

Chipbreaker Selection (Negative Insert)

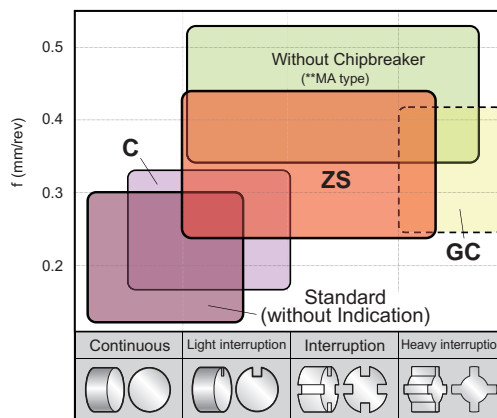
Cast Iron

B
Insert (Turning)

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

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

Chipbreaker Selection (Negative Insert)

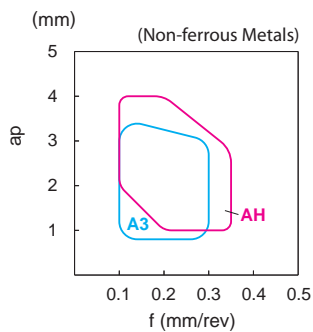


Non-ferrous Metals

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: Horning Edge Prep.

● Applicable Chipbreaker Range (ap indicates radius)



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