

Chipbreaker Selection (Negative Insert)

Steel

1 Molded Chipbreaker

B



Insert (Turning)

Cutting Range	Name	Design	Advantages	Cutting Range	Name	Design	Advantages
Finishing (With Wiper Edge)	WP		Wiper Insert. Double feed rate is available at finishing to light cutting, while maintaining a smooth finish.	Finishing-Medium	CQ		Good chip control at varied ap such as copying. Applicable to up facing.
Finishing-Medium (With Wiper Edge)	WQ		Wiper Insert. Double feed rate possible while maintaining a smooth finish. High efficiency and good chip control.	Finishing-Medium (Up Facing)	CJ		Improved chip curing at small cutting and high feed rate machining. Improved chip evacuation at copying and up facing.
Finishing	GP		Finishing to light cutting. Good chip control.	Medium-Roughing	GS		Strong edge chipbreaker. Stable at continuous machining and light interrupted cutting.
Finishing-Medium	HQ		Sharp cutting performance and wide range chip control with 3-D rake angle and double projection design.	Medium-Roughing	CS		Strong edge chipbreaker for general purpose machining. Stable at continuous machining and light interrupted cutting.

● Applicable Chipbreaker Range

