

Chipbreaker Selection (Negative Insert)

Cast Iron

B



Insert (Turning)

Cutting Range	Name	Design	Advantages
Sharp Cutting Oriented	Standard		Standard chipbreaker for continuous to light interrupted machining of cast iron. (Low cutting force)
	C		High feed rate chipbreaker for continuous to light interrupted machining of cast iron.
	ZS		Standard chipbreaker for light interrupted to interrupted machining of cast iron. (High stability)

Cutting Range	Name	Design	Advantages
Stability Oriented	No Chipbreaker		High feed rate chipbreaker for light interrupted machining of cast iron.
	GC		Chipbreaker for heavy interrupted machining of cast iron.

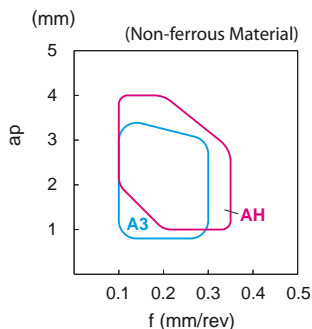
Non-ferrous Materials

Cutting Range	Name	Design	Advantages
Finishing-Medium	A3		Large rake angle and smooth surface. Good chip control and less adhesion.

Cutting Range	Name	Design	Advantages
Medium-Roughing	AH		Polished chipbreaker. Smooth chip control and less adhesion.

G Class: Sharp Edge Prep.
M Class: Honing Edge Prep.

Applicable Chipbreaker Range



A3 Chipbreaker	
	ap=2mm f=0.2mm/rev
	ap=2mm f=0.3mm/rev

AH Chipbreaker	
	ap=2mm f=0.2mm/rev
	ap=2mm f=0.3mm/rev