

CHIPBREAKER SELECTION (POSITIVE INSERTS)

Steel

1 Molded Chipbreaker

Minute D.O.C.	CF		Available for minute D.O.C. (0.0008" - 0.008") finishing.	Finishing	PP		3-step Smart Dot structure is applicable to a wide range of feed rates in steel finishing. Smooth taper cutting edge reduces cutting forces.
Finishing	GF		Dot located close to ridge line of cutting edge on corner. Chips fragmented in small pieces in cutting of small D.O.C..	Finishing	DP		Consistent chip breaking performance for finishing.
Finishing-Medium	GQ		Enables cutting over a wide range of conditions by using the optimum chipbreaker width according to the cutting depth.	Finishing	GP		Good chip control at finishing. Applicable to sticky material like low carbon steel, pipe material.
Finishing	SK		Sharp cutting performance due to Large rake angle. Large dot to the corner edge improved chip control in a wide feed rate range.	Finishing	VF		Good chip control for varied ap such as copying and undercutting.
Finishing	CK		Good cutting performance. Applicable without hand for two direction cutting on automatic lathe.	Finishing-Medium	HQ		General purpose chipbreaker for medium machining.
Finishing	WP		Dual-dot structure with one dot offering stabilized chip control at low feed rates, while a second dot controls chips at higher feed rates.	Medium	G		Chipbreaker for short chips at medium machining.
Finishing-Medium	GK		Good chip evacuation at wide range by breaker dot and wide chip pocket.	Medium	Standard		Strong edge chipbreaker for medium machining range.

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

