Chipbreaker Selection (Negative Insert)

B

Insert (Turning)

■ Stainless Steel

Cutting Range	Name	Design	Advantages
Finishing	MQ	23° / 15°	Large rake angle and circular edge line. Low cutting force and good chip control.
Medium-Roughing	MS	0.25 / 12° / 19° — 0.25 / 9° / 19°	Superior cutting edge sharpness and strength achieved by a positive land. Extra strength of cutting edge inhibits damage from wall shouldering.
Medium-Roughing	MU	15° / 15°	Large rake angle reduces cutting force. Less burring achieved by diminishing damage from notching.
Medium-Roughing	TK	13° / 9°	Smooth chipbreaker geometry improves chip flow with less adhesion. Large curled chips.
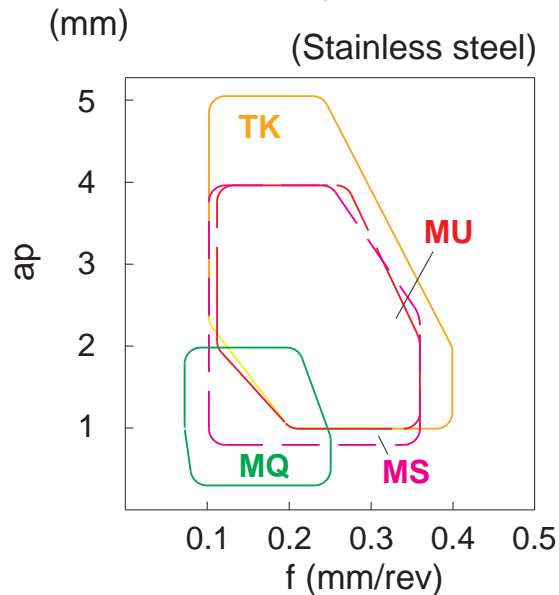
Cutting Range	Name	Design	Advantages
Finishing	GU	0.15 / 20° / 5°	Sharp cutting performance and low cutting force due to 3-D rake angle. Applicable to small shaft cutting.
Medium-Roughing	HU	0.2 / 20° / 20°	Sharp cutting performance and strong edge due to 3-D rake angle. Applicable to small shaft cutting.
Medium-Roughing	ST	14°	Less cutting force due to large rake angle. Less notching by special design.

● Applicable Chipbreaker Range

(mm)

(Stainless steel)

HU   ST

ap

GU

0.1 0.2 0.3 0.4 0.5

f (mm/rev)

● Applicable Chipbreaker Range

(mm)

(Stainless steel)

TK

MU

ap

MQ   MS

0.1 0.2 0.3 0.4 0.5

f (mm/rev)

B6