

A

Negative inserts

Finishing

Turning

SF P M K



Double sided chip breaker with good chip control. Suitable for finishing and medium machining of steel and cast iron.

B

DF P K



Milling

Double sided chip breaker with good chip control. Suitable for finishing and medium machining of steel and cast iron.

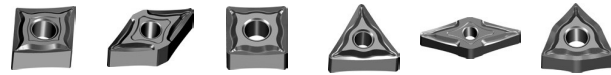
C

ADF P M



Drilling

EF M S



Double sided chip breaker with sharp cutting edge and large rake angle for finishing of stainless steel.

D

NF S M



Technical Information

Double sided chip breaker with ground cutting edge and large rake angle for finishing. E-tolerance for high repeatability.

E

NGF S M

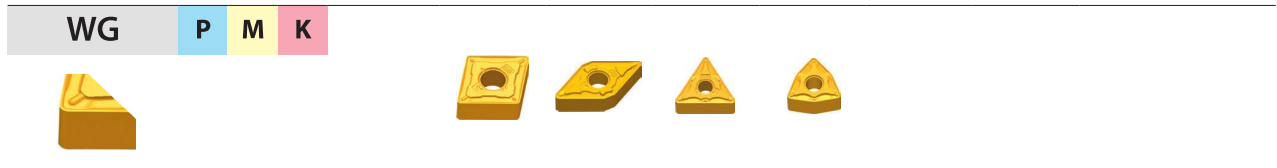


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Double sided chip breaker with ground cutting edge and large rake angle for finishing. E-tolerance for high repeatability.

Negative inserts

Wiper



Double sided chip breaker with wiper geometry. Allows to double the feed rate and improves the surface quality.

Medium machining



Double sided chip breaker for medium machining. Wide range of application due to excellent balance of sharpness and cutting edge stability.



Double sided chip breaker for medium machining. Wide range of application due to stable cutting edge and large rake angle. Very suitable for machining of steel.



Double sided chip breaker for medium machining. Wide range of application in steel and cast iron.



Double sided chip breaker with surrounding cutting edge. Process reliable machining due to highest cutting edge stability.

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Turning

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A

Negative inserts

Medium machining

NM S M



Double sided chip breaker with ground cutting edge and large rake angle for medium machining of heat-resistant materials.

Turning

B

EM M S



Double sided chip breaker with sharp cutting edge and large rake angle. Process reliable medium machining of stainless steel.

Milling

C

EG M S



Double sided chip breaker with ground cutting edge and large rake angle. Wide range of application for medium machining of stainless steel.

Drilling

D

Basic P K



Double sided chip breaker with surrounding cutting edge for universal machining of steel and cast iron.

Technical Information

Roughing

DR double sided P K



Double sided chip breaker with positive rake angle and stable cutting edge for light to medium roughing of steel and cast iron.

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Negative inserts

Roughing

DR single sided **P** **K**



Single sided chipbreaker with positive rake angle and stable cutting edge for light to medium roughing of steel and cast iron.

LR **P** **M**



Single sided chip breaker with curved cutting edge and unique bumpy geometry. Low cutting pressure for process reliable machining. Light roughing of steel and stainless steel.

ER double sided **M** **S**



Double sided chip breaker with large rake angle for low cutting forces. Suitable for roughing of stainless steel.

ER single sided **M** **S**



Single sided chip breaker with large rake angle for low cutting forces. Suitable for roughing of stainless steel.

HDR **P** **K**



Single sided chip breaker with high cutting edge stability and deformation resistance. Excellent for roughing with high cutting depths in steel and stainless steel.

HPR **P** **K**



Single sided chip breaker with high cutting edge stability and large chip space. Excellent for heavy roughing in steel and cast iron.

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Negative inserts

Roughing

Flat **K**



Double sided insert without chip breaker. Stable cutting edge design, due to missing microgeometry. Excellent for roughing in cast iron.

Turning

B

SNR **S M**



Double sided chip breaker for roughing. Wide range of application due to excellent balance of sharpness and cutting edge stability.

