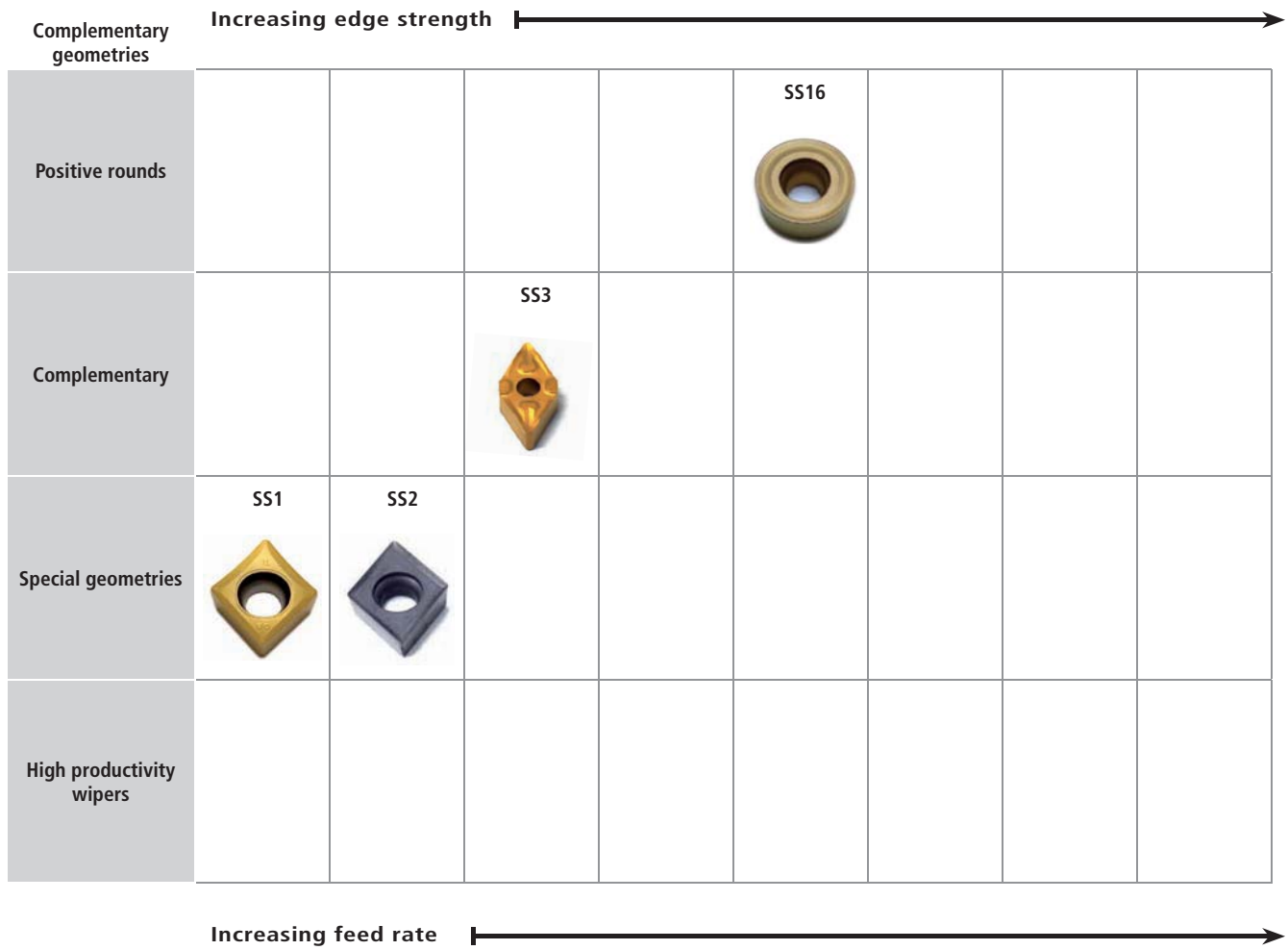

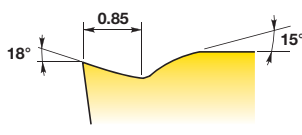
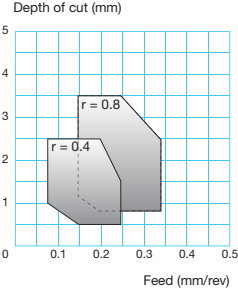
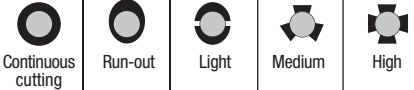

