


CDT Insert Grade Conditions

-  Good
-  Better
-  Best

Steel






































Stainless Steel

Cast Iron

Ferrite Materials

Heat-Resistant Steel

Hardened Metal

| Grade | Description | P | M | K | N | S | H |
|--------|---|---|--|---|---|---|---|
| UD51 | General purpose Tin (CVD) coated steel grade - used for roughing and semi-finishing of carbon alloy and stainless steel. |  |  |  | |  | |
| UD52 | Tough general purpose steel grade with multi-layer titanium aluminum nitride coating for alloy steel, aluminum alloys, austenitic stainless and carbon steels, copper alloys and exotic alloys. |  |  | | |  | |
| UD5C | Uncoated cermet grade for semi-finishing and finishing applications at medium to high cutting speeds on carbon and alloyed steels. Also used on stainless. Normally used without coolant. | |  |  | | | |
| UD5CBN | A Polycrystalline Cubic Boron Nitride (PCBN) Insert for precision finishing of hardened steels 50-65 rockwell. Coolant not recommended for use. | | |  | | |  |
| UD5CT | TiAlN coated cermet grade performs extremely well for semi-finish and finish applications in alloyed steels, stainless and high carbon steels. |  |  |  | | | |
| UD1 | Uncoated - Designed with a polished surface and large rake angle. Intended for machining aluminum and other non-ferrous alloys. Also works well for semi machining on cast iron. | |  | |  | | |
| UD2 | Uncoated - used to cut cast iron, aluminum, non-ferrous alloys, non-metals and most high temp alloys. Provides excellent wear resistance. | | |  |  | | |
| UD2CBN | A Polycrystalline Cubic Boron Nitride (PCBN) Insert for cast iron, gray cast iron, chilled cast, and powder metal with long tool life. Coolant not recommended for use. | | |  | | |  |
| UD21 | Multi-layer titanium aluminum nitride grade. Excellent for machining cast iron, stainless steel, nickel based high temperature alloys. Excellent oxidation resistance and bears high, semi dry/dry machining. | |  |  | |  | |
| UD22 | Tin coated insert. Suitable for semi-finishing and finishing of high temp alloys. Intended for cast iron machining. | | |  | |  | |
| UD32 | TiAlN coated insert. Used in high speed medium load applications of stainless steel and finishing to semi-finishing of high temperature alloys. |  |  |  |  |  | |
| UD204 | A PVD TiAlN coated fine grain substrate. Excellent for light to medium feeds on Cast Iron and semi-finishing to finishing of high temperature alloys. Excellent for high SFM. |  | |  | |  | |
| UD404 | A PVD TiAlN coated tough general purpose grade. Well suited for milling Alloy Steels, Stainless Steel, High Temperature Alloy Steels and Hardened Steels up to 60 Rc. |  |  |  | |  | |
| UD602 | A CVD coating of TiAl ₂ O ₃ & TiN on a tough substrate. It is suitable for light to heavy milling of alloy steel and non alloy steel, even under unfavorable condition. | | | | | | |