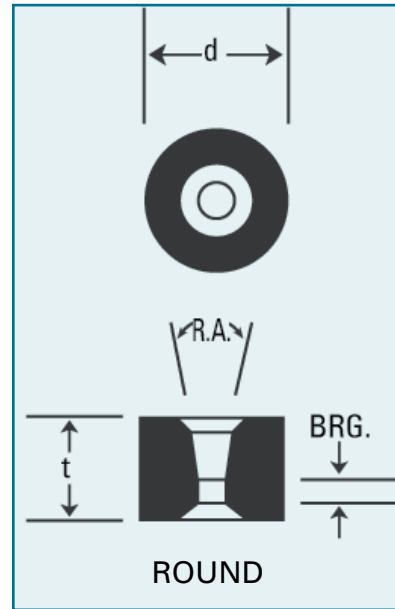


Poly-Di® Polycrystalline Diamond Dies

MILLIMETERS / SPECIFICATIONS

CORE DIMENSIONS

MILLIMETERS								
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	F	M	C, E	1	700°C	2.5	1.0
D-6	WD805	F	M	C, E	2	1000°C	2.5	1.0
D-12	WD710	F	M	C, E	1	700°C	3.2	1.5
D-12	WD810	F	M	C, E	2	1000°C	3.5	1.5
D-12	WD910	F	S, M	C, E	3	700°C	1.5	1.5
D-15	WD715	F	M	C, E	1	700°C	5.2	2.5
D-15	WD815	F	M	C, E	2	1000°C	5.2	2.5
D-15	WD915	F	S, M	C, E	3	700°C	4.0	2.3
D-18	WD720	F	M	C, E	1	700°C	5.2	3.5
D-18	WD820	F	M	C, E	2	1000°C	5.2	3.5
D-18	WD920	F	S, M	C, E	3	700°C	4.0	2.9
D-21	WD925	-	S, M	C, E	3	700°C	7.0	4.0
D-24	WD930	-	S, M	C, E	3	700°C	7.0	5.3
D-27	WD940	-	M	C, E	3	700°C	9.0	7.5
D-27	WD945	-	M	C, E	3	700°C	13.0	9.0
D-30	WD950	-	M	C, E	3	700°C	13.0	12.0
D-33	WD960	-	-	C, E	3	650°C	16.0	16.0
D-36	WD970	-	-	E	3	650°C	19.0	19.0
D-36	WD975	-	-	E	3	650°C	25.0	20.0
D-36	WD980	-	-	E	3	650°C	30.0	22.0
D-36	WD990	-	-	E	3	650°C	40.0	25.0
D-36	WD995	-	-	E	3	650°C	45.0	27.0



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**

MILLIMETERS																
ADDMA NO.	MFG. NO.	BEARING PERCENTAGE (BRG.)					BEARING PERCENTAGE (BRG.)					BEARING PERCENTAGE (BRG.)				
		REDUCTION ANGLE (R.A.)					REDUCTION ANGLE (R.A.)					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	0.41	0.59	0.76	0.93	1.08	0.36	0.49	0.61	0.71	0.79	0.32	0.42	0.50	0.57	0.63
D-6	WD805	0.41	0.59	0.76	0.93	1.08	0.36	0.49	0.61	0.71	0.79	0.32	0.42	0.50	0.57	0.63
D-12	WD710	0.69	1.00	1.29	1.56	1.83	0.60	0.83	1.02	1.19	1.34	0.54	0.71	0.85	0.96	1.06
D-12	WD810	0.69	1.00	1.29	1.56	1.83	0.60	0.83	1.02	1.19	1.34	0.54	0.71	0.85	0.96	1.06
D-12	WD910	0.69	0.89	0.89	0.89	0.89	0.60	0.83	0.89	0.89	0.89	0.54	0.71	0.85	0.89	0.89
D-15	WD715	1.27	1.84	2.38	2.90	3.38	1.12	1.54	1.90	2.21	2.48	1.00	1.32	1.57	1.78	1.95
D-15	WD815	1.27	1.84	2.38	2.90	3.38	1.12	1.54	1.90	2.21	2.48	1.00	1.32	1.57	1.78	1.95
D-15	WD915	1.17	1.70	2.19	2.67	3.00	1.03	1.41	1.74	2.03	2.28	0.92	1.21	1.45	1.64	1.80
D-18	WD720	1.78	2.58	3.34	3.88	3.88	1.56	2.15	2.65	3.09	3.47	1.39	1.85	2.20	2.49	2.74
D-18	WD820	1.78	2.58	3.34	3.88	3.88	1.56	2.15	2.65	3.09	3.47	1.39	1.85	2.20	2.49	2.74
D-18	WD920	1.47	2.14	2.77	2.94	2.94	1.29	1.78	2.20	2.56	2.87	1.15	1.53	1.83	2.07	2.27
D-21	WD925	2.03	2.95	3.82	4.63	5.34	1.79	2.46	3.03	3.53	3.96	1.59	2.11	2.52	2.85	3.13
D-24	WD930	2.69	3.91	5.06	5.19	5.19	2.37	3.26	4.02	4.68	5.19	2.11	2.79	3.34	3.78	4.14
D-27	WD940	3.81	5.53	6.63	6.63	6.63	3.35	4.61	5.69	6.62	6.63	2.99	3.95	4.72	5.34	5.86
D-27	WD945	4.57	6.64	8.58	9.83	9.83	4.02	5.53	6.83	7.94	8.92	3.58	4.74	5.66	6.41	7.03
D-30	WD950	6.09	8.85	9.50	9.50	9.50	5.36	7.38	9.10	9.50	9.50	4.78	6.33	7.55	8.55	9.38
D-33	WD960	8.36	11.86	11.86	11.86	11.86	7.35	10.13	11.86	11.86	11.86	6.56	8.68	10.37	11.74	11.86
D-36	WD970	10.17	14.38	14.38	14.38	14.38	8.94	12.32	14.38	14.38	14.38	7.98	10.57	12.61	14.28	14.38
D-36	WD975	10.77	15.65	19.42	19.42	19.42	9.47	13.05	16.10	18.73	19.42	8.45	11.19	13.36	15.13	16.59
D-36	WD980	11.98	17.41	22.52	23.62	23.62	10.54	14.51	17.90	20.83	23.39	9.40	12.45	14.86	16.82	18.45
D-36	WD990	13.79	20.04	25.92	31.49	32.03	12.13	16.71	20.61	23.98	26.93	10.82	14.33	17.10	19.36	21.24
D-36	WD995	15.00	21.79	28.19	34.24	36.23	13.19	18.17	22.41	26.08	29.28	11.77	15.58	18.60	21.06	23.10

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



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