

● Cutter Type and Chipbreaker Selection

Milling Purpose	Cutter Type			Chipbreaker				
	Coarse Pitch	Fine Pitch	Extra Fine Pitch	GM	SM	GH	GL	W
General milling for steel and alloy steel		●		●				
Steel and alloy steel (to prevent chattering due to low rigidity machine or poor clamping power)	●				●			
Productivity oriented (high metal removal rate) (D.O.C. ≥ 0.1575", fz ≥ 0.0138 ipt)	●					●		
Focusing on finishing quality	●	●					●	
General milling of stainless steel		●			●			
Stainless steel (to prevent chattering due to low rigidity machine or poor clamping power)	●				●			
Cast iron (for high feed rates and high efficiency)			●	●				
Cast iron (D.O.C. ≥ 0.1575", fz ≥ 0.0138 ipt)	●					●		
Improved surface finish in high-efficiency milling		●	●					●

● How to Use Wiper Insert

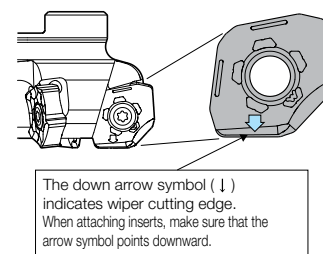
- 1) Please use one wiper insert per cutter.  
(If you use more than 2 inserts on one cutter, the workpiece surface may have galling.)
- 2) Combination of Wiper Insert with Other Chipbreakers

Chipbreaker Combination	GM	SM	W
Recommended Combination	●		●
Recommended Combination		●	●

GH+W and GL+W insert chipbreaker combinations are not recommended.

- 3) For checking the protrusion amount of the wiper insert, use tool presetter. (Appropriate protrusion: 0.0039")

● How to Attach Wiper Inserts on MFPN Cutter



GRADES	A
LINEUP / INSERTS	B
45° / 70° LEAD	C
75° LEAD	D
90° LEAD	E
HIGH FEED	F
MULTI-FUNCTION	G
SLOT MILLS	H
RADIUS / BALL-NOSE	J
OTHER APPLICATIONS	K
TOOL HOLDING	O
SPARE PARTS	P
TECHNICAL	R
INDEX	T