Milling

PCBN & PCD inserts

Flat **N H**



With brazed CBN or PCD cutting edge. For machining of hardened steel (CBN) or non-ferrous metals (PCD).

C

Drilling

Flat **H K**



Solid CBN insert for machining of steel and cast iron.

D

Technical Information

Ceramic inserts

Flat **K H**



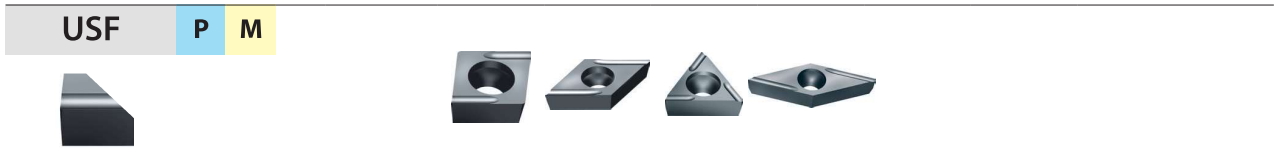
Ceramic inserts for machining of low hardened steel and cast iron.

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Positive inserts

Fine-finishing

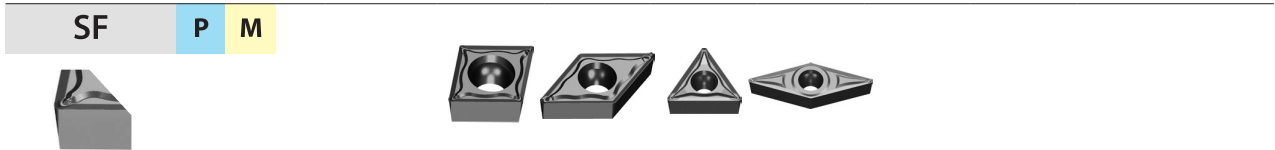


Single sided chip breaker for fine finishing. Sharp cutting edge with large hollow flute, excellently suitable for machining small work pieces. G-tolerance for high repeatability.

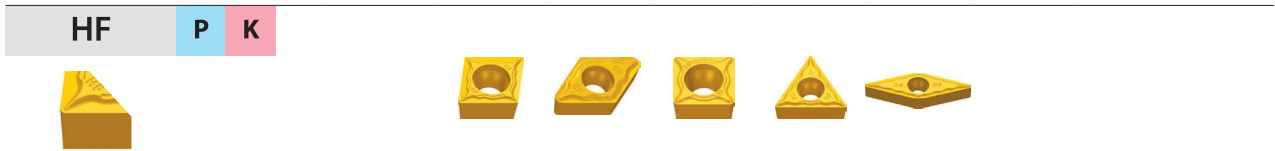
Finishing



Single sided chip breaker for fine finishing. Excellent for high surface quality. G-tolerance for high repeatability.



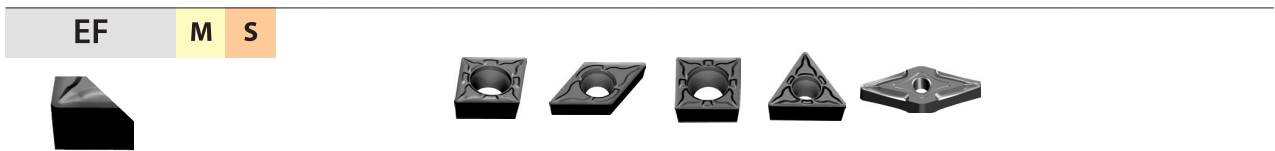
Single sided chip breaker in combination with cermet grades. Geometry with high sharpness for improved chip control and great surface quality. Ideal for machining with small cutting depths and feed rates.



Single sided chip breaker with good chip control. Suitable for finishing to medium machining of steel and cast iron.



Ground, single sided chip breaker with good chip control. Wide range of application due to excellent balance of sharpness and cutting edge stability.



Single sided chip breaker with sharp cutting edge and large rake angle for finishing of stainless steel.

