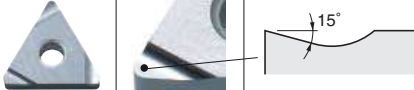

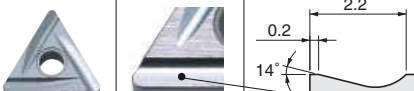
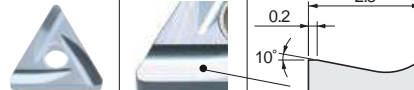
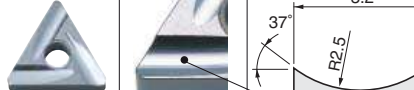


Steel

2 Ground Chipbreaker

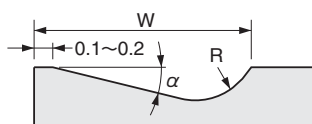
Cutting Range	Name	Design	Advantages
Finishing	S		Sharp edge and less cutting force. Good chip control and smooth chip evacuation.
Finishing-Medium	B		Suitable for general purpose machining at feed rate 0.15 to 0.25mm/rev.
Medium-Roughing	C		Suitable for general purpose machining at feed rate 0.20 to 0.35mm/rev.

Cutting Range	Name	Design	Advantages
Roughing	D		Suitable for general purpose machining at feed rate 0.30 to 0.45mm/rev.
Medium-Roughing / Low Cutting Resistance	25R		Applicable to sticky material such as low carbon steel. Large rake angle and suitable for stainless steel.

● Effectiveness of ground chipbreaker

- ① Lower cutting force and improve edge
- ② Improved adhesion resistance
- ③ Improved dimension accuracy and finishing surface accuracy
- ④ Controlled chip evacuation direction

● Specification of B, C, D and Parallel ground chipbreaker



Insert Type	Size	Chipbreaker Name	W	α	R
CNGG	09,12	Without Indication (Similar to C)	2.2	14°	1.0
WNGG	06	Without Indication (Similar to C)	2.2	14°	1.0
TNGG	11,16	B	1.5	14°	0.5
	16,22	C	2.2	14°	1.0
	16,22	D	2.8	10°	1.5
DNGG	11,15	Without Indication (Similar to C)	2.5	14°	2.0
VNGG	16	Without Indication (Similar to B)	1.5	14°	0.5
SNGG	09,12	B	1.5	14°	0.5
	12	C	2.2	14°	1.0

● Applicable Chipbreaker Range

