SUMIDIA®

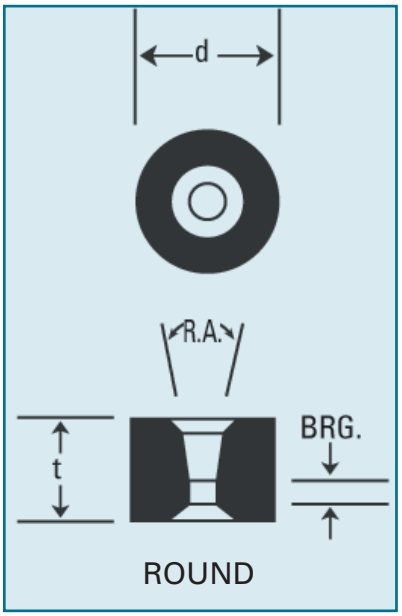
Poly-Di® Polycrystalline Diamond Dies

INCHES / SPECIFICATIONS

Core Dimensions

INCHES

ADDMA NO.	MFG. NO.	GRAIN SIZE CLASS U 0–2µ	F 3–10µ	M 11–29µ	NIB FEATURE	THERMAL STABILITY IN AIR	CORE DIM. d	t
D-6	WD705	**F**	**M**	**C**, E	1	700°C	.098	.039
D-6	WD805	**F**	**M**	C, E	2	1000°C	.098	.039
D-12	WD710	**F**	**M**	C, E	1	700°C	.126	.059
D-12	WD810	**F**	**M**	**C**, E	2	1000°C	.126	.059
D-12	WD910	**F**	S, M	C, E	3	700°C	.059	.059
D-15	WD715	**F**	**M**	C, E	1	700°C	.205	.098
D-15	WD815	**F**	**M**	**C**, E	2	1000°C	.205	.098
D-15	WD915	**F**	S, M	C, E	3	700°C	.157	.091
D-18	WD720	**F**	**M**	C, E	1	700°C	.205	.138
D-18	WD820	**F**	**M**	**C**, E	2	1000°C	.205	.138
D-18	WD920	**F**	S, M	C, E	3	700°C	.157	.114
D-21	WD925	-	S, **M**	**C**, E	3	700°C	.276	.157
D-24	WD930	-	S, **M**	**C**, E	3	700°C	.276	.209
D-27	WD940	-	**M**	**C**, E	3	700°C	.343	.295
D-27	WD945	-	**M**	C, E	3	700°C	.512	.354
D-30	WD950	-	**M**	**C**, E	3	700°C	.512	.472
D-33	WD960	-	-	**C**, **E**	3	650°C	.630	.630
D-36	WD970	-	-	**E**	3	650°C	.748	.748
D-36	WD975	-	-	**E**	3	650°C	.984	.787
D-36	WD980	-	-	**E**	3	650°C	1.181	.866
D-36	WD990	-	-	**E**	3	650°C	1.575	.984
D-36	WD995	-	-	**E**	3	650°C	1.772	1.063



Nib Features:

1. WD700 Series diamond core is self-supported, metal-filled and thermally stable to 700°C.
2. WD800 Series is thermally stable to 1000°C, metal-absent and is self-supported.
3. WD900 Series diamond core is round, metal-filled, has a tungsten carbide support ring and is thermally stable to 650°C or 700°C.

Product designations should include manufacturer's number and grain size, i.e., WD705F, WD915C. Readily available die blanks are shown in bold print. Please check availability of other products.

Maximum Recommended Hole Size Range**

INCHES

BEARING PERCENTAGE (BRG.) REDUCTION ANGLE (R.A.)		10% 8	10% 12	10% 16	10% 20	10% 24	30% 8	30% 12	30% 16	30% 20	30% 24	50% 8	50% 12	50% 16	50% 20	50% 24
D-6	WD705	.018	.026	.033	.040	.047	.016	.021	.026	.031	.034	.014	.018	.022	.025	.027
D-6	WD805	.018	.026	.033	.040	.047	.016	.021	.026	.031	.034	.014	.018	.022	.025	.027
D-12	WD710	.029	.042	.054	.066	.077	.025	.035	.043	.050	.056	.023	.030	.036	.040	.044
D-12	WD810	.029	.042	.054	.066	.077	.025	.035	.043	.050	.056	.023	.030	.036	.040	.044
D-12	WD910	.028	.035	.035	.035	.035	.025	.034	.035	.035	.035	.022	.029	.035	.035	.035
D-15	WD715	.052	.076	.098	.119	.139	.046	.063	.078	.090	.101	.041	.054	.064	.073	.080
D-15	WD815	.052	.076	.098	.119	.139	.046	.063	.078	.090	.101	.041	.054	.064	.073	.080
D-15	WD915	.047	.068	.088	.107	.118	.041	.057	.070	.082	.092	.037	.049	.058	.066	.072
D-18	WD720	.072	.105	.135	.152	.152	.063	.087	.108	.125	.140	.056	.075	.089	.101	.111
D-18	WD820	.072	.105	.135	.152	.152	.063	.087	.108	.125	.140	.056	.075	.089	.101	.111
D-18	WD920	.059	.086	.111	.115	.115	.052	.071	.088	.103	.115	.046	.061	.073	.083	.091
D-21	WD925	.081	.118	.152	.185	.210	.071	.098	.121	.141	.158	.064	.084	.100	.114	.125
D-24	WD930	.107	.155	.201	.204	.204	.094	.130	.160	.186	.204	.084	.111	.133	.150	.165
D-27	WD940	.151	.219	.261	.261	.261	.133	.183	.225	.261	.261	.118	.157	.187	.212	.232
D-27	WD945	.185	.269	.347	.386	.386	.163	.224	.276	.321	.361	.145	.192	.229	.260	.285
D-30	WD950	.245	.356	.373	.373	.373	.215	.297	.366	.373	.373	.192	.254	.304	.344	.373
D-33	WD960	.335	.467	.467	.467	.467	.295	.406	.467	.467	.467	.263	.348	.416	.467	.467
D-36	WD970	.412	.566	.566	.566	.566	.363	.500	.566	.566	.566	.324	.428	.511	.566	.566
D-36	WD975	.436	.634	.765	.765	.765	.383	.528	.652	.758	.765	.342	.453	.541	.612	.672
D-36	WD980	.484	.703	.909	.930	.930	.425	.586	.723	.841	.930	.380	.502	.600	.679	.745
D-36	WD990	.567	.823	1.065	1.261	1.261	.498	.687	.847	.985	1.107	.445	.589	.703	.796	.873
D-36	WD995	.614	.892	1.155	1.403	1.426	.540	.744	.918	1.068	1.199	.482	.638	.762	.862	.946

**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.

Fort Wayne Wire Die

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