

DMT type

MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, which can be used with all materials; it should be run at medium to high cutting speeds.

ISO	Materials	Cutting Speed ft/min	Feed inch/tooth Cutting Diameter=D						
			Ø.16	Ø.20	Ø.24	Ø.31	Ø.35	Ø.39	Ø.47
P	Low and Medium Carbon Steels <0.55%C	200-395	.0012	.0012	.0016	.0020	.0020	.0020	.0020
	High Carbon Steels ≥0.55%C	200-295	.0008	.0012	.0012	.0016	.0016	.0016	.0020
	Alloy Steels, Treated Steels	165-260	.0008	.0008	.0008	.0008	.0012	.0012	.0016
M	Stainless Steels - Free Cutting	230-330	.0008	.0008	.0008	.0008	.0012	.0012	.0012
	Stainless Steels - Austenitic	200-295	.0008	.0008	.0008	.0008	.0012	.0012	.0012
	Cast Steels	230-295	.0008	.0008	.0008	.0008	.0012	.0012	.0016
K	Cast Iron	130-260	.0012	.0012	.0016	.0020	.0020	.0020	.0020
N	Aluminum ≤12%Si, Copper	330-655	.0012	.0012	.0016	.0020	.0020	.0020	.0020
	Aluminum >12% Si	200-460	.0008	.0008	.0008	.0008	.0012	.0012	.0012
	Synthetics, Duroplastics, Thermoplastics	165-655	.0016	.0020	.0020	.0024	.0024	.0024	.0024

DMTH type

MT11 Ultra-fine Sub-Micron grade with advanced PVD triple Blue coating

ISO	Materials	Cutting Speed ft/min	Feed inch/tooth Cutting Diameter=D								
			Ø.08	Ø.12	Ø.16	Ø.20	Ø.24	Ø.31	Ø.35	Ø.39	Ø.47
P	Low and Medium Carbon Steels <0.55%C	190 - 390	.0008	.0008	.0012	.0012	.0016	.0020	.0020	.0020	.0020
	High Carbon Steels ≥0.55%C	190 - 290	.0008	.0008	.0008	.0012	.0012	.0016	.0016	.0016	.0020
	Alloy Steels, Treated Steels	160 - 260	.0008	.0008	.0008	.0008	.0008	.0008	.0012	.0012	.0016
M	Stainless Steels - Free Cutting	230 - 330	.0008	.0008	.0008	.0008	.0008	.0008	.0012	.0012	.0012
	Stainless Steels - Austenitic	190 - 290	.0008	.0008	.0008	.0008	.0008	.0008	.0012	.0012	.0012
	Cast Steels	230 - 290	.0008	.0008	.0008	.0008	.0008	.0008	.0012	.0012	.0016
K	Cast Iron	130 - 260	.0012	.0012	.0012	.0012	.0016	.0020	.0020	.0020	.0020
N	Aluminum ≤10%Si, Copper	330 - 650	.0012	.0012	.0012	.0012	.0016	.0020	.0020	.0020	.0020
	Aluminum >10% Si	190 - 460	.0008	.0008	.0008	.0008	.0008	.0008	.0012	.0012	.0012
	Synthetics, Duroplastics, Thermoplastics	160 - 650	.0016	.0020	.0016	.0020	.0020	.0024	.0024	.0024	.0024
S	Nickel Alloys, Titanium Alloys and High Temp. Alloys	65 - 130	.0008	.0012	.0012	.0016	.0020	.0020	.0024	.0024	.0024
H	Hardened Steels 45-50 HRc	190 - 230	.0008	.0008	.0008	.0012	.0016	.0016	.0020	.0020	.0020
	Hardened Steels 50-55 HRc	160 - 190	.0004	.0004	.0004	.0008	.0012	.0012	.0016	.0016	.0016