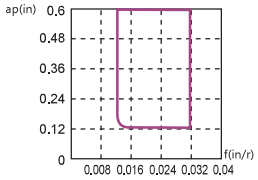
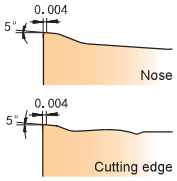
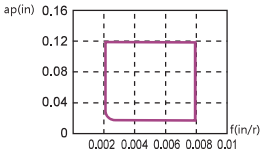
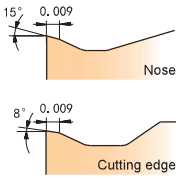
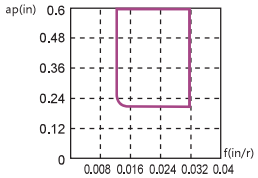
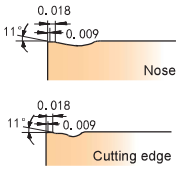
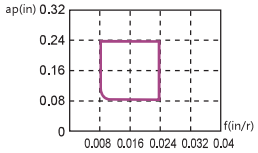
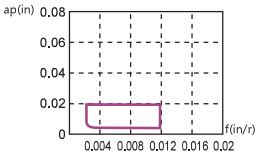
Introduction of chip-breakers

Negative inserts with a hole

Application / Chipbreaker		Precision	Recommended cutting parameters	Chipbreaker profile	Feature/Shape of insert
For roughing	DR Single-side	M			**Recommended chipbreaker for roughing P-kind materials** Single-side chipbreaker with M-class tolerance has high security on cutting edge for higher removal rates and low cutting force at large cutting depth and high feed rates.
For roughing	SNR	M			**Recommended chipbreaker for S-material high efficiency roughing** M-level double-sided chipbreaker perfectly combines sharpness and strength of the cutting edge, with small cutting resistance and high edge strength can effectively reduce groove wear. SNR is recommended chipbreaker for high depth roughing of S- materials.
Heavy-load machining	HDR	M			**Recommended chipbreaker for heavy-load machining P-kind materials** Single-side chipbreaker with M-class tolerance has high strength and security on cutting edge, with strong capability to prevent plastic-deformation under high metal removing rate.
Cast iron machining	Without chipbreaker (flat top)	M			**For machining cast iron** Double-side with M-class tolerance has high cutting edge strength to effectively machine through workpiece imperfections, such as sand pockets in cast iron.
Super hard inserts	Without chipbreaker (flat top)	G			**For machining non-ferrous metal and high-hardness material** G-class tolerance is the best choice for machining nonferrous metals with high-hardness materials by soldering PCBN and PCD onto cemented carbide substrate.

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