

Application guideline

General purpose	Special purpose	Wear resistance	Fine surface
Al-Si alloy (9-12%) Woodworking Cu alloy	Al-Si alloy face milling CFRP	Al-Si alloy (>12%) Ceramic (sintered/unsintered) Tungsten carbide Laminated floor Designed for excellent tool life	Woodworking Cu alloy Rubber Acrylglass Designed for better surface roughness
CXLII	CXLII	CXLII	CXLII
CXL	CXL	CXL	CXL
CCW	CCW	CCW	CCW
CM	CM	CM	CM
CMW	CMW	CMW	CMW
CFW	CFW	CFW	CFW
CUFSII	CUFSII	CUFSII	CUFSII
UFD-A	UFD-A	UFD-A	UFD-A

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PCD

Polycrystalline Diamond

IPOL

ILJIN Polycrystalline Diamond

	Grade	Grain Size	Property
Coarse	CXLII	40μm	Specially designed for superior wear resistance, bi-modal structure
	CXL	25μm	Excellent wear resistance with strong diamond bonding. General purposes for high Si% Al alloy composite, bi-modal structure
	CCW	25μm	Good wear resistance with special binder and diamond bonding
Medium	CM	10μm	General purpose for Al and Al-Si alloy
	CMW	10μm	General purpose, easy wire cutting and good impact resistance
Fine	CFW	4μm	Good surface finishing
	CUFSII	2μm	Good surface finishing
	UFD-A	1μm	Ultra fine diamond for high performance Al-alloy milling application

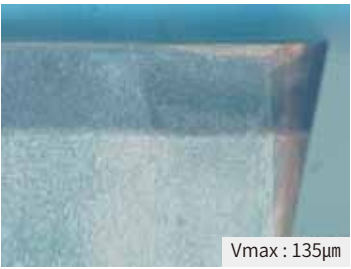
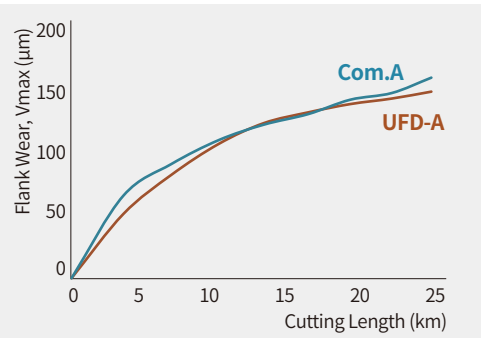
75pi diameter discs available in CM, CMW, CXL

Performance Test

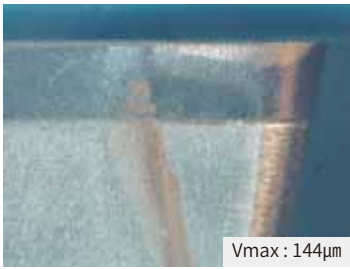
UFD-A

Al alloy O.D Continuous Turning

Material	A390 (Al-17%SiC)
Speed	800m/min
D.O.C	0.5mm
Feed	0.5mm
Coolant	WET (Water Soluble, 8%)
Insert type	SPGN120404



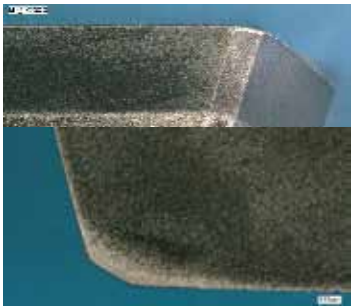
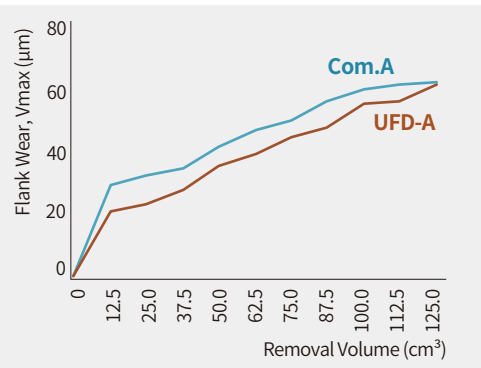
UFD-A



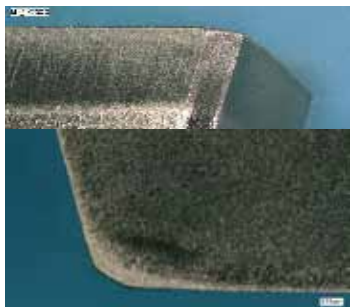
Comp. A

Al alloy Milling

Material	A390 (Al-17%SiC)
Speed	1,000m/min
D.O.C	0.2mm
Feed	0.075 mm/rev
Coolant	Dry
Insert type	CDEW1204R



UFD-A



Comp. A