

Chipbreaker Selection (Positive Inserts)


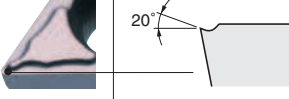

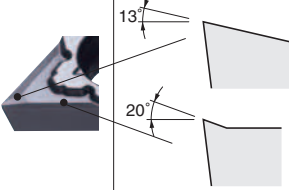

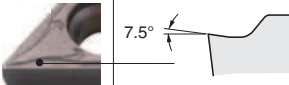



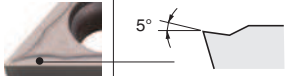



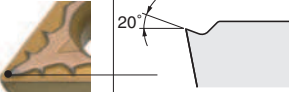

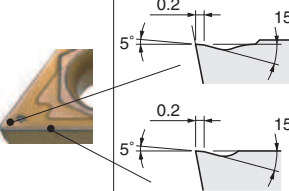

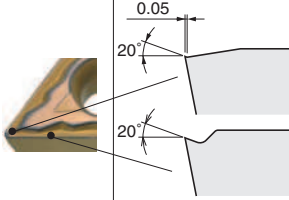

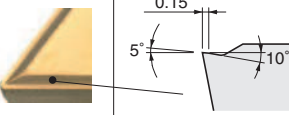

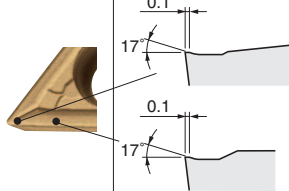


Steel

1 Molded Chipbreaker

B



Insert (Turning)

Cutting Range	Name	Design		Advantages	Cutting Range	Name	Design		Advantages
Minute ap	CF			Available for minute ap (0.02 to 0.2mm) finishing.	Finishing	CK			Good cutting performance. Applicable without hand for two direction cutting on automatic lathe.
Finishing	GF			Dot located close to ridge line of cutting edge on corner. Chips fragmented in small pieces in cutting of small ap.	Finishing	GP			Good chip control at finishing. Applicable to sticky material like low carbon steel, pipe material.
Finishing-Medium	GQ			Enables cutting over a wide range of conditions by using the optimum chipbreaker width according to the cutting depth.	Finishing	DP			Consistent chip breaking performance for finishing.
Finishing	XP			Wide chip control range and sharp cutting performance. Suitable for low carbon steel and sticky material.	Finishing-Medium	HQ			General purpose chipbreaker for medium cutting.
Finishing-Medium	XQ			Wide chip control range and sharp cutting performance. Suitable for low carbon steel and sticky material.	Medium	G			Chipbreaker for short chips at medium cutting.
Finishing-Medium	GK			Good chip evacuation at wide range by breaker dot and wide chip pocket.	Medium	Standard (Without Indication)			Strong edge chipbreaker for medium cutting range.