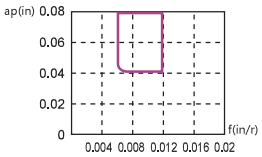
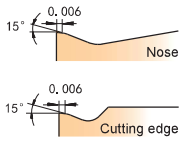
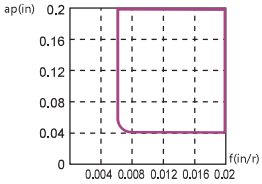
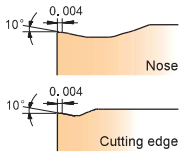
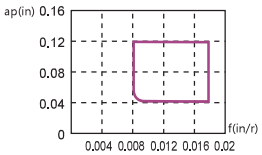
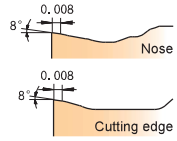
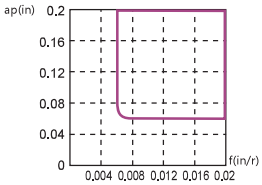
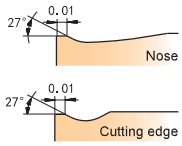
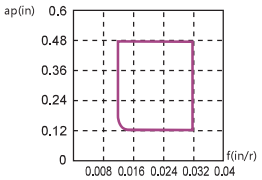
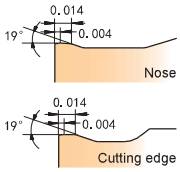
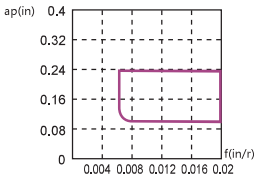
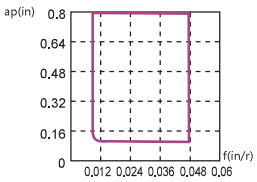
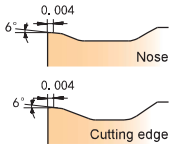
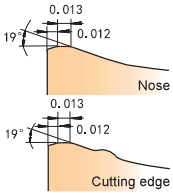
A

Introduction of chip-breakers

Negative inserts with a hole

Application / Chipbreaker	Precision	Recommended cutting parameters	Chipbreaker profile	Feature/Shape of insert
For semi-finishing				
NM	M			**Recommended chipbreaker for semi-finishing S-kind materials** Double-side chipbreaker with M-class tolerance with good capability to prevent wear and work-hardening when machining low-machinability rated metals.Possesses higher feed and depth of cut capability than NF chipbreaker.
WGM	M			**Wiper chipbreaker for semi-finishing** Double-sided chipbreaker with M-level tolerance, semi-finishing chipbreaker with wiper designed, perfect combination of good wiper result and sturdy cutting edge structure, which perfectly meet the requirement of high efficiently and good surface quality.
EM	M			**Recommended chipbreaker for semi-finishing M-kind materials** Double-side chipbreaker with M-class tolerance serves to reduce cutting force and workpiece adhesion when machining stainless steel. Possesses higher feed and depth of cut capability than EF chipbreaker.
Conventional Chipbreaker	M			**For machining P-kind, M-kind, K-kind materials from semifinishing to roughing** Double-side chipbreaker with M-class tolerance has good cutting edge toughness with wide application area. Unfavorable chip control compared to dedicated chipbreakers.
Light-load roughing				
DR Double-side	M			**Recommended chipbreaker for light-load roughing of P-kind and K-kind materials** Double-side chipbreaker with M-class tolerance for light roughing, higher metal removal rate, and greater cutting edge security.
For roughing				
ER Single/ Double side	M	 	Double-side  Single-side 	**Recommended chipbreaker for roughing M-kind materials** Single/Double side chipbreaker with M-class tolerance has good impact-resistance.The chipbreaker's cutting edge is designed to balance security and sharpness.High performance is achieved by reducing edge build-up and reducing heat when roughing stainless steel.