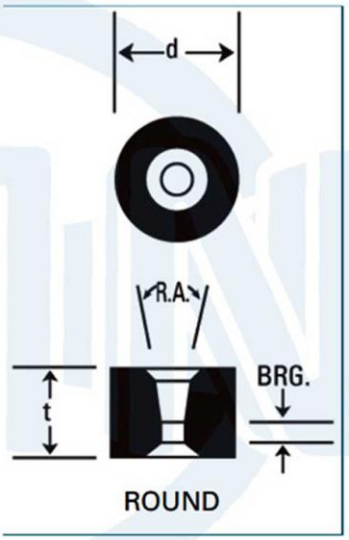
Technical support

Core Dimensions

INCHES / SPECIFICATIONS

INCHES

ADDMA NO.	MFG. NO.	GRAIN SIZE CLASS	NIB FEATURE	THERMAL STABILITY IN AIR	CORE DIM. d	t
D-6	5010	U, F, M	1	1200°C	.122	.039
D-12	5015	U, F, M	1	1200°C	.122	.059
D-12	5235	M	2	700°C	.055	.059
D-15	5823	F	2	700°C	.150	.088
D-15	5025	F, M	1	1200°C	.205	.098
D-15	5223	M	2	700°C	.150	.088
D-15	5430	C	2	700°C	.150	.088
D-18	5829	F	2	700°C	.150	.112
D-18	5035	F, M	1	1200°C	.205	.138
D-18	5229	M	2	700°C	.150	.112
D-18	5435	C	2	700°C	.150	.112
D-21	5840	F	2	700°C	.268	.152
D-21	5240	M	2	700°C	.268	.152
D-21	5530	C	2	700°C	.268	.152
D-24	5853	F	2	700°C	.268	.202
D-24	5253	M	2	700°C	.268	.202
D-24	5225	M	2	700°C	.500	.275
D-24	5535	C	2	700°C	.268	.202
D-24	5725	C	2	700°C	.500	.275
D-27	5208	M	2	700°C	.500	.343
D-27	5730	C	2	700°C	.500	.343
D-30	5211	M	2	700°C	.500	.457
D-30	5735	C	2	700°C	.500	.457
D-30	5913	M	2	700°C	.717	.531
D-33	5915	M	2	700°C	.717	.610
D-33	5917	M	2	700°C	.717	.689
D-36	5918	M	2	700°C	.717	.728



Average Grain Size Designation
U=Ultra Fine (0-2μ)
F=Fine (3-10μ)
M=Medium (11-29μ)
C=Coarse (30μ & larger)

Nib features:
1. Core is round, self-supported, metal-absent and thermally stable to 1200°C.
2. Diamond core is round, metal-filled, has a tungsten carbide support ring and is thermally stable to 700°C.

Maximum Recommended Hole Size Range**

INCHES

BEARING PERCENTAGE (BRG.) / REDUCTION ANGLE (R.A.)		10% 8	12	16	20	24	30% 8	12	16	20	24	50% 8	12	16	20	24
D-6	5010	.016	.023	.030	.037	.043	.014	.019	.024	.028	.031	.013	.017	.020	.022	.025
D-12	5015	.027	.039	.051	.062	.072	.024	.033	.040	.047	.053	.021	.028	.034	.038	.042
D-12	5235	.027	.032	.032	.032	.032	.024	.032	.032	.032	.032	.021	.028	.032	.032	.032
D-15	5823	.045	.065	.084	.102	.112	.039	.054	.067	.078	.087	.035	.047	.056	.063	.069
D-15	5025	.050	.073	.094	.114	.133	.044	.061	.075	.087	.098	.039	.052	.062	.070	.077
D-15	5223	.045	.065	.084	.102	.112	.039	.054	.067	.078	.087	.035	.047	.056	.063	.069
D-15	5430	.045	.065	.084	.102	.112	.039	.054	.067	.078	.087	.035	.047	.056	.063	.069
D-18	5829	.057	.082	.107	.109	.109	.050	.069	.085	.099	.109	.045	.059	.070	.080	.087
D-18	5035	.070	.102	.131	.153	.153	.062	.085	.105	.122	.137	.055	.073	.087	.098	.108
D-18	5229	.057	.082	.107	.109	.109	.050	.069	.085	.099	.109	.045	.059	.070	.080	.087
D-18	5435	.057	.082	.107	.109	.109	.050	.069	.085	.099	.109	.045	.059	.070	.080	.087
D-21	5840	.077	.112	.145	.176	.204	.068	.093	.115	.134	.151	.061	.080	.096	.108	.119
D-21	5240	.077	.112	.145	.176	.204	.068	.093	.115	.134	.151	.061	.080	.096	.108	.119
D-21	5530	.077	.112	.145	.176	.204	.068	.093	.115	.134	.151	.061	.080	.096	.108	.119
D-24	5853	.103	.149	.193	.199	.199	.090	.124	.153	.178	.199	.080	.107	.127	.144	.158
D-24	5253	.103	.149	.193	.199	.199	.090	.124	.153	.178	.199	.080	.107	.127	.144	.158
D-24	5225	.140	.203	.262	.318	.372	.123	.169	.208	.243	.272	.109	.145	.173	.196	.215
D-24	5535	.103	.149	.193	.199	.199	.090	.124	.153	.178	.199	.080	.107	.127	.144	.158
D-24	5725	.140	.203	.262	.318	.372	.123	.169	.208	.243	.272	.109	.145	.173	.196	.215
D-27	5208	.174	.253	.327	.378	.378	.153	.211	.260	.302	.339	.136	.181	.216	.244	.268
D-27	5730	.174	.253	.327	.378	.378	.153	.211	.260	.302	.339	.136	.181	.216	.244	.268
D-30	5211	.232	.337	.366	.366	.366	.204	.281	.346	.366	.366	.182	.241	.287	.325	.357
D-30	5735	.232	.337	.366	.366	.366	.204	.281	.346	.366	.366	.182	.241	.287	.325	.357
D-30	5913	.270	.392	.507	.540	.540	.237	.327	.403	.469	.527	.212	.280	.335	.379	.415
D-33	5915	.317	.461	.540	.540	.540	.279	.384	.474	.540	.540	.249	.330	.393	.445	.489
D-33	5917	.365	.530	.540	.540	.540	.321	.442	.540	.540	.540	.286	.379	.452	.512	.540
D-36	5918	.389	.540	.540	.540	.540	.342	.471	.540	.540	.540	.305	.404	.482	.540	.540

**The above chart designates the maximum recommended hole size for the various polycrystalline cores assuming a given reduction angle, bearing length and 20.7% area of reduction.