

35° INSERT TOOLS		Base Identification		Mounting Screw		
		VCGW 110302 VCGW 070201 for ultrasonic		Metric 2.5 x 6 / T08 (T08 is a torx driver)  Torque Specification 6 Lb/inch		
		TURNING	SHARP POINT VEE	FLYCUTTING MILLING	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	30µm facet	> 100 mm	> 100 mm	> 100 mm
Arc		1° to 145°	NA	Diamond Dependent	> 100°	> 180°
Included Angle (Top Angle)		35° to 179°	35° to >90°	NA	35° to 90°	35° to 179°
Rank Angle		+2.5° to -35°	+2.5° to -35°	+2.5° to -35°	+2.5° to -35°	0°
Front Clearance Angle		0° to 40°	0° to 45°	5° std	5° std	15°
Cutting Edge Waviness		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

Other rake angles upon request