

Chip breaker for turning

			Application range													
Geometry		Cutting edge	feed rate fn (n										4.0	4.0 6.3		Features
	-		0.1	0.16	0.25	0.4	dep	oth of c			4.0	6.3	10.0		13	
	VL VL		0.1	0.10		0.10~			1.0	2.3	4.0	0.3	10.0			For Finishing Stable chip control in high toughness material; low carbon steel, pipe steel & steel plates Improved chip control for facing, copy machining and better surface finish
V series	VB					0	.15~0.45	5~2.0								For Finishing Improved chip control for smaller depth of cuts
	VF															Excellent chip control in copying, corner R machining For Finishing
					0.05	~0.35	0.5~	1.5								Good chip control quality on varied depth of cut Excellent cutting edge strength has been acquired due to the special chip-breaker
	VC					0.1	2~0.45									For Medium to finish cutting
	The Colonial Colonia							0.5~3	3.5							Stable chip control in copying and internal machining with various depths of cut
	VQ					0.10	~0.40									For Medium to finish cutting
	T. Carlotte							1	1.0~3	.0						Medium to finishing cutting edges offer improved edge hardness For cermet
	VM					0.10	0~0.50									For Medium cutting
									1.0	-5.0						Wide available chip control range from medium-finishing to medium-roughing Suitable chip breaker for CNC machining
	VH								0.70	70~1.	1.40			~15.0		For Heavy duty cutting
													6.0~			Designed specifically for heavy machining Specialized chip breaker for the heavy industries like Ship building, Power plant industry
	VT								0.	.75~1	.60					For Heavy duty cutting
													7.0~	-17.0		Designed specifically for heavy machining Specialized chip breaker for the heavy industries like Ship building, Power plant industry
	VP1			0.05~0.20											For Finishing	
					0).1~1.5	5									High positive cutting edge Reduced contract chip minimizes temperature to improve tool life
	VP2				0.0	05~0.4	0									For Medium to finish cutting
								0.5	-4.0							Stable chip control and high machinability in copying with various depths of cut

