

## 35° INSERT TOOLS

		Base Identification VCGW 110302 VCGW 070201 for ultrasonic		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
<b>Diamond Types</b>	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
<b>Minimum Radius</b>		1.0 micron*	NA	1.0 mm	< 0.1 mm	60 micron
<b>Maximum Radius</b>		2.0 mm	30µm facet	> 100 mm	> 100 mm	> 100 mm
<b>Arc</b>		1° to 145°	NA	Diamond dependent	> 100°	> 180°
<b>Included Angle (Top Angle)</b>		35° to 179°	35° to >90°	NA	30° to 90°	30° to 179°
<b>Rake Angle</b>		+2.5° to -35°	+2.5° to -35°	+2.5° to -35°	+2.5° to -35°	0°
<b>Front Clearance Angle</b>		0° to 40°	0° to 45°	5° std	5° std	15°
<b>Cutting Edge Waviness</b>		2.0µm to <50nm	NA	2.0µm	2.0µm	1.0µm
Base Material - Tungsten		Yes	Yes	Yes	Yes	Yes
Other inserts provided upon request						

\* CVD Diamond minimum radius dependent on included angle