

Chipbreaker Selection (Positive Inserts)

Steel

2 Ground Chipbreaker

B

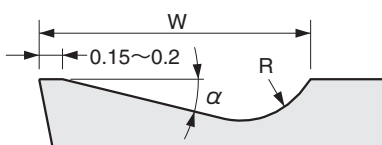


Insert (Turning)

Cutting Range	Name	Design	Advantages
Finishing	A		Large rake angle and low cutting force. Narrow chipbreaker width and consistent chip control.
	B		General purpose for light cutting range. Good balance between chip control and sharp cutting.

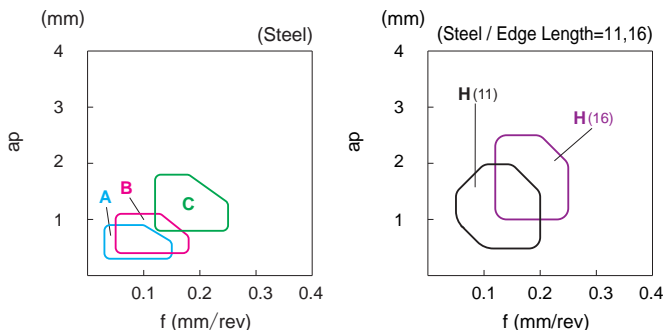
Cutting Range	Name	Design	Advantages
Medium cutting	C		Applicable to high load cutting. Good chip flow and less resistance.
	H		Sharp cutting performance and small curled chips.

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



Insert Type	Size	Chipbreaker Name	W	α	R
TPGR	11	A	1.0	17°	0.5
	11,16	B	1.5	14°	0.5
	16	C	2.2	14°	1.0
SPGR	09	Without Indication (Similar to B)	1.5	14°	0.5
	12	Without Indication (Similar to C)	2.2	14°	1.0

● Applicable Chipbreaker Range



Stainless Steel

Cutting Range	Name	Design	Advantages
Finishing	MQ		Good chip evacuation at internal turning. Small curled chips. Prevents chip entanglement with toolholder and stabilizes surface roughness.

● Applicable Chipbreaker Range

