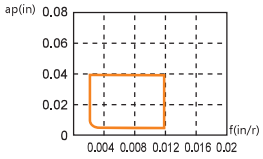
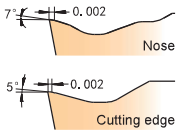
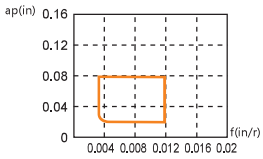
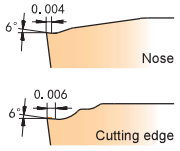
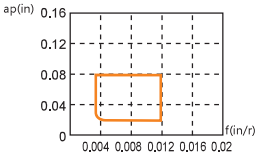
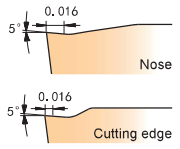
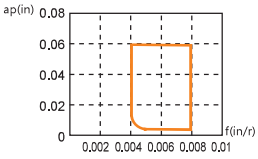
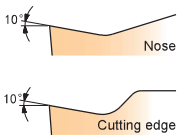
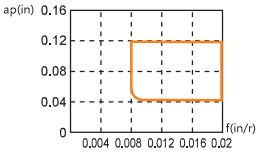
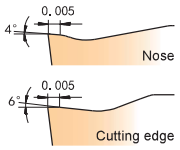
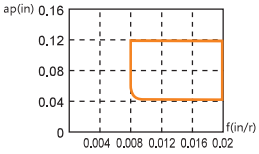
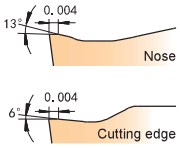
A

Introduction of chip-breakers

Positive inserts with a hole

Application / Chipbreaker	Precision	Recommended cutting parameters	Chipbreaker profile	Feature/Shape of insert
For extra finishing — SF	G			**First choice for finish machining** G-class tolerance is recommended for precision finishing.
For finishing — HF	M			**Chipbreaker for finishing with wide application** With M-class tolerance suitable for internal and external finishing machining for various materials such as steel and cast iron etc.
For finishing — EF	M			**Recommended chipbreaker for finishing M-kind materials** M-class tolerance; sharp cutting edge suitable for finishing materialsas stainless steel and soft steel, etc. where edge build-up is problem.
For finishing — NGF	E G			**Recommended chipbreaker for S-material general finishing** E, G grade accuracy, for inner hole finishing of S materials.
For semi-finishing — HM	M			**Chipbreaker for semi-finishing with wide application** M-class tolerance; suitable for boring and o.d. semi-finishing materials, like steel and cast iron etc.
For semi-finishing — EM	M			**Recommended chipbreaker for semi-finishing M-kind materials** M-class tolerance; higher toughness on cutting edge than EF chipbreaker for higher feed and depth of cut.