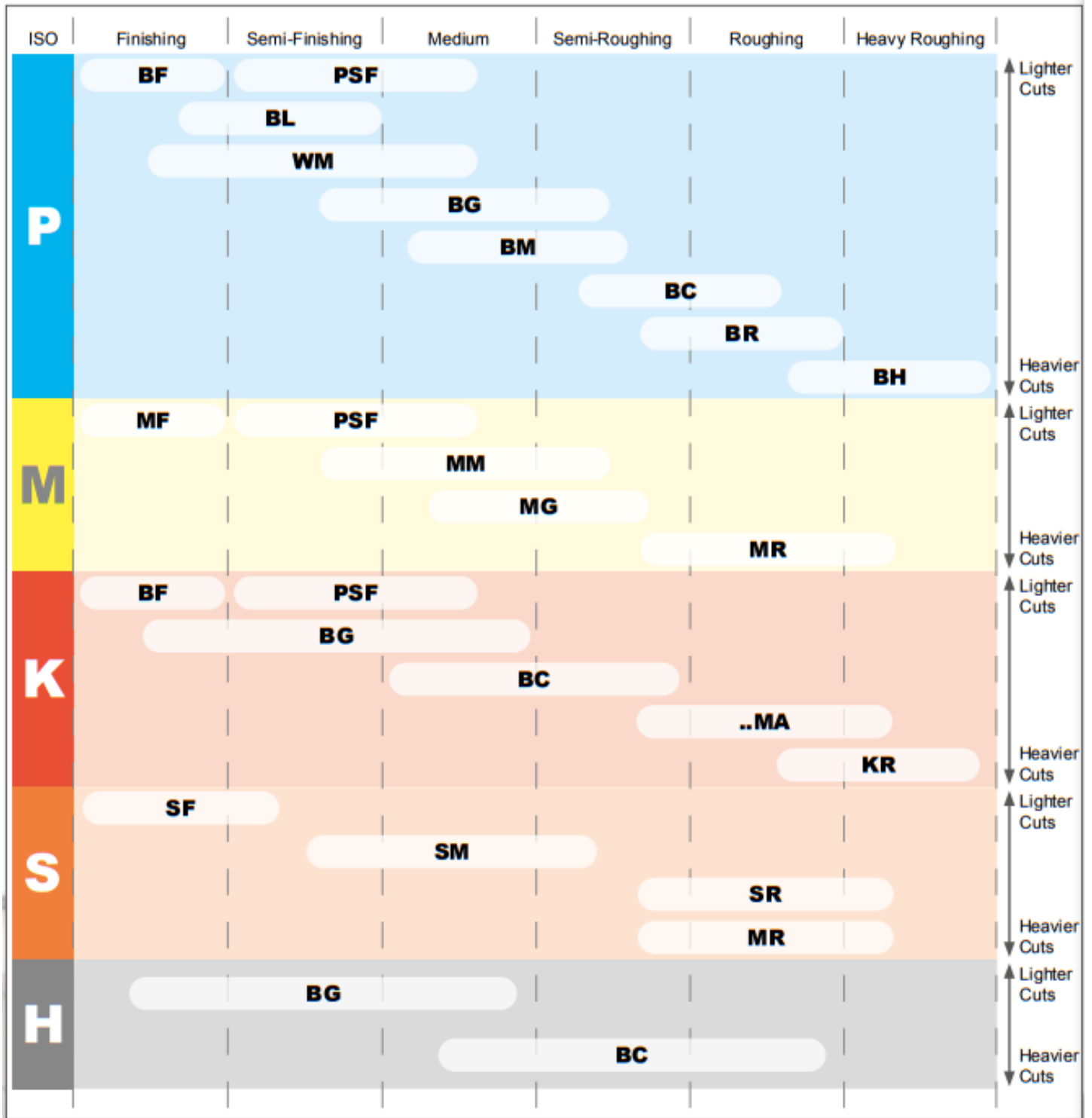


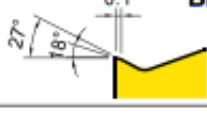
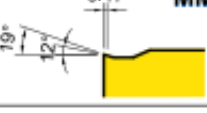
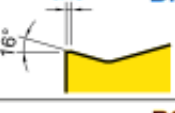

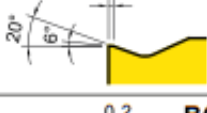

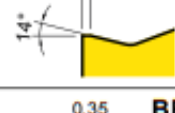
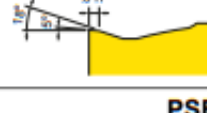

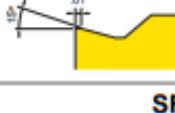

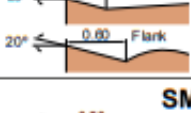



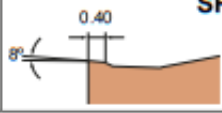


# NEGATIVE CHIPBREAKER GUIDE



# NEGATIVE CHIPBREAKER GUIDE

P	M	K	N	S	H	NEGATIVE		P	M	K	N	S	H	NEGATIVE	
●	○						<b>BF</b> Finishing	●							<b>MF</b> Finishing of stainless steel
●							<b>BL</b> Light cutting and sticky materials	●							<b>MM</b> Medium cutting of stainless steel
●							<b>BM</b> Medium cutting and unstable conditions	●							<b>MG</b> Medium to difficult conditions in stainless steel and HRSA
●	○	●			●		<b>BG</b> Medium cutting First choice	●					●		<b>MR</b> Roughing of stainless steel and scale/skin HRSA
●		●			●		<b>BC</b> Cast iron and medium roughing of steel	●	○						<b>WM</b> Wiper geometry for improved surface finish in steel
●		●					<b>BR</b> Roughing and interrupted cut	●	●	●					<b>PSF</b> Cermet chipbreaker for semi-finishing to semi-medium cuts
●		●					<b>BH</b> Heavy roughing						●		<b>SF</b> Finishing of clean HRSA material
		●					<b>--MA</b> Cast iron heavy roughing Flat insert type		○				●		<b>SM</b> Medium cutting of clean HRSA material
		●					<b>KR</b> Cast iron heavy roughing and interrupted cut		○				●		<b>SR</b> Roughing of clean HRSA material

# INSERT GRADE APPLICATION AREA

The charts below indicate grade selection in relation to cutting speed and feed rate

