



# CDTooling Molded Negative Turning Inserts

## Material

**Stainless Steel**

BEST

Insert Grade

Chip Breaker

ISO Insert Grade

ANSI Insert Grade

Insert Coating

Insert Aptitude

Condition

Depth of Cut ap

Feed per Rev. fn

### Material Hardness

**Austenitic S. S. 300 Series**

**Ferritic and Martensitic S.S. 400 Series**

**Precipitation Hardening S.S. 17-4-PH**

**HB**

**HRC**

180

10

330

35

330

35

## Application

### Finishing

**DMC30UT**

MEF

P35-M35

C5-C6

CVD  
TiCN/TiN

Hard & Wear Resistant  
Turning at High SFM

Wet

### Cutting Data

Inch

Metric

.008 - .118      0.20 - 3.00

.002 - .012      0.05 - 0.30

### SFM (Vc)

878 - 527      266 - 160

559 - 335      169 - 102

499 - 299      151 - 91

### Medium

**DMC30UT**

MEM

P35-M35

C5-C6

CVD  
TiCN/TiN

Hard & Wear Resistant  
Turning at High SFM

Wet

### Cutting Data

Inch

Metric

.031 - .157      0.80 - 4.00

.004 - .016      0.10 - 0.40

### SFM (Vc)

799 - 479      242 - 145

508 - 305      154 - 92

454 - 272      138 - 83

### Roughing

**DMC30UT**

MER

P35-M35

C5-C6

CVD  
TiCN/TiN

Hard & Wear Resistant  
Turning at High SFM

Wet

### Cutting Data

Inch

Metric

.039 - .236      1.00 - 6.00

.008 - .031      0.20 - 0.80

### SFM (Vc)

726 - 436      220 - 132

462 - 277      140 - 84

413 - 248      125 - 75

Description

ANSI

ISO

UPC 733101-

UPC 733101-

UPC 733101-