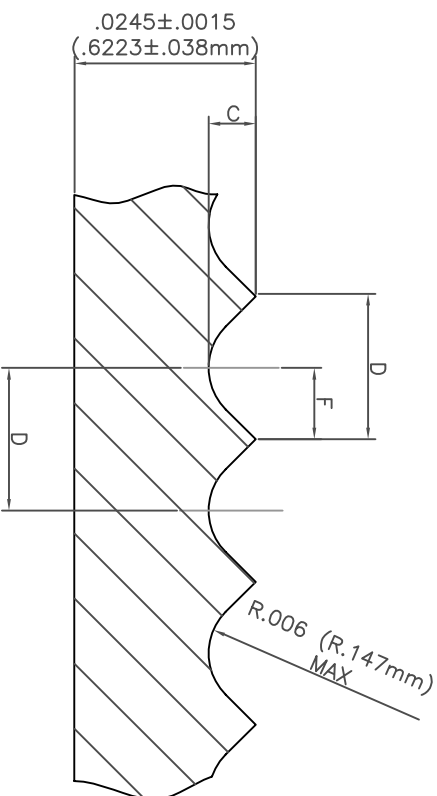
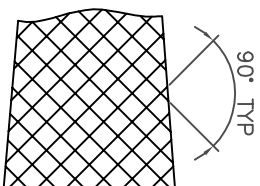
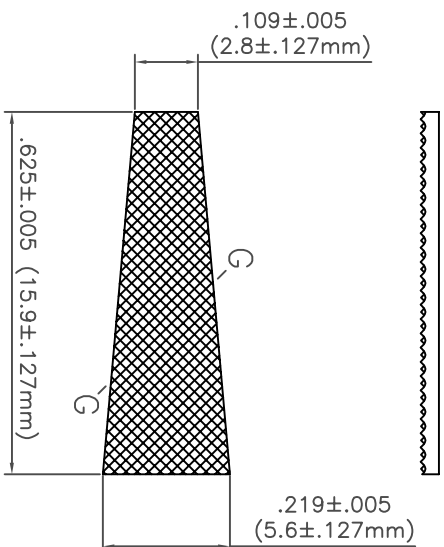


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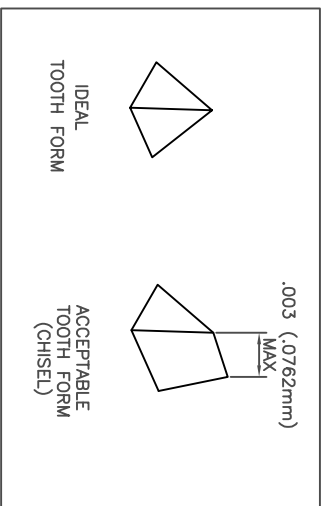
OPERATION DESCRIPTION:  
CUT-OFF TO INDIVIDUAL PCS

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)
219-C-00000-024	VC 011	0 (SMOOTH)	0	0	0
219-N-00000-024	VC 320	0 (SMOOTH)	0	0	0
219-C-02500-024	VC 011	2,500	.0097" (.246mm)	.020" (.508mm)	.010" (.254mm)
219-N-02500-024	VC 320	2,500	.0097" (.246mm)	.020" (.508mm)	.010" (.254mm)
219-C-03600-024	VC 011	3,600	.0093" (.236mm)	.0167" (.424mm)	.008" (.212mm)
219-N-03600-024	VC 320	3,600	.0093" (.236mm)	.0167" (.424mm)	.008" (.212mm)
219-C-07000-024	VC 011	7,000	.0090" (.229mm)	.0119" (.302mm)	.0059" (.151mm)
219-N-07000-024	VC 320	7,000	.0090" (.229mm)	.0119" (.302mm)	.0059" (.151mm)
219-C-10000-024	VC 011	10,000	.0041" (.104mm)	.0100" (.254mm)	.005" (.127mm)
219-N-10000-024	VC 320	10,000	.0041" (.104mm)	.0100" (.254mm)	.005" (.127mm)
219-C-14400-024	VC 011	14,400	.0036" (.091mm)	.0083" (.211mm)	.0042" (.106mm)
219-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 =  $\pm .010$   
 .XXX =  $\pm .005$   
 .XXXX =  $\pm .0002$   
 ANGLES  $\pm 1'$   
 INTERNAL  $R_s = .035$ max  
 BREAK EDGES  $.030$ min  
 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-600-219-024