

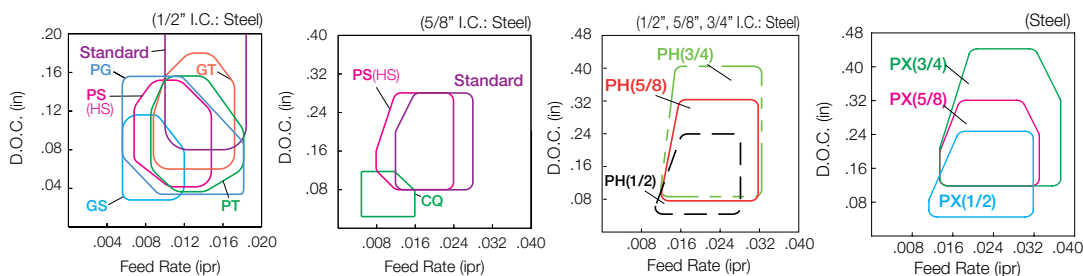
# CHIPBREAKER SELECTION (NEGATIVE INSERTS)

## Steel

### 1 Molded Chipbreaker

Medium-Roughing	GS		Strong edge chipbreaker. Stable for continuous machining and light interrupted machining.	Medium-Roughing (High Feed Rate)	GT		Strong edge chipbreaker. Wide land design and smooth chip control even at high feed rate machining.	
	PS		General purpose chipbreaker. More stable due to large contact surface.		Roughing	Standard		Low cutting force and suitable for large D.O.C. roughing.
	HS		General purpose chipbreaker. Applicable for copying.			PH		For roughing of steel. Suitable for heavy interrupted machining and for workpieces with scale due to strong cutting edge.
	PT		Low cutting force during high feed machining. Land support structure.		PX		Roughing and high feed rate operation. Low cutting force chipbreaker.	

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



GRADES	A
INSERTS	B
CBN & POD	C
TOOLHOLDERS	D
SMALL TOOLS	E
BORING	F
GROOVING	G
CUT-OFF	H
THREADING	J
HSK TOOLING	N
SPARE PARTS	P
TECHNICAL	R
INDEX	T