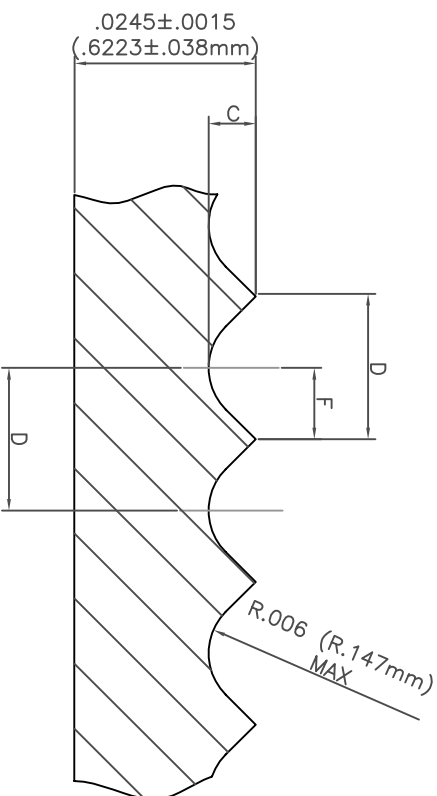
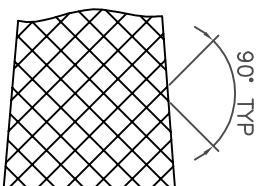
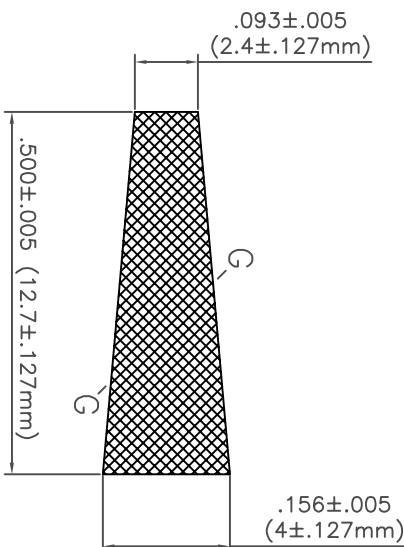


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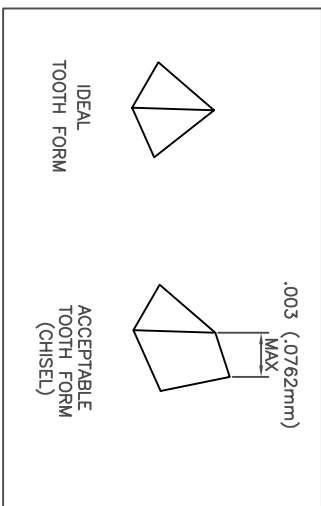
OPERATION DESCRIPTION:  
CUT-OFF TO INDIVIDUAL PCS

OP-600



SECTION G-G ROTATION 45°

PART NUMBER	MATERIAL	TEETH (PER SQUARE INCH)	DIMENSIONS (INCH & MM)		
			C $\pm .0015"$ ( $\pm .038$ mm)	D $\pm .001"$ ( $\pm .025$ mm)	F $\pm .001"$ ( $\pm .025$ mm)
156-C-00000-024	VC 011	0 (SMOOTH)	0	0	0
156-N-00000-024	VC 320	0 (SMOOTH)	0	0	0
156-C-02500-024	VC 011	2,500	.0097" (.246mm)	.020" (.508mm)	.010" (.254mm)
156-N-02500-024	VC 320	2,500	.0097" (.246mm)	.020" (.508mm)	.010" (.254mm)
156-C-03600-024	VC 011	3,600	.0093" (.236mm)	.0167" (.424mm)	.008" (.212mm)
156-N-03600-024	VC 320	3,600	.0093" (.236mm)	.0167" (.424mm)	.008" (.212mm)
156-C-07000-024	VC 011	7,000	.0090" (.229mm)	.0119" (.302mm)	.0059" (.151mm)
156-N-07000-024	VC 320	7,000	.0090" (.229mm)	.0119" (.302mm)	.0059" (.151mm)
156-C-10000-024	VC 011	10,000	.0041" (.104mm)	.0100" (.254mm)	.005" (.127mm)
156-N-10000-024	VC 320	10,000	.0041" (.104mm)	.0100" (.254mm)	.005" (.127mm)
156-C-14400-024	VC 011	14,400	.0036" (.091mm)	.0083" (.211mm)	.0042" (.106mm)
156-N-14400-024	VC 320	14,400	.0036" (.091mm)	.0083" (.211mm)	.0042" (.106mm)



MATERIAL	COMPOSITION
VC 011	COBALT TANTALUM CARBIDE TUNGSTEN CARBIDE BALANCE
VC 320	NICKEL TUNGSTEN CARBIDE BALANCE

UNLESS OTHERWISE NOTED:

.XX = ±.010  
.XXX = ±.005  
.XXXX = ±.0002  
ANGLES ±1°  
INTERNAL R<sub>a</sub> = .035max  
BREAK EDGES .030min  
SURFACE FINISH 64 U.O.S.

CUSTOMER: CARBIDE

P/N

AutoCad

SCALE: N.T.S.

PART NAME:

CARBIDE INSERT

Drawn by:

DATE: 4/7/99

ABRASIVE WEST LLC  
1292 HUMBRACHT CIRCLE, UNIT F, BARTLETT, IL 60103  
(630)-736-0818  
FAX(630)-736-0883

ACAD DWG #  
RLC

REV

CHANGE

DATE

BY

OP-600-156-024