

THE NEW VALUE FRONTIER



Internal turning
ground chipbreaker

| **P** chipbreaker

P chipbreaker



Stable chip evacuation toward outside of workpiece

Special ground chipbreaker controls direction of chip evacuation

Combination with dynamic bar provides solutions for internal turning

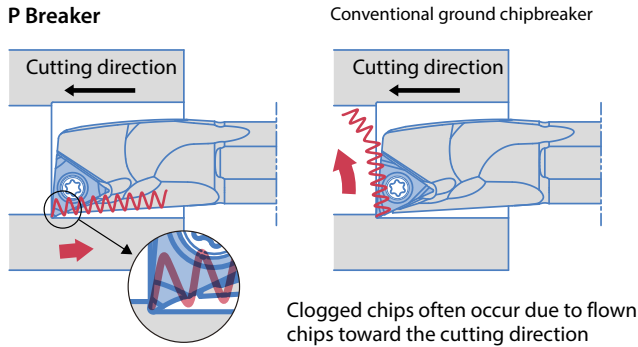
R-hand insert for R-hand toolholder, L-hand insert for L-hand toolholder

*WBET type: L-hand insert for R-hand toolholder



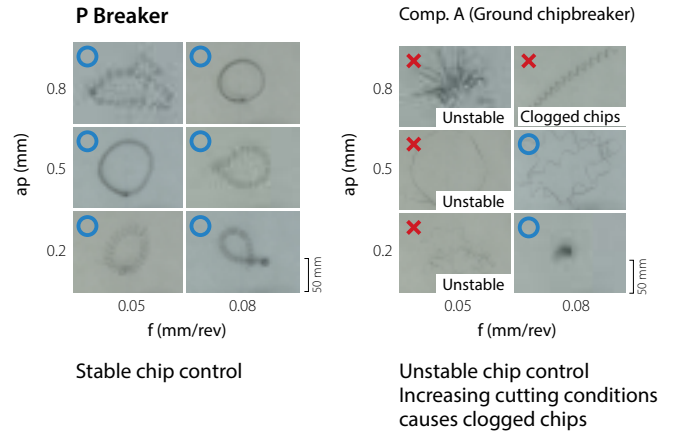
Special chipbreaker shape ensures good chip control toward outside of workpiece

Chip control (Image)



Smooth chip evacuation toward outside of workpiece

Chip control comparison (In-house evaluation)



Cutting conditions: $V_c = 100$ m/min, wet, Workpiece: X5CrNi1810
Inserts: TP □ □ type

Available inserts

Shape	Description	Dimensions (mm)				Relief angle	MEGACOAT NANO	
		I.C.	Thickness	Hole	Corner-R (rε)		PR1425	PR1535
Right-hand (R)	CCET 09T301M R/L-P	9.525	3.97	ø4.4	<0.1	7°	●	●
	09T302M R/L-P				<0.2		●	●
	09T304M R/L-P				<0.4		●	●
Right-hand (R)	TPEH 080201M R/L-P	4.76	2.38	ø2.3	<0.1	11°	●	●
	080202M R/L-P				<0.2		●	●
	080204M R/L-P				<0.4		●	●
	TPEH 090201M R/L-P	5.56	2.38	ø3.2	<0.1	11°	●	●
	090202M R/L-P				<0.2		●	●
	090204M R/L-P				<0.4		●	●
	TPEH 110301M R/L-P	6.35	3.18	ø3.3	<0.1	11°	●	●
	110302M R/L-P				<0.2		●	●
	110304M R/L-P				<0.4		●	●
Left-hand (L)	*WBET 080201M L/R-P	4.76	2.38	ø2.3	<0.1	5°	●	●
	080202M L/R-P				<0.2		●	●
	080204M L/R-P				<0.4		●	●

R-hand insert for R-hand toolholder, L-hand insert for L-hand toolholder
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An insert which corner R(rε) dimension is shown with inequality sign (Ex: <0.1, <0.2) indicates minus tolerance of corner R(rε)

Recommended cutting conditions

Workpiece	Recommended grade	Min. - Recommendation - Max.
		Cutting speed V_c (m/min)
Carbon steel / Alloy steel	PR1425	60 - 120 - 200
Stainless steel	PR1535	60 - 100 - 180

