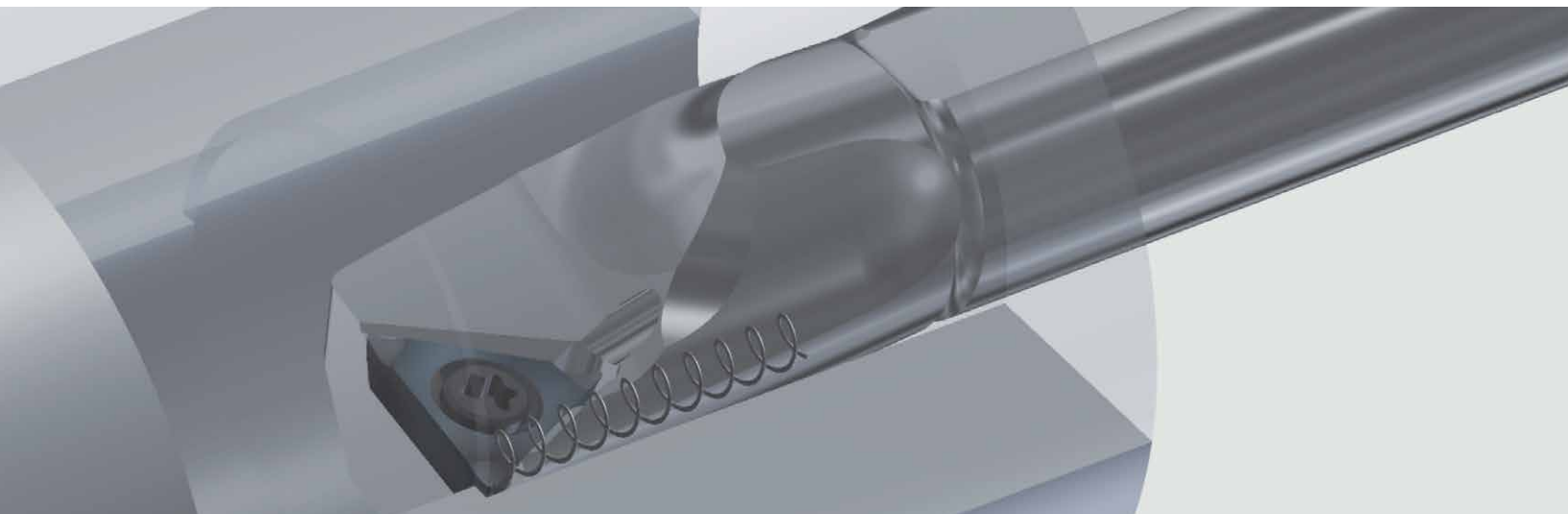




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# P Chipbreaker

Ground Chipbreaker for Boring



Stable Chip Evacuation Towards the Outside of the Workpiece

Special ground chipbreaker controls direction of chip evacuation

The combination with Dynamic Bars provide better solutions for boring

Right-hand insert for right-hand holders

Left-hand insert for left-hand holders

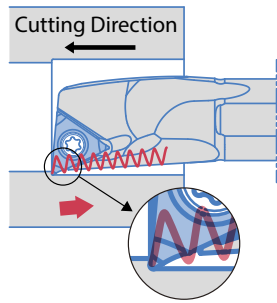
\*WBET insert: Left-hand insert for right-hand holder



