

CHIPBREAKER SELECTION (POSITIVE INSERTS)

Low Carbon Steel (Pipe / Rolled Plate / Rolled Steel)

Finishing

XP

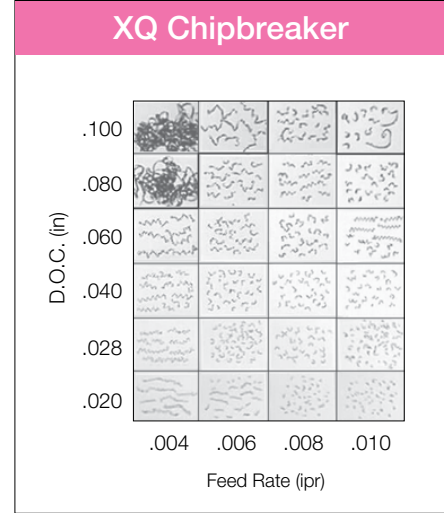
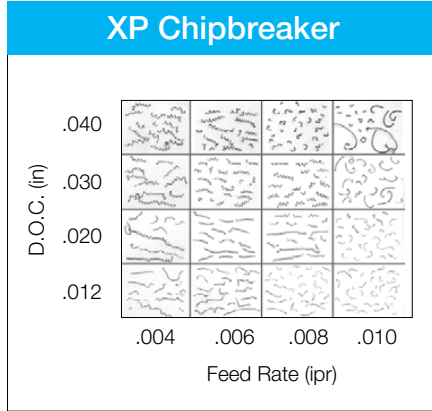
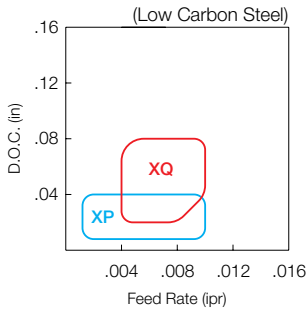
Wide chip control range and sharp cutting performance. Suitable for low carbon steel and sticky material.

Finishing-Medium

XQ

Wide chip control range and sharp cutting performance. Suitable for low carbon steel and sticky material.

Applicable Chipbreaker Range (D.O.C. Indicates Radius)



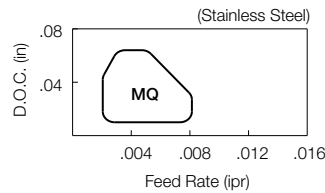
Stainless Steel

Finishing

MQ

Good chip evacuation at internal turning. Small curled chips. Prevents chip entanglement with toolholder and stabilizes surface roughness.

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



Finishing-Medium

AH

Positive chip groove and good chip control with low cutting forces. Polished surface reduces adhesion.

Finishing-Medium

A3

Large rake angle, smooth chip flow and less adhesion. Sharp edge and good surface finish.

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

