

PCD Applications

RECOMMENDED RUNNING CONDITIONS

General Info	Material	SFM	IPR	D.O.C.	Grade Recommendations		
					First	Second	Third
Negative Inserts	Aluminum Alloys (4% - 8% Si)	3000 - 10000	0.004 - 0.025	0.120"	DA2200	DA150	DA200
	Aluminum Alloys (9% - 14% Si)	2000 - 8000	0.004 - 0.020	0.120"	DA2200	DA150	DA200
	Aluminum Alloys (15% - 18% Si)	1000 - 2300	0.004 - 0.015	0.120"	DA2200	DA150	DA200
Positive Inserts	Copper Alloy	3300	0.002 - 0.008	0.120"	DA2200	DA150	DA200
	Hard Plastic	3300	0.004 - 0.012	0.080"	DA2200	DA150	DA200
Ace-Fix Inserts	Wood & Composite	13000	0.004 - 0.015	-	DA2200	DA150	DA200
	Tungsten Carbide	30 - 70	0.003 - 0.008	0.020"	DA90	DA150	-
Threading, Grooving, & Cut-Off Inserts	Reinforced Plastics	3300	0.016	0.080"	DA2200	DA150	DA200

Note: The above running parameters are for turning applications only.

Ceramic Inserts

PCBN & PCD Inserts

Toolholders

Swiss Toolholders

Boring Bars

Technical Info

ALMT