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Positive inserts

Finishing

NF M S



Turning

Single sided chip breaker with ground cutting edge and large rake angle for finishing. E-tolerance for high repeatability.

B

NGF M S



Milling

Single sided chip breaker with ground cutting edge and large rake angle for finishing. E-tolerance for high repeatability.

Medium machining

TC K P



Drilling

Single sided chip breaker with encircling cutting edge. Process reliable machining due to highest cutting edge stability.

HM P K



D

Single sided chip breaker for medium machining. Wide range of application due to excellent balance of sharpness and cutting edge stability.

Technical Information

EM M S



Single sided chip breaker with sharp cutting edge and large rake angle. Process reliable medium machining of stainless steel.

E

Basic P K

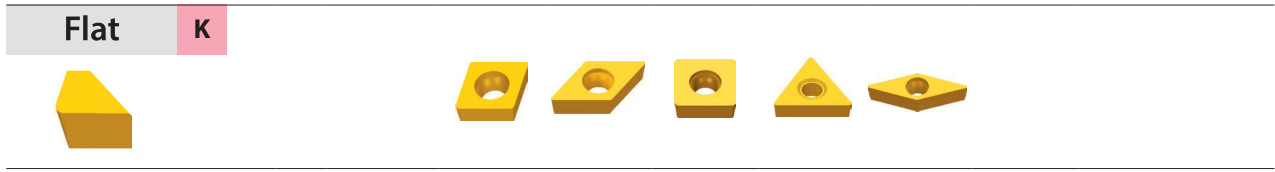


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Single sided chip breaker with encircling cutting edge for universal machining of steel and cast iron.

Positive inserts

Roughing



Single sided insert without chip breaker. Stable cutting edge design due to missing microgeometry. Excellent for roughing in cast iron.



Single sided chip breaker with positive rake angle and stable cutting edge for light to medium roughing of steel and cast iron.

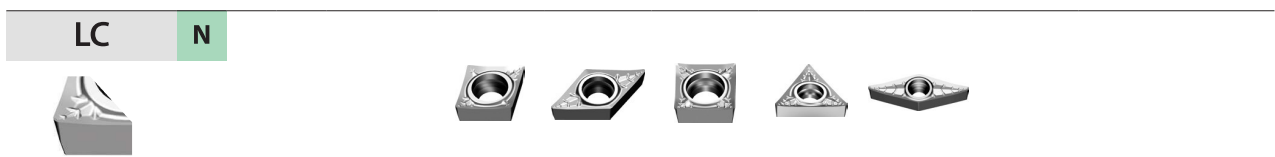


Single sided chip breaker for roughing. Wide range of application due to excellent balance of sharpness and cutting edge stability.



Single sided chip breaker with encircling cutting edge for universal machining of steel and cast iron.

Aluminium machining



Single sided chip breaker with excellent cutting edge design. Sharp cutting edge with positive rake angle. G-tolerance for high repeatability.

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Positive inserts

Aluminium machining

LH N



Single sided chipbreaker for machining of cast aluminium alloys. Sharp cutting edge with positive rake angle. G-tolerance for high repeatability.

B
Milling

PCBN & PCD inserts

Flat N H



With brazed CBN or PCD cutting edge. For machining of hardened steel (CBN) or non-ferrous metals (PCD).

