FORM & SHAVE

Contact Somma Engineering Department for Inserts
Custom Designed & Manufactured based on your part print
or
Purchase the Resharpenable and Throwaway RQC Insert Blanks
Listed Below

RESHARPENABLE EDM READY BLANKS FOR THOSE WITH EDM FACILITIES

Resharpenable Insert

Spacer

- Inserts can be resharpened by grinding material from top surface and reused without resetting.
- Inserts can be resharpened 20 to 30 times.
- Inserts are ground to 5/16" or 3/8" thickness only.
- Blanks oversize on width and length for EDMing.
- Blanks are recessed on back end for mounting in EDM fixture.
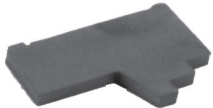- Adaptable for "Datum Point" Applications (See page 20)

For best results, inserts should be cut in Wire EDM Fixtures shown on page 27 & 29.

RESHARPENABLE INSERT SIZE						
*5/16 X 3/4	**5/16 X 1-1/8**	**5/16 X 1-3/4**	**3/8 X 1-1/4**	**3/8 X 1-3/4**	**3/8 X 2-1/4**	**3/8 X 2-3/4**
C2 MICRO RI-.75MIC	RI-1.125MIC	RI-1.75-N-MIC	RI-1.25MIC	RI-1.75MIC	RI-2.25MIC	RI-2.75MIC
C6 MICRO RI-.75C6	RI-1.125C6	RI-1.75-N-C6	RI-1.25C6	RI-1.75C6	RI-2.25C6	RI-2.75C6
76 PM HSS RI-.75-A	RI-1.125-A	RI-1.75-N-A	RI-1.25-A	RI-1.75-A	RI-2.25-A	RI-2.75-A
MAXAMET RI-.75-M	RI-1.125-M	RI-1.75-N-M	RI-1.25-M	RI-1.75-M	RI-2.25-M	RI-2.75-M
SPACER RI-.75-3/32	RI-1.125-3/32	RI-1.75-N-3/32	RI-1.25-1/8	RI-1.75-1/8	RI-2.25-1/8	RI-2.75-1/8

*Note: 5/16 x 3/4 blanks are used for 5/16 x 3/8 Inserts.

THROWAWAY EDM READY BLANKS FOR THOSE WITH EDM FACILITIES

Throwaway Insert

Back-up Anvil

- For those who don't want to resharpen inserts but still want to enjoy advantages of "RQC" Holders
- Adaptable for "Datum Point" applications (see page 20)
- Inserts are ground to 1/8" thickness only.
- Blanks oversize on width and length for EDMing.
- Blanks are recessed on back end for mounting in EDM fixture.

For best results, inserts blanks should be cut in Wire EDM Fixtures shown on page 27 & 29.

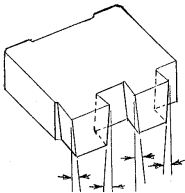| THROWAWAY INSERT SIZE						
*1/8 X 3/4	**1/8 X 1-1/8**	**1/8 X 1-1/4**	**1/8 X 1-3/4**	**1/8 X 2-1/4**	**1/8 X 2-3/4**
C2 MICRO TA-1.25MIC	TA-1.25MIC	TA-1.25MIC	TA-1.75MIC	TA-2.25MIC	TA-2.75MIC
C6 MICRO TA-.75C6	TA-1.25C6	TA-1.25C6	TA-1.75-C6	-	-
76PM HSS TA-.75-A	TA-1.25-A	TA-1.25-A	TA-1.75-A	TA-2.25-A	TA-2.75-A
MAXAMET TA-.75-M	TA-1.25-M	TA-1.25-M	TA-1.75-M	TA-2.25-M	TA-2.75-M
ANVIL BA-.75-3/16	BA-1.125-3/16	BA-1.25-1/4	BA-1.75-1/4**	BA-2.25-1/4	BA-2.75-1/4

*Note: 1/8 x 3/4 blanks are used for 1/8 x 3/8 Inserts.
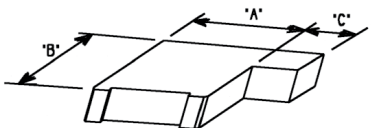*** Note: Use BA-1.75-3/16 for RQCGLD20-W holder*

Somma can custom design Throwaway Inserts with top to bottom clearance

- Inserts with top to bottom clearance (see diagram) reduce side rubbing and improves part finish
- Adaptable for "Datum Point" Applications.

Prices on application for inserts EDM'd to your part print.

CENTERING GAGES FOR RQC INSERT HOLDERS

- Gages are same (B) length as standard inserts.
- Gages are "L" shaped and overhang holder for easy setting to center.
- Just clamp in holder and set to center as you would normally.

CAT. NO.	A	B	C
RQCG-5/16	3/4	.630	.500
RQCG-3/8	1-1/4	.956	.500