Chip breaker for turning

	Geometry	Cutting edge	Application range (feed rate fn (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 ap (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)	Features
G series	GR		0.30~0.80 3.0~8.0	**For Roughing** • Suitable for deep depth of cut and high feed cutting of steel and cast iron • Suitable for intermittent cutting
G series	GH		0.30~1.30 3.0~11.0	**For Heavy duty cutting** • Suitable for heavy duty cutting due to strong cutting edge • Wide chip control range with low cutting force
B series	B25		0.50~1.00 4.0~10.0	**For General cutting** • Suitable for general cutting condition cutting
V-Posi series	VF		0.05~0.25 0.1~1.5	**For Finishing** • Improved surface finish and size accuracy due to stable inner boring
V-Posi series	VL		0.05~0.20 0.1~1.0	**For Finishing** • Superior chip control in low carbon steel, pipes, and steel plates
V-Posi series	VP1		0.01~0.25 0.1~1.5	**For Finishing** • Excellent chip control in application with micro depth of cut and low feed • Low cutting load and superb surface finish • Optimal for both internal and external machining
H-Posi series	HMP		0.08~0.40 0.5~3.5	**For Medium cutting** • Excellent chip control at wide range of cutting conditions • Machining versatility over a wide range of materials
C-Posi series	C25		0.10~0.35 1.0~3.0	**For Roughing** • Suitable for interrupted cutting and cast iron machining • Good surface finish due to low cutting force • Suitable for both boring and outer diameter turning
P-Posi series	MP		0.05~0.30 0.3~3.0	**For Medium cutting** • Sharp cutting edge and wide chip pocket for low cutting load • Stable chip control at varying depth of cuts • Excellent cutting performance when machining automobile components
AL series	AK		0.03~0.40 0.1~4.0	**For Medium to finish cutting** • High rake angle and low resistance cutting edge secures long tool life in continuous cutting of aluminum turning • High speed of finishing operation

Notice: Application ranges are based on main cutting material