

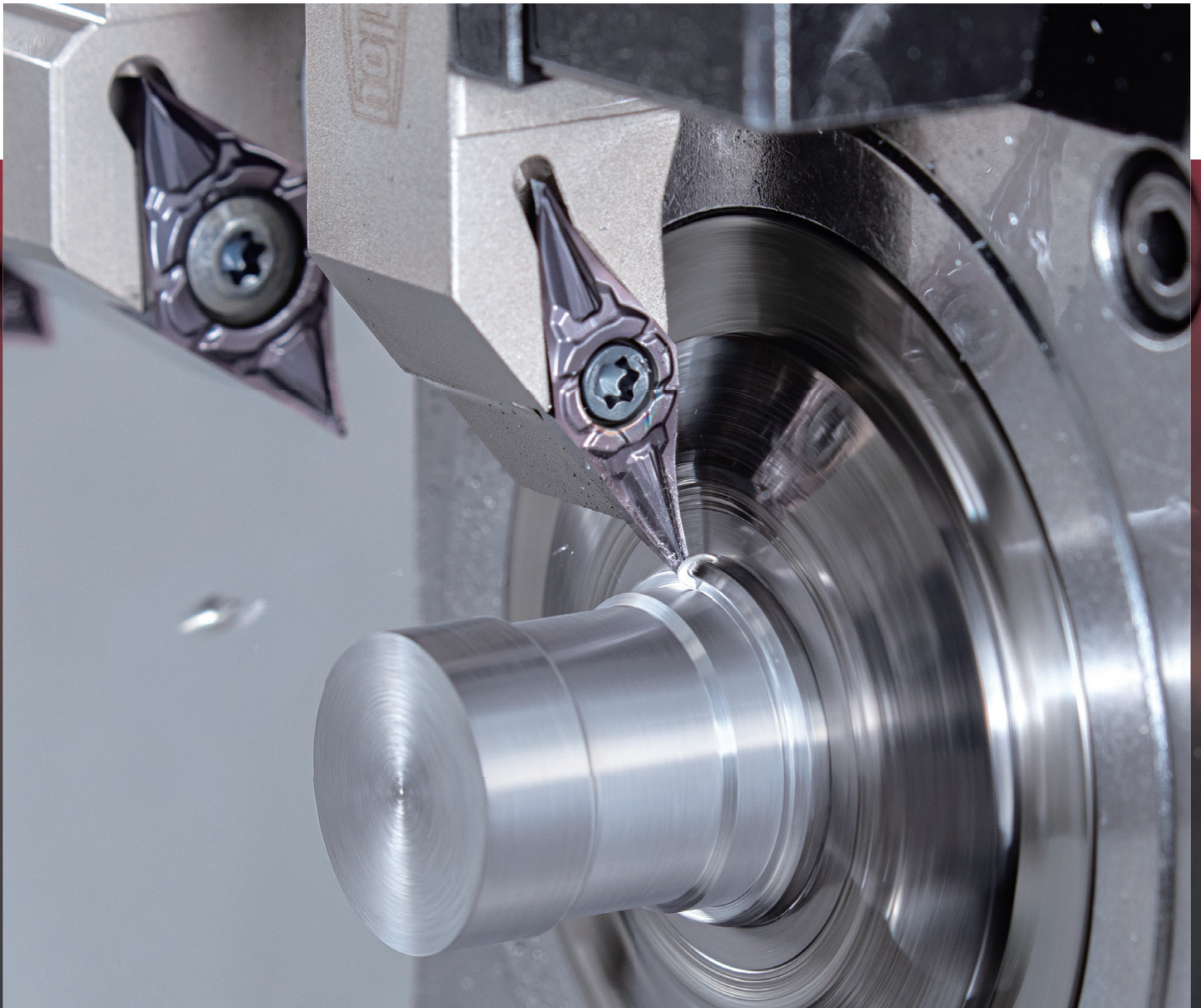


Grades for small parts machining

SH725

Tungaloy Report No. 436S2-G

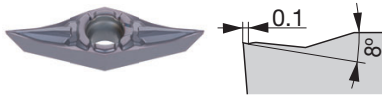
Introducing **JP & JS** chipbreakers for **VPGT** inserts dedicated for small part turning applications



Pressed 3D chipbreaker series for small parts machining

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

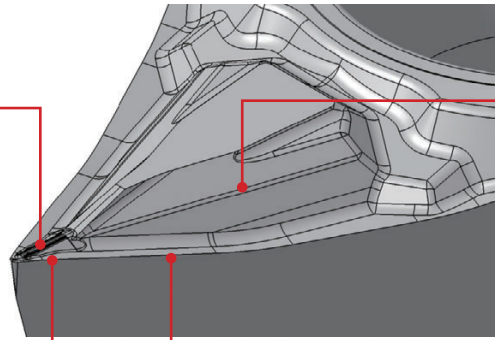
I JP First choice chipbreaker for high precision finishing



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 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

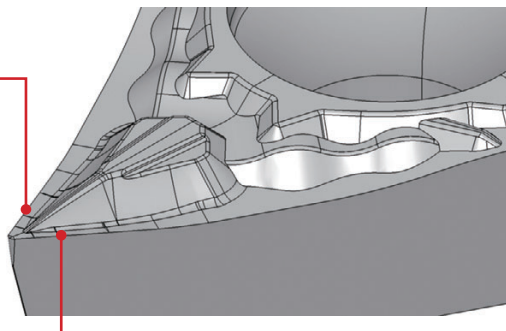
I JS First choice chipbreaker for finish cutting



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

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