

55° INSERT TOOLS

		Base Identification Standard - DCGW070202 Large - DCMW11T304		Mounting Screw Metric 2.5 x 6 / T08 (T08 is a torx driver) Torque Specification 6 Lb/inch		
		Turning	Sharp Point Vee	Flycutting	Boring	Form Tools
Diamond Types	CVD Pure Diamond (Poly-crystal)	Yes	Yes	Yes	Yes	Yes
	E-diamond synthetic (Dodec 110 orientation)	Yes	Yes	Yes	Yes	No
	MCC synthetic (Dodec 110 orientation)	Yes	Yes	Yes	Yes	No
	Mono-Die synthetic (Dodec 110 orientation)	Yes	Yes	Yes	Yes	No
	Natural (Dodec 110 orientation)	Yes	Yes	Yes	Yes	No
	Sumitomo synthetic (Cubic 100 orientation)	Yes	Yes	Yes	Yes	No
Minimum Radius		1.0 micron*	NA	1.0 mm	< 0.1 mm	60 micron
Maximum Radius		2.0 mm	NA	100 mm	> 100 mm	> 100 mm
Arc		1° to 125°	NA	Diamond dependent	> 100°	> 180°
Included Angle (Top Angle)		55° to 179°	55° to 179°	NA	55° to 90°	55° to 179°
Rake Angle		+2.5° to -35°	+2.5° to -35°	+2.5° to -35°	+2.5° to -35°	0°
Front Clearance Angle		5° to 40°	5° to 50°	5° std	5° std	15°
Cutting Edge Waviness		2.0µm to <50nm	NA	2.0µm	2.0µm	1.0µm

* CVD Diamond minimum radius dependent on included angle