

DRILLED- END CONVENTIONAL CUTTING NEEDLES

EXAMPLE OF NEEDLE CODE

DC135 28 100 40 AS

1 SHAPE

- D - 3/8 Circle
- F - 5/8 Circle
- H - 1/2 Circle
- K - Half curved
- X - Compound curve

2 POINT

- C - Conventional cutting edge

3 ANGLE OF CURVATURE

- 130° - (3/8 Circle)
- 135° - (3/8 Circle)
- 160° - (1/2 Circle)
- 165° - (1/2 Circle)
- 170° - (1/2 Circle)
- 175° - (1/2 Circle)
- 180° - (1/2 Circle)
- 225° - (5/8 Circle)

4 LENGTH

Length of needle (in mm)

10	42
12	45
13	48
15	49
18	50
20	52
22	55
24	58
25	59
26	60
28	63
30	65
35	70
36	80
38	90
40	

5 WIRE SIZE

Wire dia. of needle in hundredths of mm.

28	74
30	81
33	84
38	86
40	88
43	92
46	100
48	108
51	112
56	120
58	127
61	130
66	140
71	157

8 SILICONISED

S - Siliconised

6 HOLE SIZE

Diameter of drilled hole in hundredths of mm.

12	47
14	48
15	49
16	51
17	53
19	55
20	56
21	59
23	61
25	63
27	65
28	69
30	70
32	73
33	79
36	84
40	85
42	90
43	93
44	103
46	105

7 GRADE OF STEEL

- A - AISI 420
- B - Custom 455(max. wire dia. 1.27mm)
- C - 1RK 91(max. wire dia. 1.14mm)
- D - AISI 302
- F - Custom 470(max. wire dia. 1.12mm)