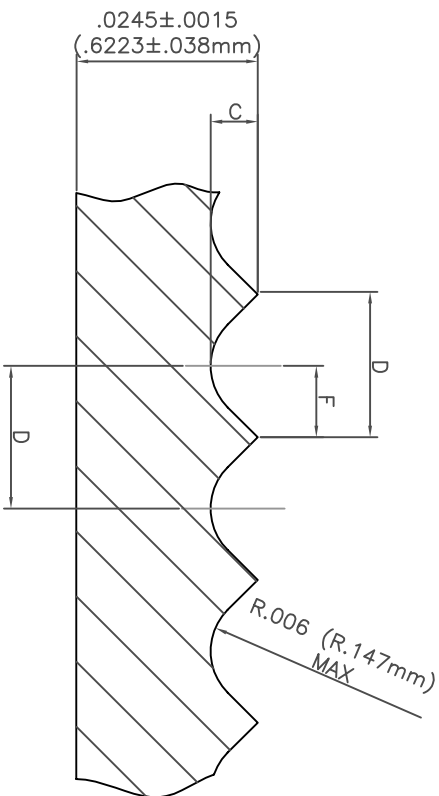
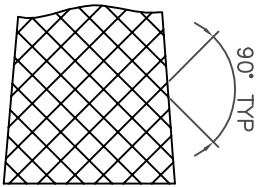
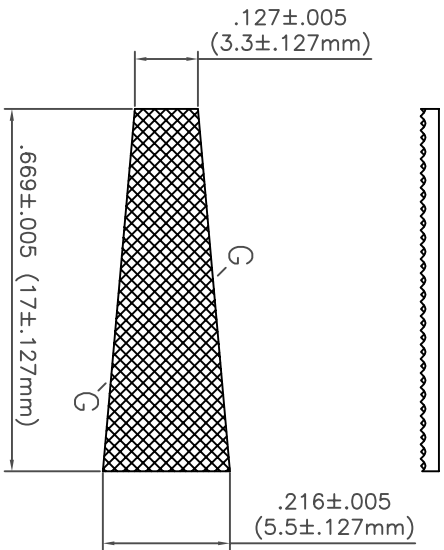


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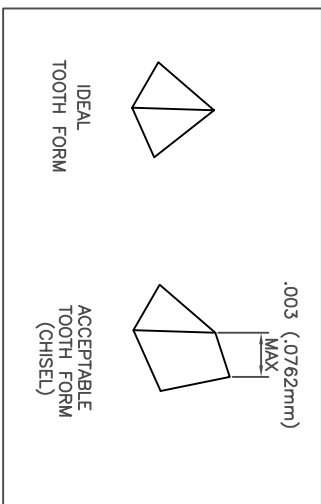
OPERATION DESCRIPTION:
CUT-OFF TO INDIVIDUAL PCS

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)
669-C-00000-024	VC 011	0 (SMOOTH)	0	0	0
669-N-00000-024	VC 320	0 (SMOOTH)	0	0	0
669-C-02500-024	VC 011	2,500	.0097" (.246mm)	.020" (.508mm)	.010" (.254mm)
669-N-02500-024	VC 320	2,500	.0097" (.246mm)	.020" (.508mm)	.010" (.254mm)
669-C-03600-024	VC 011	3,600	.0093" (.236mm)	.0167" (.424mm)	.008" (.212mm)
669-N-03600-024	VC 320	3,600	.0093" (.236mm)	.0167" (.424mm)	.008" (.212mm)
669-C-07000-024	VC 011	7,000	.0090" (.229mm)	.0119" (.302mm)	.0059" (.151mm)
669-N-07000-024	VC 320	7,000	.0090" (.229mm)	.0119" (.302mm)	.0059" (.151mm)
669-C-10000-024	VC 011	10,000	.0041" (.104mm)	.0100" (.254mm)	.005" (.127mm)
669-N-10000-024	VC 320	10,000	.0041" (.104mm)	.0100" (.254mm)	.005" (.127mm)
669-C-14400-024	VC 011	14,400	.0036" (.091mm)	.0083" (.211mm)	.0042" (.106mm)
669-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 .030min
 SURFACE FINISH 64 U.O.S.

CUSTOMER: CARBIDE

P/N

AutoCad

SCALE: N.T.S.

PART NAME:

CARBIDE INSERT

Drawn by:

RLC

DATE: 4/7/99



ABRASIVE WEST LLC
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 (630)-736-0818 FAX(630)-736-0883

ACAD DWG #
 OP-600-669-024

REV	CHANGE	DATE	BY
1	-	-	-