





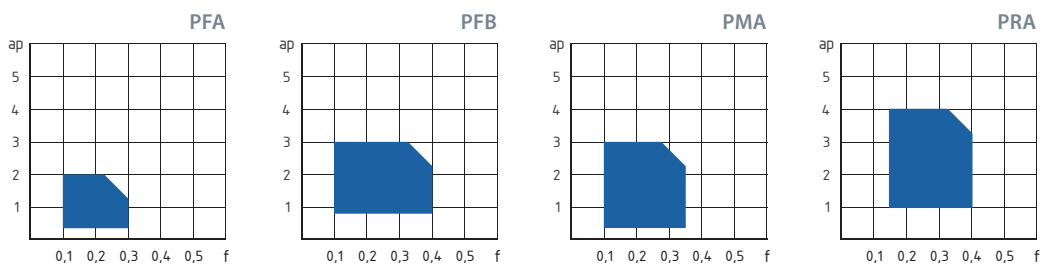


## Chip breakers – specification



### CHIP BREAKERS FOR STEEL (CVD coating)

name		machining	application and features
PFA		finishing	First choice for steel finish turning. Larger chip pocket prevents increased cutting resistance and ensures good chip control. Adequate geometry of chip breaker improves the durability of cutting edge. first choice: <b>P</b> second choice: <b>M K</b>
PFB		finishing	Chip breaker for universal applications. Characterised by strong cutting edge combined with classic breaker geometry. Suitable for a wide range of applications with thickness of depth to be cut from 0.8 to 3 mm. first choice: <b>P</b> second choice: <b>K</b>
PMA		medium	Chip breaker designed for medium and finish turning of steel. Optimised breaker geometry provides good chip control over a wide range of cutting depths. first choice: <b>P</b> second choice: <b>M K</b>
PRA		roughing	Chip breaker used in double-sided inserts. Its innovative, three-dimensional surface provides good chip control in case of medium and large allowance, in a wide range of materials. First choice for HPC applications. first choice: <b>P</b> second choice: <b>M K</b>


Depth of cut **ap** [mm] / feed **f** [mm/rev]



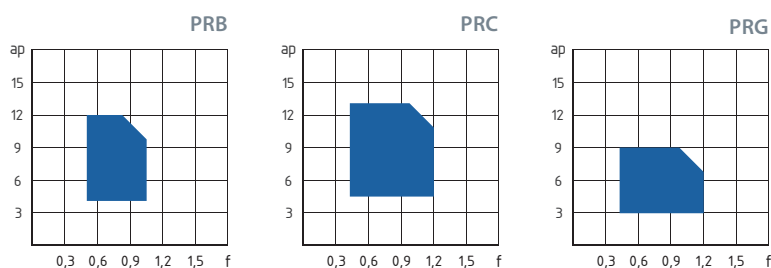
### CHIP BREAKERS FOR STEEL (inserts size 19 and 25, CVD coating)

name		machining	application and features
PRB		roughing	Chip breaker for roughing under medium and heavy conditions. Reinforced cutting edge improves the insert durability and enables easier cutting. The breaker guarantees high performance in multiple applications. first choice: <b>P</b> second choice: <b>K</b>
PRC		roughing	Chip breaker for medium and rough cutting of steel and cast iron. Optimum breaker geometry ensures good chip breaking regardless of the cross-section of layer to be cut. first choice: <b>P</b> second choice: <b>K</b>






<b>PRG</b>		roughing	<p>Chip breaker used in single-sided inserts with negative geometry. Designed for rough cutting of steel and cast iron. Its reinforced cutting edge guarantees stable process at cutting depths from 3 to 9 mm.</p> <p>first choice: <b>P</b>    second choice: <b>K</b></p>
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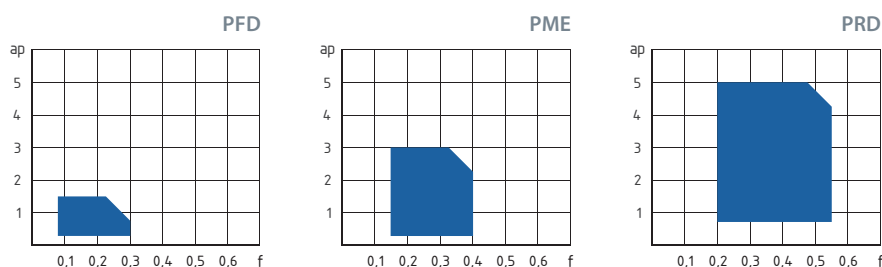
Depth of cut **ap** [mm] / feed **f** [mm/rev]



CHIP BREAKERS FOR STEEL (PVD coating)





name	machining	application and features
<b>PFD</b>	 finishing	<p>Chip breaker for finish turning of steel and stainless steel. Shape of the breaker allows for excellent chip control even at low cutting depths. It also ensures effective chip evacuation in case of ductile materials.</p> <p>first choice: <b>P</b>    second choice: <b>M</b> <b>K</b></p>
<b>PME</b>	 medium	<p>Chip breaker for medium cutting ensuring stable chip control in a wide range of materials. First choice for general-purpose inserts.</p> <p>first choice: <b>P</b>    second choice: <b>M</b> <b>K</b></p>
<b>PRD</b>	 roughing	<p>Chip breaker designed for general roughing applications. Reinforced cutting edge for high-feed operations. Excellent chip control at high cutting depths.</p> <p>first choice: <b>P</b>    second choice: <b>M</b> <b>K</b></p>

