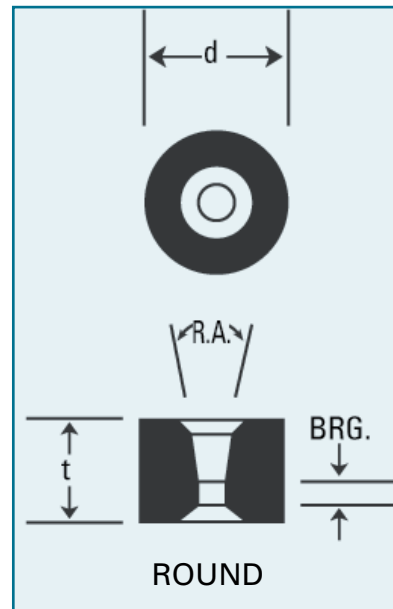


# Poly-Di® Polycrystalline Diamond Dies

INCHES / SPECIFICATIONS

## CORE DIMENSIONS

INCHES								
ADDMA NO.	MFG. NO.	GRAIN SIZE CLASS			NIB FEATURE	THERMAL STABILITY IN AIR	CORE DIM.	
		U 0-2µ	F 3-10µ	M 11-29µ			d	t
D-6	WD705	<b>F</b>	<b>M</b>	C, E	1	700°C	.098	.039
D-6	WD805	<b>F</b>	<b>M</b>	C, E	2	1000°C	.098	.039
D-12	WD710	<b>F</b>	<b>M</b>	C, E	1	700°C	.126	.059
D-12	WD810	<b>F</b>	<b>M</b>	C, E	2	1000°C	.126	.059
D-12	WD910	<b>F</b>	S, M	C, E	3	700°C	.059	.059
D-15	WD715	<b>F</b>	<b>M</b>	C, E	1	700°C	.205	.098
D-15	WD815	<b>F</b>	<b>M</b>	C, E	2	1000°C	.205	.098
D-15	WD915	<b>F</b>	S, M	C, E	3	700°C	.157	.091
D-18	WD720	<b>F</b>	<b>M</b>	C, E	1	700°C	.205	.138
D-18	WD820	<b>F</b>	<b>M</b>	C, E	2	1000°C	.205	.138
D-18	WD920	<b>F</b>	S, M	C, E	3	700°C	.157	.114
D-21	WD925	-	<b>S, M</b>	C, E	3	700°C	.276	.157
D-24	WD930	-	<b>S, M</b>	C, E	3	700°C	.276	.209
D-27	WD940	-	<b>M</b>	C, E	3	700°C	.354	.295
D-27	WD945	-	<b>M</b>	C, E	3	700°C	.512	.354
D-30	WD950	-	<b>M</b>	C, E	3	700°C	.512	.472
D-33	WD960	-	-	<b>C, E</b>	3	650°C	.630	.630
D-36	WD970	-	-	<b>E</b>	3	650°C	.748	.748
D-36	WD975	-	-	<b>E</b>	3	650°C	.984	.787
D-36	WD980	-	-	<b>E</b>	3	650°C	1.181	.866
D-36	WD990	-	-	<b>E</b>	3	650°C	1.575	.984
D-36	WD995	-	-	<b>E</b>	3	650°C	1.772	1.063



### Nib Features:

1. WD700 Series diamond core is self-supported, metal-filled and thermally stable to 700°C.
2. WD800 Series is thermally stable to 1000°C, metal-absent and is self-supported.
3. WD900 Series diamond core is round, metal-filled, has a tungsten carbide support ring and is thermally stable to 650°C or 700°C.

Product designations should include manufacturer's number and grain size, i.e., WD705F, WD915C. Readily available die blanks are shown in bold print. Please check availability of other products.

## MAXIMUM RECOMMENDED HOLE SIZE RANGE\*\*

INCHES																
ADDMA NO.	MFG. NO.	BEARING PERCENTAGE (BRG.)						REDUCTION ANGLE (R.A.)								
		8	12	10% 16	20	24	8	12	30% 16	20	24	8	12	50% 16	20	24
D-6	WD705	.016	.023	.030	.037	.043	.014	.019	.024	.028	.031	.013	.017	.020	.022	.025
D-6	WD805	.016	.023	.030	.037	.043	.014	.019	.024	.028	.031	.013	.017	.020	.022	.025
D-12	WD710	.027	.039	.051	.062	.072	.024	.033	.040	.047	.053	.021	.028	.034	.038	.042
D-12	WD810	.027	.039	.051	.062	.072	.024	.033	.040	.047	.053	.021	.028	.034	.038	.042
D-12	WD910	.027	.035	.035	.035	.035	.024	.033	.035	.035	.035	.021	.028	.034	.035	.035
D-15	WD715	.050	.073	.094	.114	.133	.044	.061	.075	.087	.098	.039	.052	.062	.070	.077
D-15	WD815	.050	.073	.094	.114	.133	.044	.061	.075	.087	.098	.039	.052	.062	.070	.077
D-15	WD915	.046	.067	.086	.105	.118	.040	.056	.069	.080	.090	.036	.048	.057	.065	.071
D-18	WD720	.070	.102	.131	.153	.153	.062	.085	.105	.122	.137	.055	.073	.087	.098	.108
D-18	WD820	.070	.102	.131	.153	.153	.062	.085	.105	.122	.137	.055	.073	.087	.098	.108
D-18	WD920	.058	.084	.109	.116	.116	.051	.070	.087	.101	.113	.046	.060	.072	.081	.089
D-21	WD925	.080	.116	.150	.183	.210	.070	.097	.119	.139	.156	.063	.083	.099	.112	.123
D-24	WD930	.106	.154	.199	.205	.205	.093	.128	.158	.184	.205	.083	.110	.131	.149	.163
D-27	WD940	.150	.218	.261	.261	.261	.132	.182	.224	.261	.261	.118	.156	.186	.210	.231
D-27	WD945	.180	.261	.338	.387	.387	.158	.218	.269	.313	.351	.141	.187	.223	.253	.277
D-30	WD950	.240	.348	.374	.374	.374	.211	.291	.358	.374	.374	.188	.249	.297	.337	.369
D-33	WD960	.329	.467	.467	.467	.467	.289	.399	.467	.467	.467	.258	.342	.408	.462	.467
D-36	WD970	.400	.566	.566	.566	.566	.352	.485	.566	.566	.566	.314	.416	.497	.562	.566
D-36	WD975	.424	.616	.765	.765	.765	.373	.514	.634	.738	.765	.333	.441	.526	.596	.653
D-36	WD980	.472	.685	.887	.930	.930	.415	.571	.705	.820	.921	.370	.490	.585	.662	.726
D-36	WD990	.543	.789	1.021	1.240	1.261	.478	.658	.811	.944	1.060	.426	.564	.673	.762	.836
D-36	WD995	.591	.858	1.110	1.348	1.426	.519	.715	.882	1.027	1.153	.463	.613	.732	.829	.909

\*\*The above chart designates the maximum recommended hole size for the various polycrystalline cores depending on a given reduction angle and bearing length.