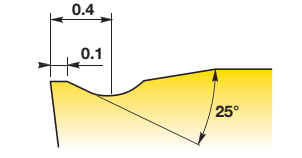
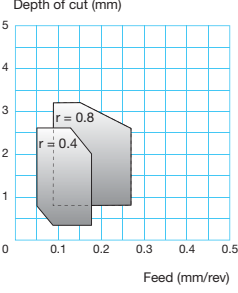
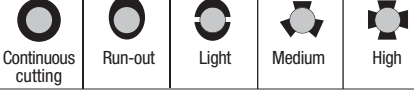

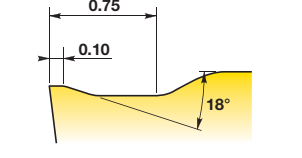
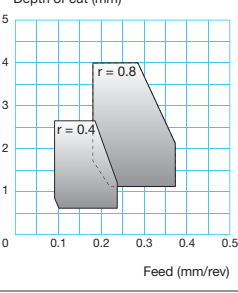
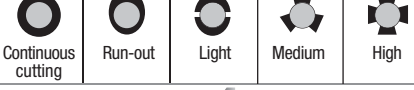

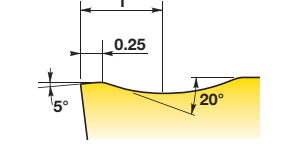
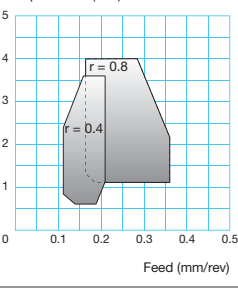
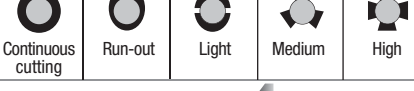

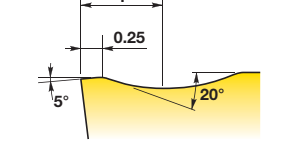
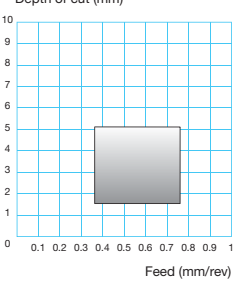
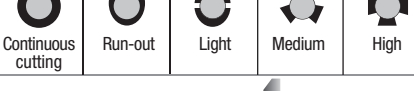



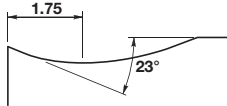
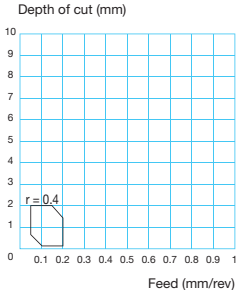






Increasing edge strength 


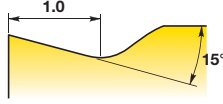
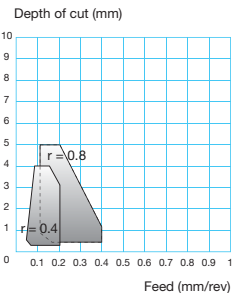
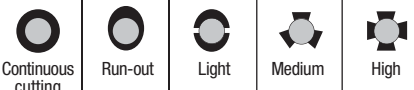

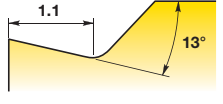
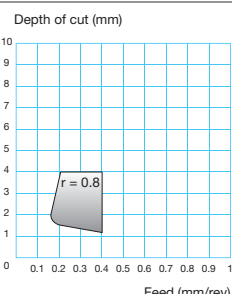


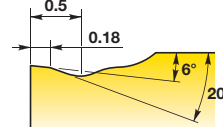
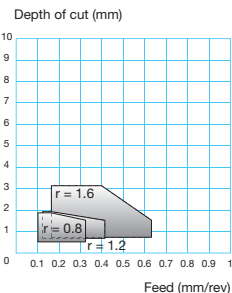
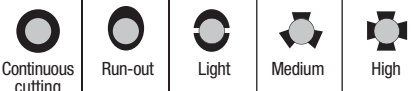

