

		PCD Diamond Inserts	
Picture	Style	Grade PCD13	Grade PCD15
	CCMW 21.51	60000	60004
	CCMW 21.52	60050	60054
	CCMW 32.51	60100	60104
	CCMW 32.52	60150	60154
	CDCD 51		60254
		* .060" PCD edge	
	CNGA 431	60300	60304
	CNGA 432	60450	60454
	CPMW 21.51	61200	61204
	CPMW 21.52	61250	61254
	CPMW 32.51	61300	61304
	CPMW 32.52	61350	61354
	DCMW 21.51	61400	61404
	DCMW 32.52	61450	61454
	DNGA 431	615000	61504
	DNGA 431	61650	61654
	DPMW 21.51	61950	61954
	DPMW 32.52	62150	62154
	SPG 321		63404
	SPG 322		63454
	SPG 421		63604
	SPG 422		63654
	TCMW 21.51	64000	64004
	TNG 321		64504
	TNG 322		64554
	TPG 221		65154
	TPG 222		65204
	TPG 321	65250	65254
	TPG 322	65300	65304
	TPG 431		65604
	TPG 432		65604
	TPMW 21.51		66054
	VNGA 331		66754
	BNGA 332	66900	66904

PCP Application Guidelines

PCD 13	PCD 15 / PCD 18
General purpose applications Aluminums <12% Silicon Copper Alloys	Interrupted Cuts Aluminums >12% Silicon Composite Graphite Epoxy Metal Matrix Composites

Material	Operation	Grade	Surface Speed		Feed Rate	
			mm/min.	ft./min.	mm/rpm	In./rev.
Aluminum/Aluminum Alloys ,12% Silicon	Rough Turning	13	610-1830	2000-6000	0,13-0,50	.005-.020
	Finish Turning	15 / 18			0,08-0,20	.003-.008
Aluminum/Aluminum Alloys >12% Silicon	Rough Turning	15 / 18	300-610	1000-2000	0,13-0,38	.005-.015
	Finish Turning	15 / 18	300-920	1000-3000	0,08-0,20	.003-.008
Copper/Copper Alloys/Zinc	Rough Turning	13	245-365	800-1200	0,13-0,25	.005-.010
	Finish Turning	13	300-610	1000-2000	0,10-0,41	.004-.010
Plastics/Composites	Rough Turning	15 / 18	195-795	650-2600	0,10-0,41	.004-.016
	Finish Turning	13	300-1525	1000-5000	0,10-0,41	.004-.016
Sintered Tungsten Carbide <16 Cobalt	Finish Turning	15	15-30	50-100	0,10-0,25	.004-.010