

# CHIPBREAKER SELECTION (POSITIVE INSERTS)

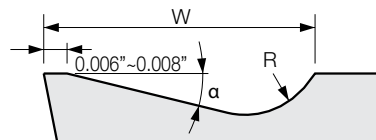
## Steel

### 2 Ground Chipbreaker

Finishing Low Feed	(Without Indication)			Good chip control during finishing to light machining with low cutting forces.
	F			Good chip control during finishing to light machining with low cutting forces.
	Y			Sharp cutting performance and good surface finish.
	J			Slant chipbreaker width and chip control at various D.O.C..
	U			Good chip control at low feed rate and varied D.O.C. with low cutting force. Suitable for automatic lathes.

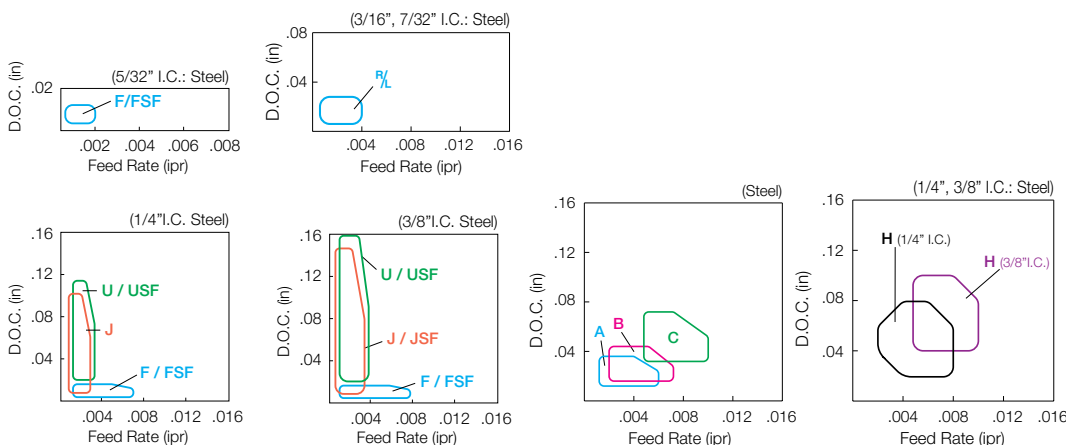
Finishing Medium Finishing-Medium	A			Large rake angle and low cutting force. Narrow chipbreaker width and consistent chip control.
	B			General purpose chipbreaker for medium machining. Good balance between chip control and sharp cutting.
	C			Applicable to high load machining. Good chip flow and less resistance.
	H			Sharp cutting performance and small curled chips.

### ● Specification of A, B, C and parallel ground chipbreaker



Insert Type	Size	Chipbreaker Name	W (in)	$\alpha$	R (in)
TPGR	1/4	A	0.040	17°	0.020
	1/4, 3/8	B	0.060	14°	0.020
	3/8	C	0.087	14°	0.040
SPGR	3/8	Without Indication (Similar to B)	0.060	14°	0.020
	1/2	Without Indication (Similar to C)	0.087	14°	0.040

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



GRADES	A
INSERTS	B
CBN & PCD	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