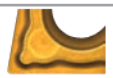
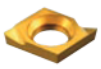
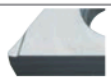
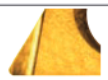
Chipbreakers for Mogul Bar

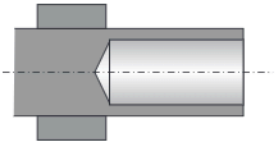
Molded Chipbreakers

Name	Chipbreaker Geometry	Features	ER Style	CC Style	CP Style	TC Style	TP Style
FG		●Evacuate chips BACKWARD at light depth of cut	—	—	—	—	
YL		●Great combination of sharpness and toughness ●Covers extremely wide range ●Excellent chip control	—		—	—	—
CL		●Double-positive geometry ●Sharp edge and low tool pressure ●Very wide chip control range	—		—	—	—
AM3		●Great combination of sharp edge and chip control	—			—	—
AZ7		●Excellent chip control at light feed and light depth of cut	—		—	—	—
ZR		●Covers a wide range of depth of cut under high-speed and low-feed conditions	—		—	—	—
AM5		●Provides both good cutting performance and chip control	—			—	—

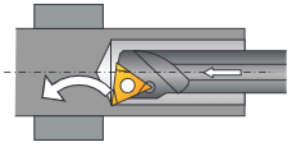
Ground Chipbreakers

Name	Chipbreaker Geometry	Features	ER Style	CC Style	CP Style	TC Style	TP Style
F05・F1		●Exclusively designed for ID boring ●Evacuate chips BACKWARD					
S		●Sharp cutting edge with excellent chip control	—			—	—
U・U1		●Sharp cutting edge prevents work materials from work hardening	—		—	—	—
KHG		●Excellent chip control on finishing cuts ●For super high-precision machining	—		—	—	—
K		●Superb chip control on finishing applications	—	—	—		—
A・A1		●Tough cutting edge and good chip control ●General-purpose ID chipbreaker	—	—		—	—
A2		●Sharp cutting edge due to large rake angle		—	—	—	—
B1・B2・B3		●Stable cutting in boring thanks to sharp and tough cutting edge	—	—	—		

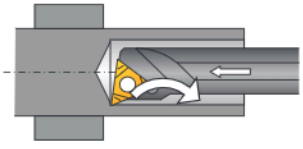
Boring on CNC Swiss-Type Lathes



Blind hole due to bar stock



Typical inserts direct chips forward
Then packed chips damage and break cutting edges



FG, F1 and F05 chipbreakers direct chips backward and prevent cuttting edges from breaking

Note: Use right-hand inserts with FG, F1 and F05 chipbreakers for right-hand boring bars