# Special Chipbreaker Shape Ensures Good Chip Evacuation Towards the Outside of the Workpiece

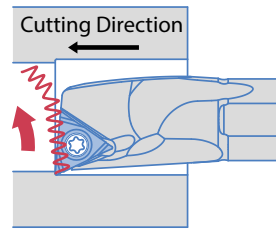
## Chip Control

### P Chipbreaker



Smooth chip evacuation towards the outside of workpiece

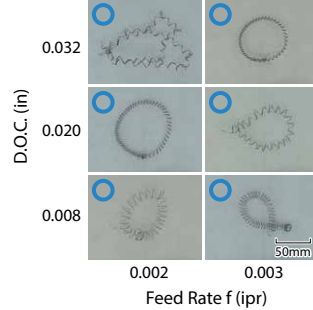
### Conventional Ground Chipbreaker



Clogged chips often occur due to chip flow towards the inside of the workpiece

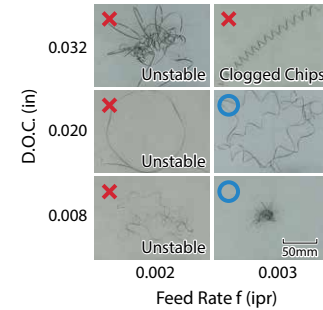
## Chip Control Comparison (Internal Evaluation)

### P Chipbreaker



Stable chip control

### Competitor A (Ground Chipbreaker)

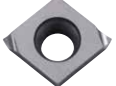
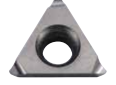



Unstable chip control

Increasing cutting conditions causes clogged chips

Cutting Conditions :  $V_c = 330$  sfm, Wet Workpiece : 304  
Inserts : TP □ □ Type

## Positive Inserts

Shape	Part Number	Dimensions (in)				Relief Angle	MEGACOAT NANO	
		I.C.	Thickness	Hole	Corner-R (rε)		PR1425	PR1535
 Right-Hand Shown	CCET 32502M <sup>R/L</sup> -P	3/8	5/32	Ø.173	<0.004	7°	○	○
	32505M <sup>R/L</sup> -P				<0.008		○	○
	3251M <sup>R/L</sup> -P				<1/64		○	○
 Right-Hand Shown	TPEH 151502M <sup>R/L</sup> -P	3/16	3/32	Ø.091	<0.004	11°	○	○
	151505M <sup>R/L</sup> -P				<0.008		○	○
	15151M <sup>R/L</sup> -P				<1/64		○	○
	TPEH 181502M <sup>R/L</sup> -P	7/32	3/32	Ø.126	<0.004	11°	○	○
	181505M <sup>R/L</sup> -P				<0.008		○	○
	18151M <sup>R/L</sup> -P				<1/64		○	○
 Left-Hand Shown	TPEH 2202M <sup>R/L</sup> -P	1/4	1/8	Ø.130	<0.004	11°	○	○
	2205M <sup>R/L</sup> -P				<0.008		○	○
	221M <sup>R/L</sup> -P				<1/64		○	○
	*WBET 151502M <sup>R/L</sup> -P				3/16		3/32	Ø.091
151505M <sup>R/L</sup> -P	<0.008	○	○					
15151M <sup>R/L</sup> -P	<1/64	○	○					

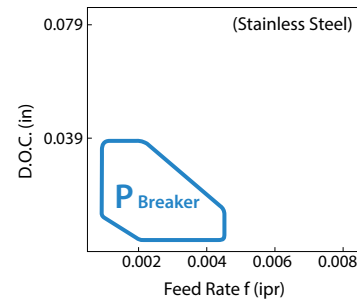
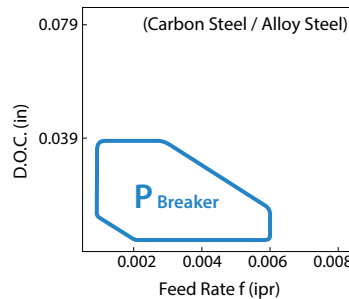
Inserts with corner-R (rε) dimension shown with less than sign (i.e. <0.004, <0.008) indicate models with minus tolerance for corner-R (rε) ○ : World Express (Shipping: 7-10 Business Days)

R-hand Insert for R-hand Toolholder, L-hand Insert for L-hand Toolholder

\*WBET Type: L-hand Insert for R-hand Toolholder

## Recommended Cutting Conditions

Workpiece	Recommended Grade	MIN - Recommendation - MAX
		Cutting Speed $V_c$ (sfm)
Carbon Steel / Alloy Steel	PR1425	200 - 390 - 660
Stainless Steel	PR1535	200 - 330 - 590



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