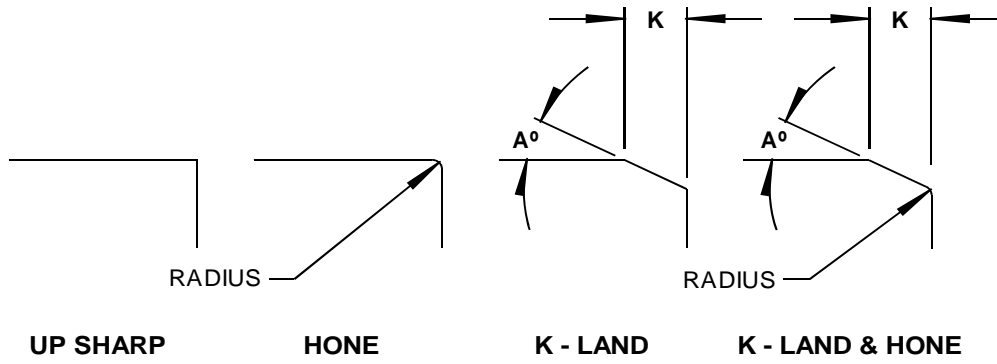
	I.C.	T
CBN-375E	.375	.125
CBN-500E	.500	.125
CBN-500SE	.500	.187

### BRNG

#### SOLID

	I.C.	T
CBN-375	.375	.125
CBN-500	.500	.125
CBN-500S	.500	.187

# CBN EDGE PREPARATION



## PCD & CBN GRADES

### DEBEERS INDUSTRIAL

SYNDITE PCD	002	010	025
AMBORITE CBN	DBC50	DBA80	AMB90

### DIAMOND INNOVATIONS

COMPAX PCD	1300	1500	1600
BORAZON CBN	6000	7000	8100

### SUMITOMO ELECTRIC

SUMIDIA PCD	DA90	DA100	DA150	DA200		
SUMIBORON CBN	BN100	BN200	BN300	BN520	BN550	BNX4

### MEGADIAMOND

PCD	F05	M10	C30X
CBN	N50	N90	

## PCD STARTING PARAMETERS

<b>MATERIAL</b>	<b>SPEED SFM</b>	<b>DOC INCH</b>	<b>FEEDRATE IPR</b>
ALUMINUM <7.5% SILICON	1800-5000	.002-.125	.004-.020
ALUMINUM 7.5-12% SILICON	1000-4000	.002-.125	.004-.015
ALUMINUM 16-18% SILICON	500-2500	.002-.100	.002-.010
COPPER	1200-3500	.005-.125	.005-.020
BRASS	1200-3500	.005-.125	.005-.020
SINTERED CARBIDE	40-90	.002-.025	.004-.020
UNSINTERED CARBIDE	400-1200	.005-.100	.004-.025
CEMENTED PRESSED CERAMICS	200-800	.001-.005	.001-.005
FIBERGLASS	300-2500	.005-.020	.001-.010
PLASTICS	550-4500	.002-.100	.005-.020

## CBN STARTING PARAMETERS

<b>MATERIAL</b>	<b>SPEED SFM</b>	<b>DOC INCH</b>	<b>FEEDRATE IPR</b>
MEDIUM CARBON STEELS Rc 50-60	250-350	.005-.125	.005-.015
ALLOY STEELS Rc 50-68	230-500	.005-.125	.005-.015
TOOL STEELS	250-325	.002-.065	.005-.020
HARDENED STEELS INTERRUPTED CUT	240-400	.002-.012	.002-.008
GREY CAST IRON	1000-2700	.005-.060	.002-.015
CHILLED CAST IRON	200-350	.005-.125	.005-.015
WHITE CAST IRON	200-350	.005-.125	.005-.015
NI-HARD Rc 50-68	250-350	.005-.125	.005-.015
STAINLESS STEEL Bhn 375-440	300-500	.002-.100	.005-.012
STELLITE	230-500	.005-.060	.002-.006