

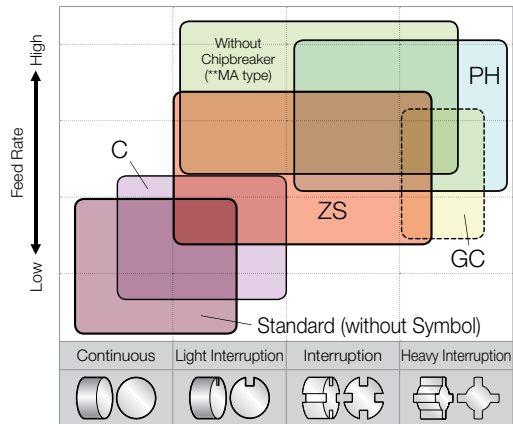
# CHIPBREAKER SELECTION (NEGATIVE INSERTS)

## Cast Iron

Sharp Cutting Oriented	Standard		Standard chipbreaker for continuous to light interrupted machining of cast iron. (Low cutting force)
	C		High feed rate chipbreaker for continuous to light interrupted machining of cast iron.
	ZS		Standard chipbreaker for light interrupted to interrupted machining of cast iron. (High stability)
	Without Chipbreaker		High feed rate chipbreaker for light interrupted machining of cast iron.

Stability Oriented	GC		Chipbreaker for heavy interrupted machining of cast iron. (Tough edge chipbreaker)
	PH		Chipbreaker for roughing of cast iron. Suitable for heavy interrupted machining and for workpieces with scale due to strong cutting edge.

### Chipbreaker Selection (Negative Inserts)

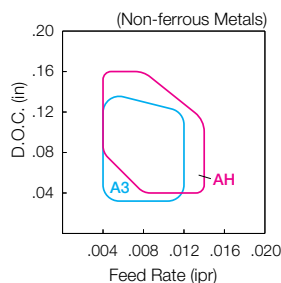


## Non-ferrous Metals

Finishing-Medium	A3		Large rake angle and smooth surface. Good chip control and less adhesion.
	AH		Polished chipbreaker. Smooth chip control and less adhesion.

Medium-Roughing	AH		Polished chipbreaker. Smooth chip control and less adhesion.
			G Class: Sharp Edge Prep. M Class: Horned Edge Prep.

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



A3 Chipbreaker	
	D.O.C.= 0.08" f= 0.008 ipr
	D.O.C.= 0.08" f= 0.012 ipr

AH Chipbreaker	
	D.O.C.= 0.08" f= 0.008 ipr
	D.O.C.= 0.08" f= 0.012 ipr