

CHIPBREAKER SELECTION (POSITIVE INSERTS)

Steel

1 Molded Chipbreaker

GRADES	INSERTS	CBN & PCD	TURNING	BORING	GROOVING	CUT-OFF	THREADING	SOLID END MILLS	MILLING	SPARE PARTS	TECHNICAL	INDEX									
A	B	C	E	F	G	H	J	L	M	P	R	T	Minute D.O.C.	CF		Available for minute D.O.C. (0.02 to 0.2mm) finishing.	Finishing	GP		Good chip control at finishing. Applicable to sticky material like low carbon steel, pipe material.	
													Finishing	GF		Dot located close to ridge line of cutting edge on corner. Chips fragmented in small pieces in cutting of small D.O.C..		Finishing-Medium	GK		Good chip evacuation at wide range by breaker dot and wide chip pocket.
													Finishing-Medium	GQ		Enables cutting over a wide range of conditions by using the optimum chipbreaker width according to the cutting depth.		Finishing-Medium	HQ		General purpose chipbreaker for medium cutting.
													Finishing	CK		Good cutting performance. Applicable without hand for two direction cutting on automatic lathe.		Finishing	XP		Wide chip control range and sharp cutting performance. Suitable for low carbon steel and sticky material.
													Medium	Standard (without Symbol)		Strong edge chipbreaker for medium cutting range.		Finishing-Medium	XQ		Wide chip control range and sharp cutting performance. Suitable for low carbon steel and sticky material.
													Finishing	PP		3-step Smart Dot structure is applicable to a wide range of feed rates in steel finishing. Smooth taper cutting edge reduces cutting forces.					

Applicable Chipbreaker Range (D.O.C. indicates radial depth per side of the workpiece)

