

CHIPBREAKER SELECTION (NEGATIVE INSERTS)

Steel

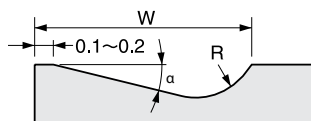
2 Ground Chipbreaker

Finishing-Medium	S		Sharp edge and less cutting force. Good chip control and smooth chip evacuation.	
		B		Suitable for general purpose machining at feed rate 0.006 to 0.010ipr.
			C	
Roughing	D			Suitable for general purpose machining at feed rate 0.012 to 0.018ipr.
		Medium-Roughing / Low Cutting Force	25R	

Effectiveness of ground chipbreaker

- (1) Lower cutting force and improve edge
- (2) Improved adhesion resistance
- (3) Improved dimension accuracy and finishing surface accuracy
- (4) Controlled chip evacuation direction

Specification of B, C, D and Parallel Ground Chipbreaker



Insert Type	I.C. Size	Chipbreaker Name	W (in)	α	R (in)
CNGG	3/8, 1/2	Without Indication (Similar to C)	0.087	14°	0.040
WNGG	3/8	Without Indication (Similar to C)	0.087	14°	0.040
TNGG	1/4, 3/8	B	0.060	14°	0.020
	3/8, 1/2	C	0.087	14°	0.040
	3/8, 1/2	D	0.110	10°	0.060
DNGG	3/8, 1/2	Without Indication (Similar to C)	0.100	14°	0.080
VNGG	3/8	Without Indication (Similar to B)	0.060	14°	0.020
SNGG	3/8, 1/2	B	0.060	14°	0.020
	1/2	C	0.087	14°	0.040

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

