

Insert Grade & Coating Selection

TOUGHEST
(Shock Resistant)



HARDEST
(Wear Resistant)

Grade	Materials		Machining Conditions			Coating			Coolant
			Roughing	Medium	Light	1st Choice	2nd Choice	3rd Choice	
			Severe	Moderate	Rigid				
DMK35	High-Temp. Alloys	S20-S40	■	■	■	IN	HM	TS	●
	Stainless Steel	M20-M40	■	■	■	HM	IN		●
DMP35	Steel	P30-P40	■	■	□	HM	GLH	TCI	★ ○
	Iron	K25-K40	■	□	□	HM	GLH	TCI	◆
	High-Temp. Alloys	S20-S35	□	□	□	HM	TS	GLH	●
	Stainless Steel	M20-M35	□	□	□	HM	GLH	TCI	●
DMK30 (High-Feed, Button / Face)	Steel	P30-P40	■	■	□	GLH	HM	TCI	★
	Iron	K25-K40	■	□	□	HM	GLH	TCI	◆
	High-Temp. Alloys	S20-S35	□	□	□	HM	TS	GLH	●
	Stainless Steel	M20-M35	□	□	□	HM	GLH	TCI	●
DMK30 (Square Shoulder)	Steel	P15-P25	□	□	□	HM	GLH	TCI	★ ○
	Iron	K15-K25	□	■	□	HM	GLH	TCI	◆
	Stainless Steel	M15-M25	□	□	□	HM	GLH	TCI	●
	Copper Alloys	N20-N30	■	■	■	GLH	TCI		●
DMP30	Steel	P25-P35	□	■	□	HM	GLH	TCI	★ ○
	Iron (Ductile)	K20-K30	■	■	□	HM	GLH	TCI	◆
	Hardened Steel (< 45 Rc)	H20-H30	□	■	■	HM	GLH	TS	★ ○
DMM25 (High-Feed)	Steel	P30-P40	□	■	■	UHT			★
	Iron	K25-K40	□	□	□	UHT			★
	High-Temp. Alloys	S20-S35	■	■	■	UHT			●
	Stainless Steel	M20-M35	■	■	■	UHT			★
DMP25	Steel	P25-P35	□	■	□	GLH	HM	TCI	★
	Iron (Ductile)	K20-K30	■	■	□	HM	GLH	TCI	◆
	Hardened Steel (< 45 Rc)	H20-H30	□	■	■	HM	GLH	TS	★ ○
DMK25 (High-Feed, Button / Face)	Steel	P15-P25	□	□	□	GLH	HM	TCI	★
	Iron	K15-K25	□	■	□	HM	GLH	TCI	◆
	Stainless Steel	M15-M25	□	□	□	HM	GLH	TCI	●
	Copper Alloys	N20-N30	■	■	■	GLH	TCI		●
DMK25 (Square Shoulder)	Hardened Steel (> 45 Rc)	H10-H30	□	□	■	HM	GLH	TS	★ ○
	Iron	K10-K30	□	■	■	HM	GLH	TCI	◆
	Non-Ferrous	N10-N30	■	■	■	GLH	TCI	Uncoated	●
	Non-Ferrous (Alu, Graph)	N10-N30	□	■	■	PCD	DL	Uncoated	●
	Steel	P10-P25	□	□	■	GLH	HM	TCI	★ ○
DMK15	Hardened Steel (> 45 Rc)	H10-H30	□	□	■	HM	GLH	TS	★ ○
	Iron	K10-K30	□	■	■	HM	GLH	TCI	◆
	Non-Ferrous	N10-N30	■	■	■	Uncoated	GLH	TCI	●
	Steel	P10-P25	□	□	■	GLH	HM	TCI	★

- Highly Recommended
- Recommended
- Not Recommended
- Coolant Beneficial
- ◆ Coolant Optional
- Coolant Detrimental
- ★ Air Preferred
- › **Bold text** indicates preferred material.

Ball Nose Insert Grade & Coating Selection

Grade	Materials		Machining Conditions			Coating			Coolant
			Roughing	Medium	Light	1st Choice	2nd Choice	3rd Choice	
			Severe	Moderate	Rigid				
F1 / UC	Steel	P10-P25	☐	■	■	GLH	HM	TS	◆
	Hardened Steel (> 45 Rc)	H10-H20	☐	▣	■	HM	GLH	TS	★ ○
	Iron	K10-K25	▣	■	■	HM	GLH	TS	◆
	Stainless Steel	M10-M20	☐	▣	■	HM	GLH	TS	●
	High-Temp. Alloys	S10-S20	☐	▣	■	HM	TS	GLH	●
	Non-Ferrous (Alu, Graph)	N10-N40	■	■	■	PCD	FPD	FPDL	●
	Non-Ferrous (Wood, Plastic)	N10-N40	■	■	■	Uncoated			●
	Copper Alloys	N10-N30	■	■	■	GLH	FPO		●
T1	Steel	P10-P35	■	■	■	HM	TS		◆
	Hardened Steel (> 45 Rc)	H10-H25	▣	■	■	HM	TS		★ ○
	Iron	K10-K35	■	■	■	HM	TS		◆
	Stainless Steel	M10-M30	■	■	■	HM	TS		●
	High-Temp. Alloys	S10-S25	■	■	■	TS	HM		●
	Non-Ferrous (Alu, Graph, Wood, Plastic)	N10-N40	▣	▣	▣	T1			●
	Copper Alloys	N10-N40	■	▣	▣	TS	HM		●

- Highly Recommended
- ▣ Recommended
- ☐ Not Recommended
- Coolant Beneficial
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- › **Bold text** indicates preferred material.

HIGH-FEED

SQUARE SHOULDER

BUTTON / FACE

BALL NOSE / BACK DRAFT

GRADE & COATING SELECTION