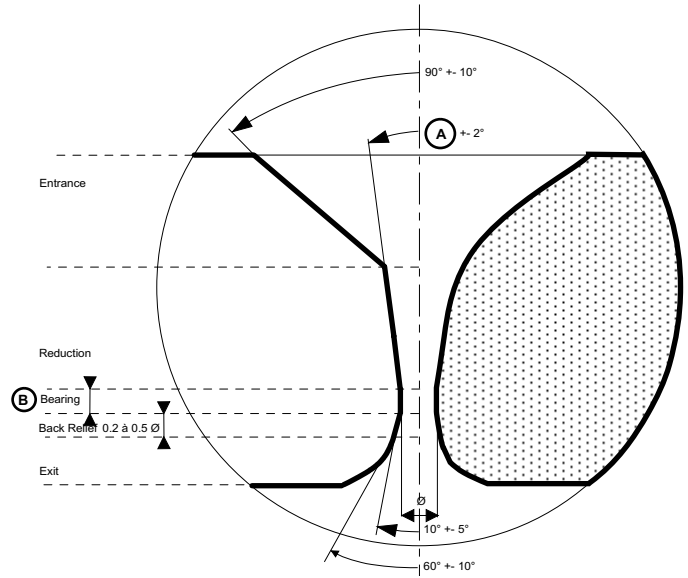
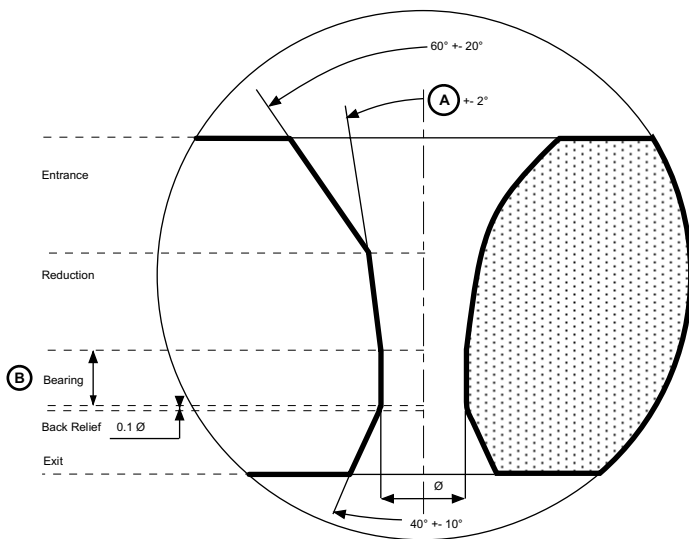


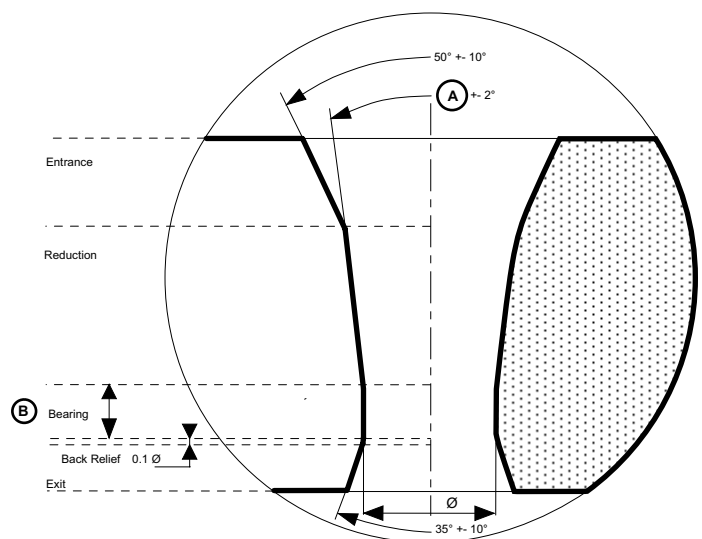
NSCD or SSCD dies up to 50 μ



NSCD or SSCD dies 50 μ to 100 μ



NSCD or SSCD dies over 100 μ



PCD dies

Typical Profile	Entrance (angle)	Approach (angle)	Reduction A (angle)		Bearing B (length)		Back Relief (depth)	Back Relief (angle)	Exit (angle)
			Soft Material	Hard material	Soft Material	Hard material			
up to 50 μ	$90^\circ \pm 10^\circ$	$30^\circ \pm 10^\circ$	18°	14°	$0.2-0.5 \text{ } \varnothing$	$0.5-0.8 \text{ } \varnothing$	$0.1 \text{ } \varnothing \text{ min.}$	$10^\circ \pm 5^\circ$	----
50 μ to 100 μ	$90^\circ \pm 10^\circ$	----	18°	14°	$0.2-0.5 \text{ } \varnothing$	$0.4-0.6 \text{ } \varnothing$	$0.2-0.5 \text{ } \varnothing$	$10^\circ \pm 5^\circ$	$60^\circ \pm 10^\circ$
over 100 μ	$60^\circ \pm 20^\circ$	----	18°	14°	$0.3-0.5 \text{ } \varnothing$	$0.4-0.6 \text{ } \varnothing$	$0.1 \text{ } \varnothing \text{ min.}$	blended	$40^\circ \pm 10^\circ$
P.C.D	$50^\circ \pm 10^\circ$	----	18°	14°	$0.2-0.4 \text{ } \varnothing$	$0.3-0.5 \text{ } \varnothing$	$0.1 \text{ } \varnothing \text{ min.}$	blended	$35^\circ \pm 10^\circ$