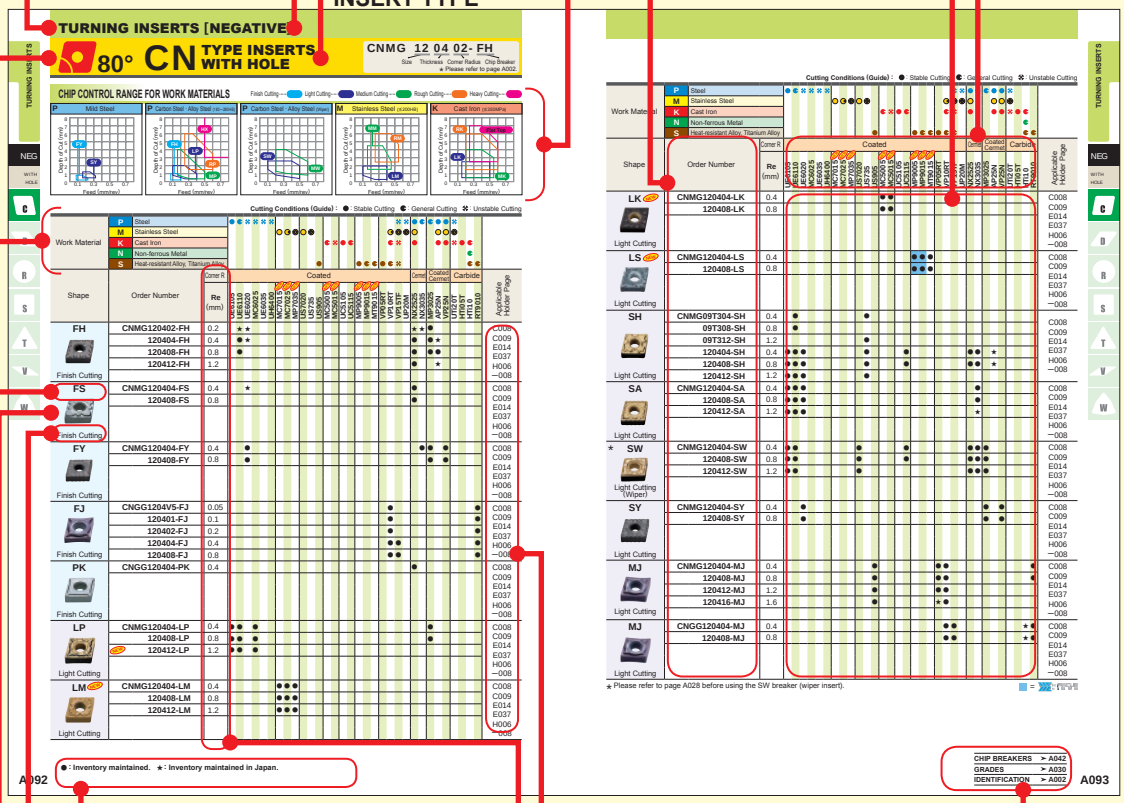
HOW TO READ THE STANDARD OF TURNING INSERTS

●How this section page is organised

①Organised according to turning insert shape.
(Refer to the index on the next page.)
②Inserts are arranged in order of :
• Negative inserts (with hole→without hole)
• Positive inserts (with hole→without hole)
③Breakers are arranged in order of :
Finish Cutting→Light Cutting→Medium Cutting →Rough Cutting→Heavy Cutting

●Graph of chip control by work material

Shows recommended chip breakers and chip control range according to work material and cutting application.
Graphs are coloured according to cutting applications (Finish→Light→Medium→Rough→Heavy) and contain recommended breakers for each application.

Finish Cutting : Light Cutting : Medium Cutting :
Rough Cutting : Heavy Cutting :