Depth of cut **ap** [mm] / feed **f** [mm/rev]

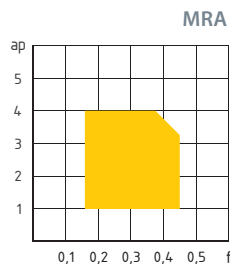
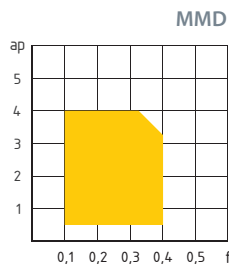
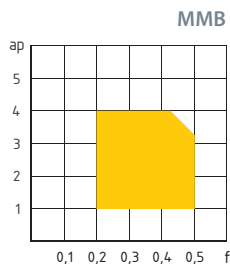
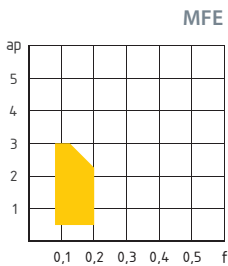






CHIP BREAKERS FOR STAINLESS STEEL (negative inserts, PVD coating)

name		machining	application and features
MFE		finishing	Chip breaker for finish turning of stainless steel. Used with negative inserts. Provides optimum chip control at low cutting depths. first choice: <b>M</b> second choice: <b>P S</b>
MMB		medium	Chip breaker for medium cutting of stainless steel. Properly adjusted rake angle and shape of the breaker ensures good chip control over a wide range of cutting depths and feed rates. first choice: <b>M</b> second choice: <b>P S</b>
MMD		medium	Chip breaker for medium turning of stainless steel and heat-resistant alloys. Used with negative inserts. Ensures excellent chip evacuation regardless of the cross-section of layer to be cut. first choice: <b>M</b> second choice: <b>S</b>
MRA		roughing	Chip breaker for medium and rough cutting of stainless steel and steel. Provides stable chip evacuation in a wide range of materials at medium and high cutting depths. first choice: <b>M</b> second choice: <b>P S</b>



Depth of cut **ap** [mm] / feed **f** [mm/rev]



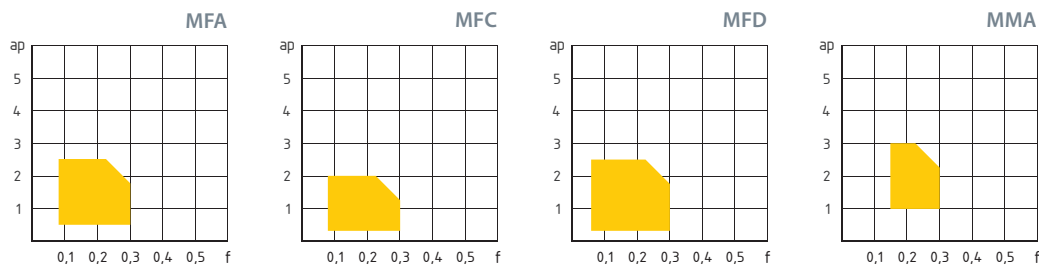
CHIP BREAKERS FOR STAINLESS STEEL (positive inserts, PVD coating)

name		machining	application and features
MFA		finishing	Chip breaker for finish turning of stainless steel, steel and heat-resistant alloys. High quality of surface and excellent chip evacuation even at low cutting depths. first choice: <b>M</b> second choice: <b>P S</b>
MFC		finishing	Chip breaker for finish turning of stainless steel and heat-resistant alloys. Guarantees the highest quality of surface and stable chip evacuation at low cutting depth. first choice: <b>M</b> second choice: <b>P S</b>





<b>MFD</b>		finishing	<p>Chip breaker for finish turning of stainless steel and heat-resistant alloys. High performance and excellent chip control at low cutting depth.</p> <p>first choice: <b>M</b>    second choice: <b>P S</b></p>
<b>MMA</b>		medium	<p>Chip breaker for medium turning of stainless steel and heat-resistant alloys. Perfect combination of appropriate rake angle and strong cutting edge ensures smooth chip breaking.</p> <p>first choice: <b>M</b>    second choice: <b>S</b></p>

Depth of cut **ap** [mm] / feed **f** [mm/rev]



CHIP BREAKERS FOR HEAT-RESISTANT ALLOYS (PVD coating)

name	machining	application and features
<b>SFA</b>	 finishing	<p>Chip breaker for finish turning of heat-resistant alloys and stainless steel. It allows to achieve high quality of surface and very good chip control at low cutting depth and low feed rates.</p> <p>first choice: <b>S</b>    second choice: <b>M</b></p>
<b>SMA</b>	 medium	<p>Chip breaker for medium cutting of heat-resistant alloys and stainless steel. The breaker geometry prevents the increase of cutting resistance and ensures effective chip evacuation over a wide range of cutting depths and feed rates.</p> <p>first choice: <b>S</b>    second choice: <b>M</b></p>

Depth of cut **ap** [mm] / feed **f** [mm/rev]

