

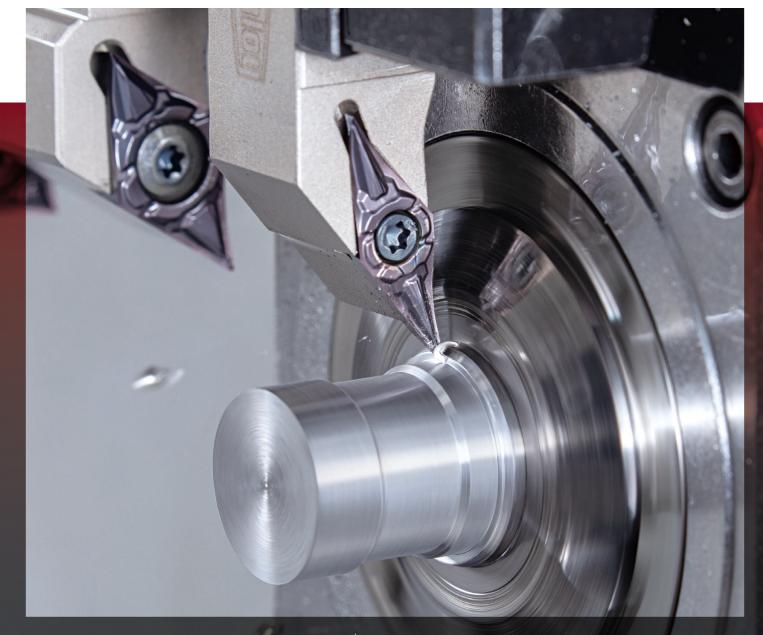


Grades for small parts machining



Tungaloy Report No. 436S2-US

Introducing JP & JS chipbreakers for VPGT inserts dedicated for small part turning applications





SH725

Pressed 3D chipbreaker series for small parts machining

Full lineup of chipbreakers for unrivaled chip control and super surface finishing

I JP First choice chipbreaker for high precision finishing

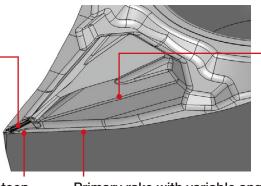


Eliminates chip nesting and other chip-associated issues that impede the shop's productivity and provides stable chip breaking over a wide range of feed rates and D.O.C.

- Effective chip breaking for high part quality
- Versatile geometry designed for a broad application range
- Eliminates burr generation and controls vibration during large depth of cut

A protrusion extending towards the nose radius

Provides excellent chip control in finish to precision finish cutting



Secondary rake with multiple facets Guides and redirects

Guides and redirects chips generated during machining at large depth of cut

Cutting edge with a steep inclination angle

- For better chip evacuation
- For reduced cutting force

Primary rake with variable angles

Controls the generation of burrs and vibration when machining at a large depth of cut capability

IJS First choice chipbreaker for finish cutting



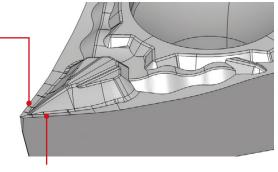


Chipbreaker geometry that allows light cutting action and excellent chip breaking

- A steep cutting edge inclination angle for better chip control and reduced cutting force
- A unique protrusion that extends towards the radius effectively controls chip flow from small to large depth of cut

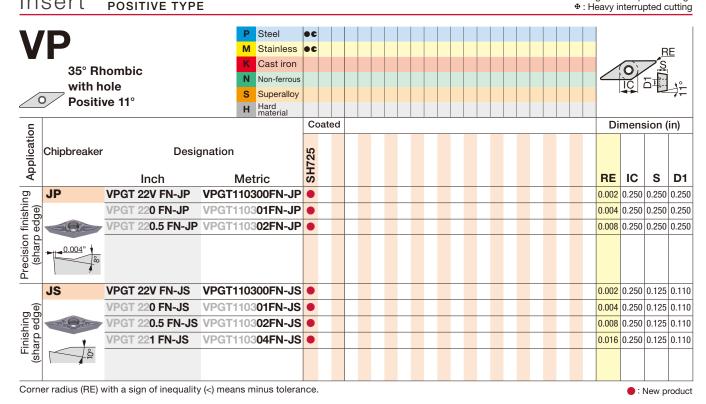
Cutting edge with a steep inclination angle

Provides good chip evacuation and reduced cutting force

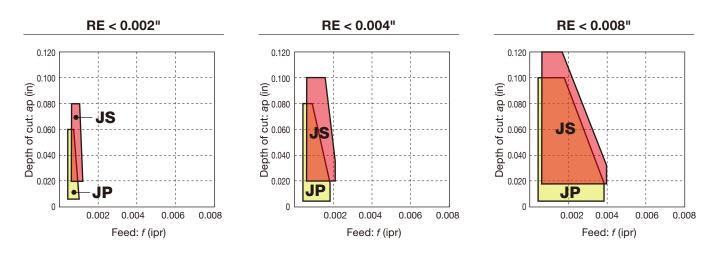


Rake with variable angles and steep protrusion

Provides stable chip control in the small to large depth of cut range and also maintains cutting edge integrity and sharpness over extended period of time



■ Chip control range



STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Chipbreaker	Grade	Cutting speed	Depth of cut		Feed: f (ipr)		
				Vc (sfm)	ap (in)	RE < 0.001"	RE < 0.004"	RE < 0.008"	RE < 0.016"
P	Carbon steel Alloy steel	JP	SH725	33 - 656	0.002 - 0.098	0.0008 - 0.0012	0.001 - 0.002	0.001 - 0.004	-
		JS	SH725	33 - 656	0.020 - 0.118	0.0008 - 0.0012	0.001 - 0.002	0.001 - 0.004	0.002 - 0.008
M	Stainless steel	JP	SH725	33 - 656	0.002 - 0.098	0.0008 - 0.0012	0.001 - 0.002	0.001 - 0.004	-
		JS	SH725	33 - 656	0.020 - 0.118	0.0008 - 0.0012	0.001 - 0.002	0.001 - 0.004	0.002 - 0.008

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