



CDTooling Precision Positive Ground Turning Inserts

Material

Cast Iron	BEST
Carbon-Graphite-Phenolics	BEST
Hardened Material	BEST

Material Hardness	HB	HRC
Gray Cast Iron Low Tensile Strength	180	10
Carbon-Graphite-Phenolics		
Hardened Material		45

Application

	General	Finishing	Roughing			
Insert Grade	DKU10HT	DUP15VT	DUP35RT			
Chip Breaker	KEU	KEU	KEU			
ISO Insert Grade	M10-K10-S10	P10 M10 K10 S10	P20 M25 K25 S25			
ANSI Insert Grade	C3-C4	C3-C8	C3-C7			
Insert Coating	Uncoated	PVD AlCrN	PVD TiAlN/WC/C			
Insert Aptitude	Hard & Wear Resistant Turning at High SFM	Very Hard & Abrasive Resistant Turning at Higher SFM	Difficult & Unstable Operation Turning at High SFM			
Condition	Wet	Dry	Wet-Dry			
	Cutting Data	Cutting Data	Cutting Data			
	Inch	Metric	Inch	Metric		
Depth of Cut ap	.002 - .039	0.05 - 1.00	.002 - .098	0.05 - 2.50	.008 - .157	0.20 - 4.00
Feed per Rev. fn	.002 - .008	0.05 - 0.20	.002 - .008	0.05 - 0.20	.002 - .016	0.05 - 0.40
	SFM (Vc)	SFM (Vc)	SFM (Vc)			
	625 - 375	190 - 114	1042 - 625	316 - 190	891 - 624	270 - 189
	228 - 137	69 - 41	380 - 190	115 - 58	264 - 211	80 - 64
	69 - 42	21 - 13	116 - 69	35 - 21	99 - 69	30 - 21

Description	ANSI	ISO	UPC 733101-	UPC 733101-	UPC 733101-
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