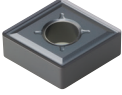

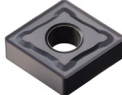

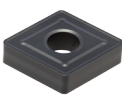

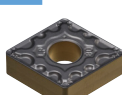

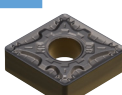













Chip breaker for turning

Geometry	Cutting edge	Application range											Features										
		feed rate f_n (mm/rev)																					
		0.04	0.063	0.10	0.16	0.25	0.4	0.63	1.0	1.6	2.5	4.0		6.3									
depth of cut a_p (mm)																							
											0.1	0.16	0.25	0.4	0.63	1.0	1.6	2.5	4.0	6.3	10.0	11.6	13
V series	VP3			0.05~0.45 0.5~4.5											<p>For Medium cutting</p> <ul style="list-style-type: none"> High positive cutting edge with wide land Stable cutting performance in interrupted machining with high toughness Stable machinability and chip control in machining with high depth of cut 								
	VP4			0.15~0.45 1.0~4.5											<p>For Roughing</p> <ul style="list-style-type: none"> The first recommended chip breaker for inconel cutting High hard and resistant rake angle to prevent notch wear in roughing of rugged surfaces 								
	VR			0.25~0.55 1.2~7.0											<p>For Roughing</p> <ul style="list-style-type: none"> High feed machining with the combination of wide land and pockets Shallow chip breaker design prevents chip blocking at high feed Decreased wear on major cutting edge due to special treatment on blade 								
-P series	LP			0.10~0.40 0.5~2.5											<p>For Medium to finish cutting</p> <ul style="list-style-type: none"> Angle land decreases cutting resistance for better surface roughness Special dot design prevents chip blocking by clear chip breaking 								
	MP			0.15~0.45 0.5~4.5											<p>For Medium cutting</p> <ul style="list-style-type: none"> Increased productivity due to excellent chip control in various conditions Stable tool life by reducing cutting load at high speed and high feed 								
-M series	MM			0.12~0.45 0.5~5.5											<p>For Medium cutting</p> <ul style="list-style-type: none"> The first recommended chip breaker for continuous stainless applications cutting Improved tool life and surface finish due to dual lands combining both machinability and toughness Wide chip pockets for stable chip evacuation at high depth of cuts and high feeds 								
	RM			0.15~0.55 2.0~6.0											<p>For Roughing</p> <ul style="list-style-type: none"> The first recommended chip breaker for interrupted cutting or roughing of stainless steel Inhibited notch wear and burr creation at high depth of cuts and feeds Reduced cutting loads and longer tool life at high feeds 								
-K series	MK			0.10~0.50 1.0~5.0											<p>For Medium cutting</p> <ul style="list-style-type: none"> Suitable for continuous cutting of ductile and gray cast iron Excellent tool life and surface finish thanks to angle lands improving cutting performance 								
	RK			0.20~0.60 1.5~6.0											<p>For Roughing</p> <ul style="list-style-type: none"> Suitable for machining ductile and gray cast iron at high speeds and high feeds Improved toughness and chipping resistance due to flat lands 								
H series	HA			0.03~0.30 0.5~2.5											<p>For Medium to finish cutting</p> <ul style="list-style-type: none"> Sharp cutting edge generates low cutting force Specially designed tough main cutting edge Suitable for cutting of low carbon steel, stainless steel, aluminum 								

Notice: Application ranges are based on main cutting material

