

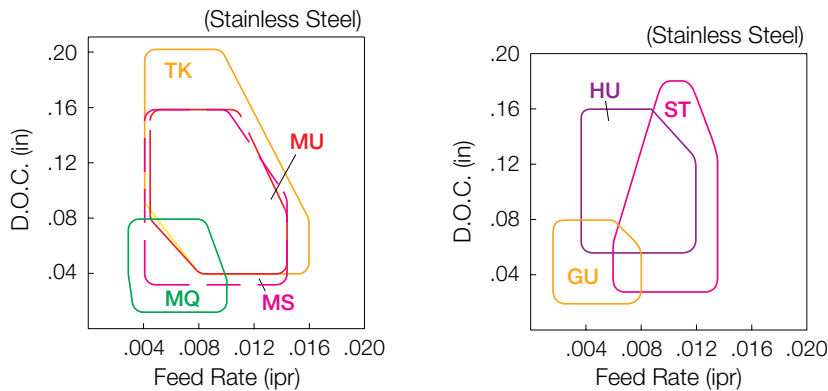
CHIPBREAKER SELECTION (NEGATIVE INSERTS)

Stainless Steel / Heat-Resistant Alloy / Titanium Alloy

Medium-Roughing	TK		Smooth chipbreaker geometry improves chip flow with less adhesion. Large curled chips.
	MU		Large rake angle reduces cutting force. Less burring achieved by diminishing damage from notching.
	MS		Superior cutting edge sharpness and strength achieved by a positive land. Extra strength of cutting edge inhibits damage from wall shouldering.
	MQ		Large rake angle and circular edge line. Low cutting force and good chip control.
Medium-Roughing	ST		Fewer cutting forces due to large rake angle. Less notching with special design.
	HU		Sharp cutting performance due to 3-D rake angle.
	GU		Sharp cutting performance and low cutting force due to 3-D rake angle.
	MQ		Large rake angle and circular edge line. Low cutting force and good chip control.

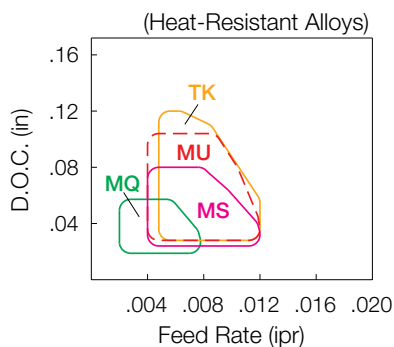
Stainless Steel

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



Heat-Resistant Alloys (PR1535 / PR13-Series)

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



Titanium Alloys (SW Series)

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

