

Recommended Chipbreakers (ZXMT)

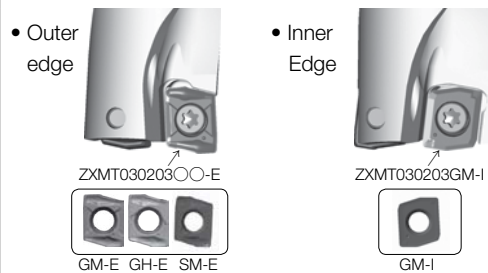
Workpiece Material	Insert Chipbreaker	ZXMT type											
		GM				GH				SM			
	Cutting Depth	2D	3D	4D	5D	2D	3D	4D	5D	2D	3D	4D	5D
Low-carbon Steel		☆	☆	☆	☆					★	★	★	★
Carbon Steel		★	★	★	☆	☆	☆	☆	☆	☆	☆	☆	★
Alloy Steel		★	★	★	☆	☆	☆	☆	☆	☆	☆	☆	★
Mold Steel		☆	☆	☆	☆	★	★	★	★				
Stainless Steel										★	★	★	★
Cast Iron		★	★	★	★								
Aluminum Alloys										★	★	★	★
Brass										★	★	★	★
Titanium Alloys										★	★	★	★

★ : 1st Recommendation ☆ : 2nd Recommendation

How to select ZXMT03

ZXMT03 type (Cutting Dia : $\phi 12 \sim \phi 13$)

- 1) For outer edge, please select "-E" insert from three different chipbreakers for each application.
- 2) For inner edge, please select "-I" insert (GM chipbreaker only).



Magic Drill DRX

Drilling

Features of the Magic Drill DRX Chipbreakers

Chipbreaker			GM	GH	SM
Insert					
Advantages			1st. recommendation for carbon steel and alloy steel, 1st. recommendation for cast iron.	1st. recommendation for interrupted machining and hard materials. Cutting edge strength oriented design.	Suitable for sticky materials such as stainless steel and low carbon steel
			Good balance of sharp cutting and cutting edge strength.	Middle to high feed rates of steel machining, GM Chipbreaker alternative.	Sharp cutting, prevents chattering. For low to medium feed rates of steel.
Outer edge	 Wide chipbreaker	Cross-section			
		Chips from Outer edge			
Inner edge	 Flat chipbreaker	Cross-section			
		Chips from Inner edge			
Workpiece Materials			C50 (S50C)	C50 (S50C)	X5CrNi18 10 (SUS304)