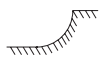
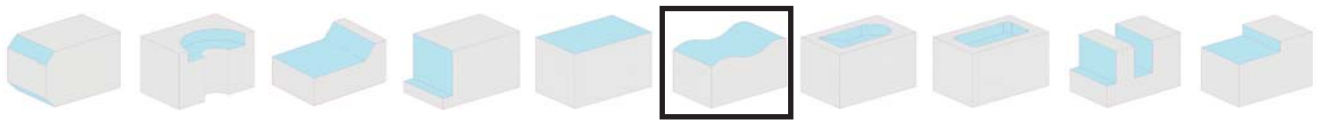


# PCD Polycrystalline Diamond Tooling

Round 



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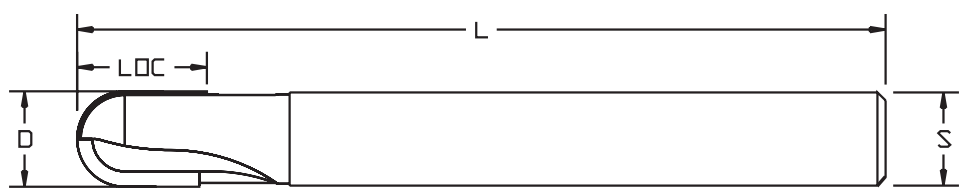
Gray Iron

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• Ball End Mills

**PCD Ball Series - Dimensional Specifications**

| Product Number      | D     | S     | LOC   | L     | Teeth |
|---------------------|-------|-------|-------|-------|-------|
| B0375-100E130-S037R | 0.375 | 0.375 | 1.000 | 4.000 | 2     |
| B0500-100E130-S050R | 0.500 | 0.500 | 1.000 | 4.000 | 2     |
| B0750-100E130-S075R | 0.750 | 0.750 | 1.000 | 4.000 | 2     |

**NOTE: Machining Parameters below are for the tooling shown on pages 4 and 5**

**PCD - Starting Parameters**

| Material                          | SFM Range     | IPR Range   | DOC Range   |
|-----------------------------------|---------------|-------------|-------------|
| Carbon                            | 750 - 2,000   | .004 - .008 | .100 >      |
| Fiberglass - Fiberglass Epoxy     | 1,500 - 3,000 | .004 - .008 | .010 >      |
| Graphite - Graphite Composite     | 1,500 - 2,000 | .004 - .008 | .010 >      |
| Phenolic Materials                | 1,500 - 3,000 | .004 - .008 | .010 >      |
| Plastic                           | 1,500 - 3,000 | .008 - .012 | .005 >      |
| Tungsten Carbide (over 6% Cobalt) | 45 - 150      | .004 - .006 | .002 - .010 |