C
Drilling

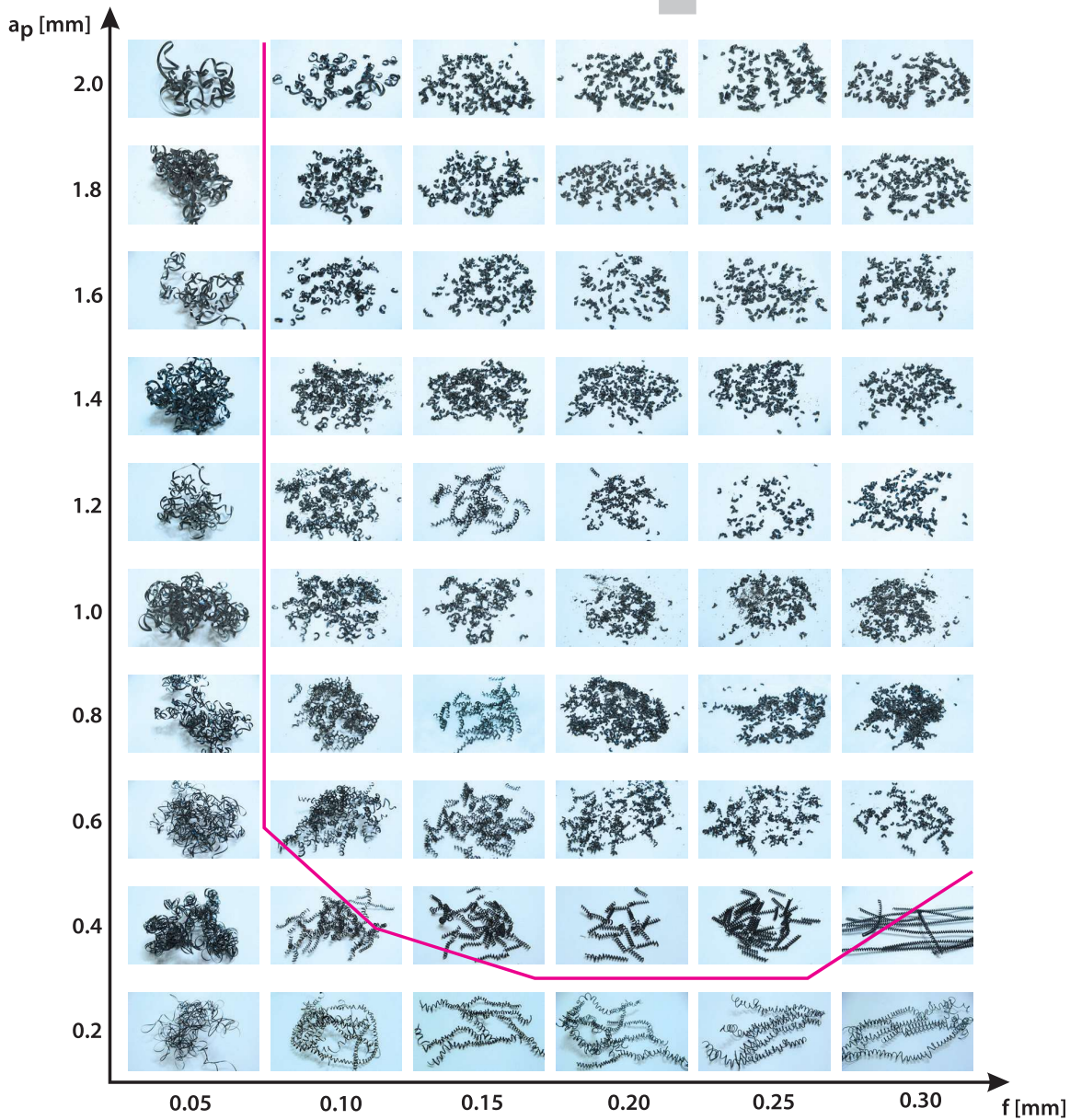
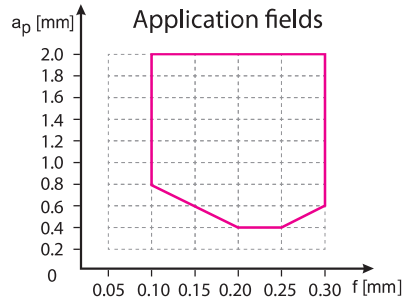
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General turning

