

TKFB-GQ Chipbreaker

for Back-Turning

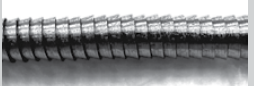
GRADES	A
INSERTS	B
CBN & PCD	C
TOOLHOLDERS	D
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BORING	F
GROOVING	G
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THREADING	J
HSK TOOLING	N
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1 Original double-function chipbreaker for improved chip control

Turning Function


- Prevents chip entanglement

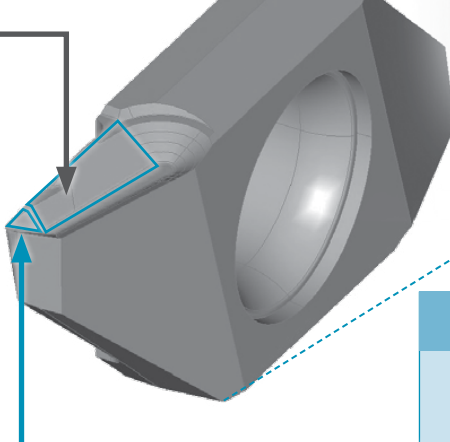
GQ Chipbreaker



Stable Chip Control

Competitor (Ground)







Grooving Function

- Prevents chip biting

GQ Chipbreaker



Competitor (Ground)

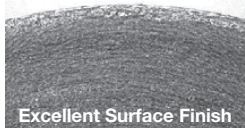
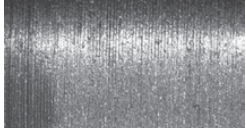
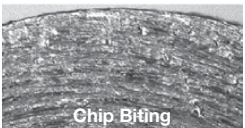
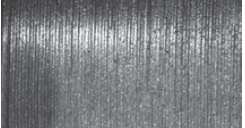


Good Surface Roughness

2 Prevents chip biting and clogging for excellent surface finishes

Surface Finish Comparison

Cutting Conditions: $V_c = 330\text{sfm}$ D.O.C. = $0.112''$ $f = 0.008\text{ipr}$ (Grooving), 0.002ipr (Turning)
Workpiece: 1045 Steel

	GQ Chipbreaker		Competitor (Ground)	
	Facing	External	Facing	External
Workpiece Surface	 <p>Excellent Surface Finish $R_z = 2.92\ \mu\text{m}$</p>	 <p>$R_z = 3.85\ \mu\text{m}$</p>	 <p>Chip Biting $R_z = 31.23\ \mu\text{m}$</p>	 <p>$R_z = 7.67\ \mu\text{m}$</p>

Reduced cycle time with excellent surface finish in a single pass!