

CHIPBREAKER SELECTION (POSITIVE INSERTS)

A	GRADES
B	INSERTS
C	CBN & PCD
E	TURNING
F	BORING
G	GROOVING
H	CUT-OFF
J	THREADING
L	SOLID END MILLS
M	MILLING
P	SPARE PARTS
R	TECHNICAL
T	INDEX

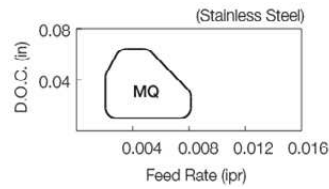
Stainless Steel

Finishing

MQ

Good chip evacuation at internal turning. Small curled chips. Prevents chip entanglement with toolholder and stabilizes surface roughness.

Applicable Chipbreaker Range (D.O.C. indicates radius)



Aluminum & Non-ferrous Metals

Finishing-Medium

AH

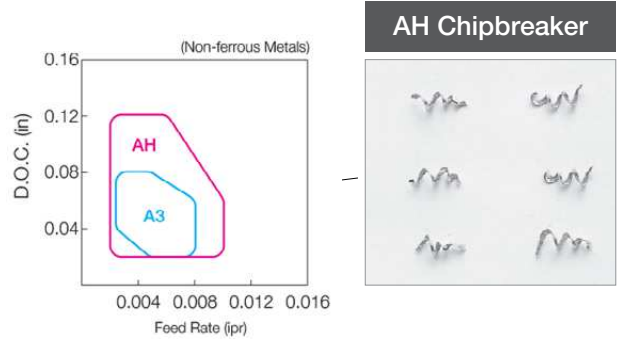
Positive chip groove and good chip control with low cutting forces. Polished surface reduces adhesion.

Finishing-Medium

A3

Large rake angle, smooth chip flow and less adhesion. Sharp edge and good surface finish.

Applicable Chipbreaker Range (D.O.C. indicates radius)



Insert Color

● Cermet, MEGACOAT Cermet, and PVD Coated Cermet

Grades	Cermet	MEGACOAT NANO Cermet	MEGACOAT Cermet	PVD Cermet
	NEW TN620 TN6010 TN6020 TN60 TN100M TC40N TC60M	NEW PV720	PV7005 PV7010 PV7025 PV7040	PV7020 PV90
Insert Color				

● MEGACOAT (PVD Coated Carbide)

Grades	MEGACOAT						
	PR1210	PR1215	PR1225	PR1230	PR1305	PR1310	PR1325
Insert Color							

● CVD Coated Carbide and PVD Coated Carbide

Grades	CVD Coated Carbide	PVD Coated Carbide
	NEW CA510 CA515 CA525 CA530 CA55 Series CA65 Series	PR930 PR1005 PR1025 PR1115 PR1125
Insert Color		

● MEGACOAT NANO (PVD Coated Carbide)

Grades	MEGACOAT NANO		
	PR1425	PR1510	PR1525
Insert Color			

● CBN and PCD

Grades	CBN	PCD	MEGACOAT CBN
	KBN65B KBN510 KBN525 NEW KBN570	KPD001 KPD010 KPD230	KBN..M
Insert Color			

● Carbide

Grades	Carbide			
	GW15	GW25	KW10	SW05
Insert Color				