Application fields of chip breakers determination

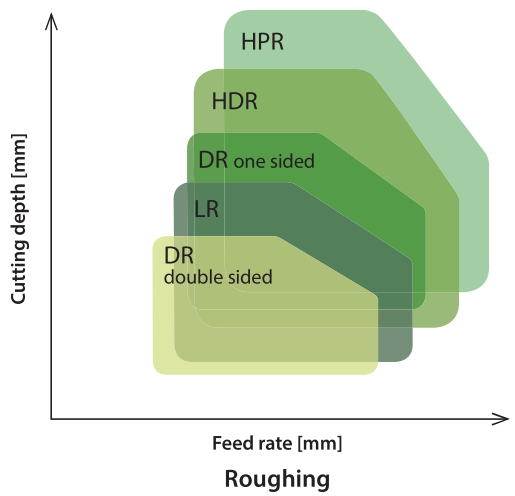
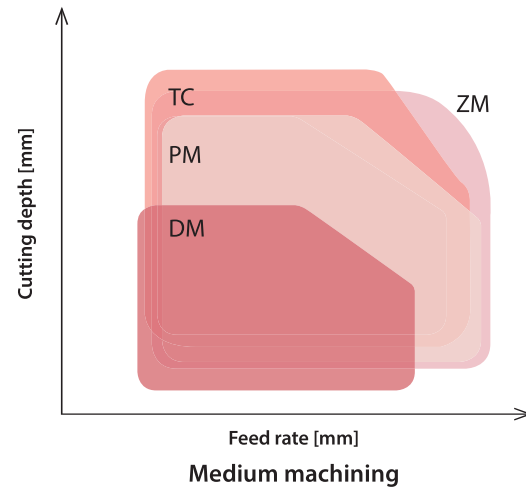
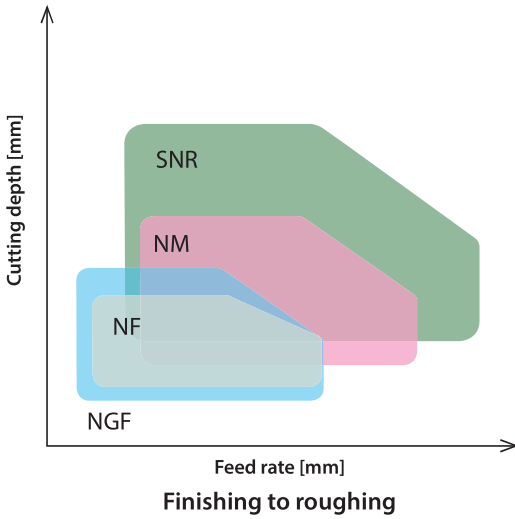
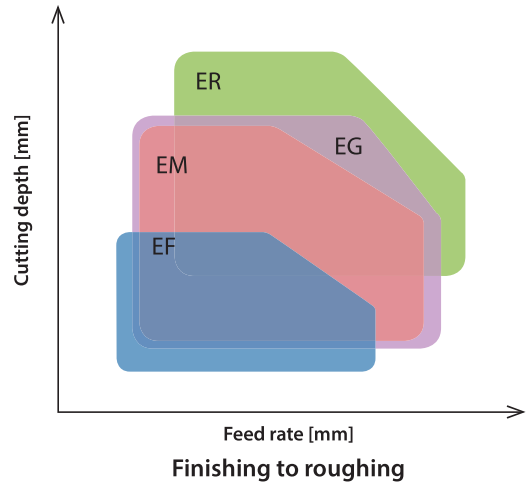
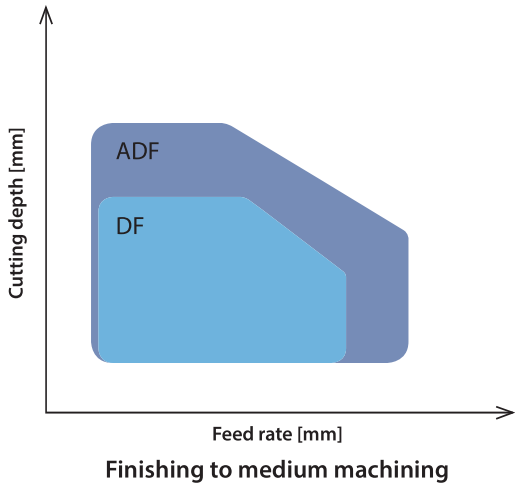
Example
 Insert: CNMG120408-DF
 Holder: PCLNL2525M12
 Material: C 45 steel
 V_c : 200 m/min



