







# 55° Diamond

Positive Insert with Hole

Part Number	A	T	Ød	(in)	α
DCMW 215_	1/4	3/32	0.110		7°
325_	3/8	5/32	0.177		

Edge Prep.				Gray Cast Iron (with Scale)														Toolholder Page					
Symbol	Cutting Edge Spec.	Example		Nodular Cast Iron (without Scale)																			
F	Sharp Edge			Nodular Cast Iron (with Scale)																			
E	Rounded Cutting Edge (Hone)	E003	R0.003" Honed	Hard Materials (Roughing)																			
T	Chamfered Cutting Edge	T00315	0.003" X 15° Chamfered Cutting Edge	Hard Materials (Finishing)																			
S	Chamfered and Honed Cutting Edge	S00525	0.005" X 25° Chamfered and Honed Cutting Edge	Hard Materials (Chip Control)																			
				Powdered Steel																			
Insert			ANSI Part Number	Edge Prep (in)	ISO Part Number	Dimensions (in)		No. of Edges	MEGACOAT CBN								CBN						
						rε	S		KBN05M	KBN10M	KBN25M	KBN30M	KBN35M	KBN60M	KBN65M	KBN70M	KBN510	KBN525	KBN475	KBN65B	KBN570		
 Multi-Edge Sharp Edge			DCMW 3251MEF	F	DCMW 11T304MEF	0.008	0.075	2															
					3252MEF	11T308MEF	1/64		0.067														
 Multi-Edge			DCMW 21505T00315ME	T00315	DCMW 070202T00815ME	0.008	0.075	2	○	○	○		○	●			●	●	●				
			2151T00315ME		070204T00815ME	1/64	0.067		●	○	●		●	●		●	●	●					
			2152T00315ME		070208T00815ME	1/32	0.075		○	○	●		●	●		●	●						
			DCMW 32505T00315ME	T00315	DCMW 11T302T00815ME	0.008	0.075	2	○	○	○		●	●		●	●		●	●	●		
			3251T00315ME		11T304T00815ME	1/64	0.067		○	○	○		●	●	○	●	●	●	●	●			
3252T00315ME	11T308T00815ME	1/32	0.075		○	○	○			●	●	○	●	●	●	●	●	●					
3253T00315ME	11T312T00815ME	3/64	0.075		○	○	○			●	●		○	○									
 Multi-Edge General Purpose			DCMW 32505S00525MES	S00525	DCMW 11T302S01225MES	0.008	0.075	2	●														
			3251S00525MES		11T304S01225MES	1/64	0.067		●											●			
			3252S00525MES		11T308S01225MES	1/32	0.075		●												●		
 Multi-Edge Tough			DCMW 21505S00435MET	S00435	DCMW 070202S01035MET	0.008	0.075	2		○	○		○										
			2151S00435MET		070204S01035MET	1/64	0.067			○	●		●										
			2152S00435MET		070208S01035MET	1/32	0.075			○	○		●										
			DCMW 32505S00435MET	S00435	DCMW 11T302S01035MET	0.008	0.075	2	●	○	○		●					●					
			3251S00435MET		11T304S01035MET	1/64	0.067		●	○	●		●					●					
3252S00435MET	11T308S01035MET	1/32	0.075			○	●			●					●								
3253S00435MET	11T312S01035MET	3/64	0.075			○	○			●													
 Small Edge			DCMW 21505T00315SE	T00315	DCMW 070202T00815SE	0.008	0.075	1		○	○					●	○						
			2151T00315SE		070204T00815SE	1/64	0.067			○	○					●	○						
			DCMW 32505T00315SE	T00315	DCMW 11T302T00815SE	0.008	0.075	1									○	○					
			3251T00315SE		11T304T00815SE	1/64	0.067									●	●						
 Small Edge Tough			DCMW 2151S00435SET	S00435	DCMW 070204S01035SET	1/64	0.067	1								○							
			DCMW 32505S00435SET	S00435	DCMW 11T302S01035SET	0.008	0.075	1									○						
			3251S00435SET		11T304S01035SET	1/64	0.067									●	●						
			3252S00435SET		11T308S01035SET	1/32	0.075									●							

Reference Table Below