



# CDTooling Molded Negative Turning Inserts

## Material

Steel Alloy Steel	BEST
Stainless Steel	Good
Cast Iron	Fair

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

**Carbon Steel Annealed**

**Alloy Steel Annealed**

**Alloy Steel Heat Treated**

**Stainless Steel Austenitic 300 Series**

**Gray Cast Iron**

HB	HRC
125	
180	8
300	32
180	8
180	8

## Application

Finishing		Universal		Roughing	
DPC15HT		DPC25UT		DPC35RT	
PEF/PEM/PER		PEF/PEM/PER		PEF/PEM/PER	
P10 P25 M10-M25		P15-P35 M15-M35		P25-P45 M25-M45	
C6-C7		C5-C6		C5	
CVD Al <sub>2</sub> O <sub>3</sub> /TiCN/Al <sub>2</sub> O <sub>3</sub> /TiCN		CVD Al <sub>2</sub> O <sub>3</sub> /TiCN/Al <sub>2</sub> O <sub>3</sub> /TiCN		CVD Al <sub>2</sub> O <sub>3</sub> /TiCN/Al <sub>2</sub> O <sub>3</sub> /TiCN	
Hard & Wear Resistant Turning at High SFM		Hard, Tough, & Wear Resistant Turning at Medium SFM		Hard, Tough, & Impact Resistant Turning at Low SFM	
Wet		Wet		Wet	
Cutting Data		Cutting Data		Cutting Data	
Inch	Metric	Inch	Metric	Inch	Metric
.002 - .039	0.05 - 1.00	.016 - .236	0.40 - 6.00	.031 - .394	0.80 - 10.00
.004 - .079	0.10 - 2.00	.004 - .020	0.10 - 0.50	.008 - .031	0.20 - 0.80
SFM (Vc)		SFM (Vc)		SFM (Vc)	
1616 - 969	490 - 294	1346 - 808	408 - 245	1122 - 561	340 - 170
1140 - 684	346 - 207	950 - 570	288 - 173	792 - 396	240 - 120
570 - 342	173 - 104	475 - 285	144 - 86	396 - 198	120 - 60
808 - 485	245 - 147	673 - 404	204 - 122	561 - 281	170 - 85
990 - 693	300 - 210				

Description

ANSI

ISO

UPC 733101-

UPC 733101-

UPC 733101-