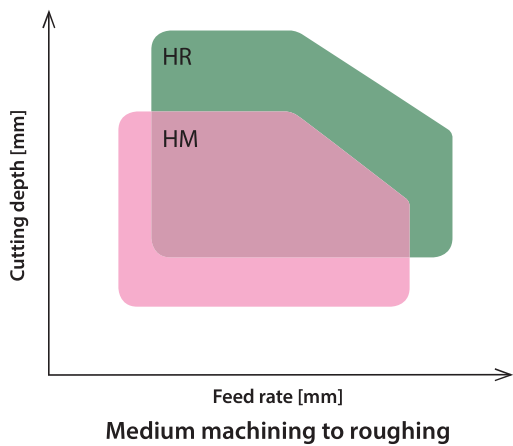
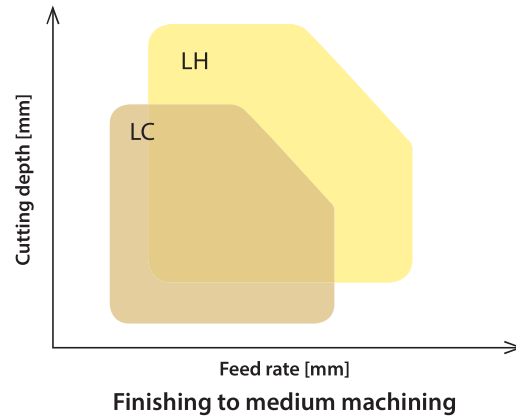
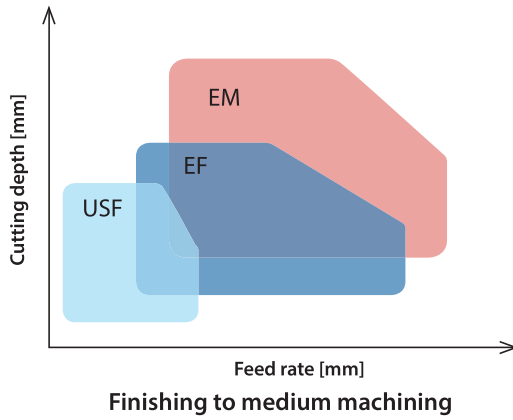
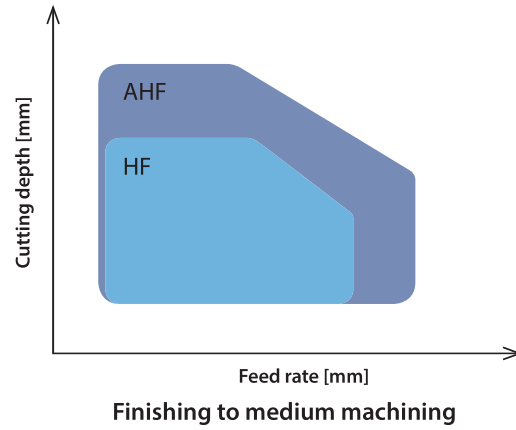
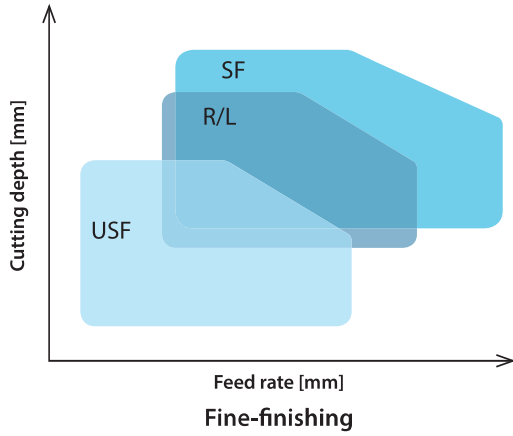
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