

CHIPBREAKER SELECTION (NEGATIVE INSERTS)

Steel

1 Molded Chipbreaker

Finishing (With Wiper Edge)	WP		Wiper Insert. Double feed rate is available for finishing to light machining, while maintaining a smooth finish.	Finishing	GP		Finishing to light machining. Good chip control.	
	WQ		Wiper Insert. Double feed rate possible while maintaining a smooth finish. High efficiency and good chip control.		Finishing-Medium	HQ		Sharp cutting performance with 3-D rake angle and double projection design.
	PP		3-step dot structure realizes stable chip control at a wide range of feed rate. Less cutting force due to sharp cutting edge and smooth rake face.		Finishing-Medium (Up Facing)	CJ		Ensures chips will curl even in small depth, high feed rate machining. Improves chip evacuation when copying and up-facing.
	PQ		Stable chip control in a wide feed rate range by breaking chips effectively. The well-balanced edge sharpness and toughness.		Medium-Roughing	PG		Stable machining with a balance of edge sharpness and strength. Prevents chip clogging at high feed rates. Good chip control at low feed rates. Stable machining with wide chip control range.

● Applicable Chipbreaker Range (D.O.C. Refers to Radial Depth of Cut)