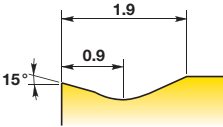
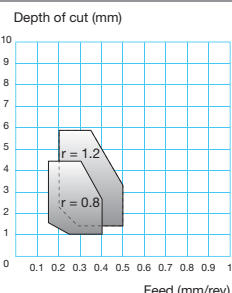
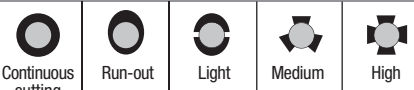

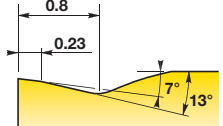
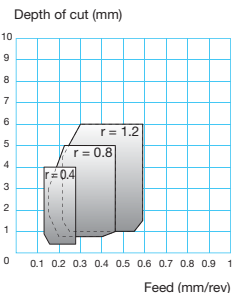
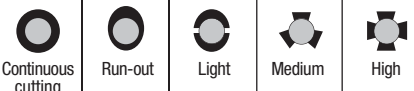
Positive	Finishing						SS14	
	Medium machining		SS5	SS6	SS7	SS8		
Negative	Finishing					SS4		
	Medium machining	SS9	SS10	SS11	SS12		SS13	
	Roughing			SS26				

Increasing feed rate 



Positive geometry	Chipbreaker profile	Applications	Description
 <p>SS5</p>	 <ul style="list-style-type: none"> Finishing / semi-finishing applications Positive cutting edge for reduced forces Broad chip-control application range Excellent profiling capability 	<p>P</p> <p>M</p> <p>K</p> 	 <p>SS5</p> <p>Main application area: Depth of cut: $a_p = 0.5 - 3.5$ mm Feed: $f = 0.08 - 0.34$ mm/rev</p>
 <p>SS6</p>	 <ul style="list-style-type: none"> Finishing and semi-finishing High positive cutting angle Low cutting forces Good chip control at light depth of cut 	<p>P</p> 	 <p>SS6</p> <p>Main application area: Depth of cut: $a_p = 0.4 - 3.0$ mm Feed: $f = 0.06 - 0.28$ mm/rev</p>
 <p>SS7</p>	 <ul style="list-style-type: none"> Semi-finishing to medium machining Low to medium feed rates Medium depths of cut Good chip control 	<p>P</p> <p>K</p> 	 <p>SS7</p> <p>Main application area: Depth of cut: $a_p = 0.6 - 4.0$ mm Feed: $f = 0.1 - 0.36$ mm/rev</p>
 <p>SS8</p>	 <ul style="list-style-type: none"> Semi-finishing to light roughing Medium feed rates Medium depths of cut 	<p>P</p> <p>M</p> <p>K</p> 	 <p>SS8</p> <p>Main application area: Depth of cut: $a_p = 0.6 - 4.0$ mm Feed: $f = 0.12 - 0.4$ mm/rev</p>
 <p>SS16</p>	 <ul style="list-style-type: none"> Semi roughing and roughing Neutral cutting angle for strong edge Best for interrupted cutting conditions 	<p>P</p> <p>K</p> 	 <p>SS16</p> <p>Main application area: Depth of cut: $a_p = 1.5 - 5.1$ mm Feed: $f = 0.36 - 0.76$ mm/rev</p>

Negative geometry	Chipbreaker profile	Applications	Description				
<p>SS3</p> 	 <ul style="list-style-type: none"> • High positive cutting angle • Low cutting forces 	<p>P</p> <p>M</p> <p>S</p> 	 <p>Continuous cutting</p>	 <p>Run-out</p>	 <p>Light</p>	 <p>Medium</p>	 <p>High</p>
 <p>SS3</p>			<p>Main application area: Depth of cut: $a_p = 0.1 - 2.0$ mm Feed: $f = 0.05 - 0.2$ mm/rev</p>				

Negative geometry	Chipbreaker profile	Applications	Description
SS4 	 <ul style="list-style-type: none"> Finishing to medium machining High positive cutting angle Low cutting forces - ideal for soft materials, work hardening materials 	<p>Depth of cut (mm)</p> 	 <p>SS4</p> <p>Main application area: Depth of cut: $a_p = 0.3 - 5.0$ mm Feed: $f = 0.05 - 0.4$ mm/rev</p>
SS9 	 <ul style="list-style-type: none"> Semi-finishing to light roughing High positive cutting angle Low cutting forces - ideal for soft materials, work hardening materials 	<p>Depth of cut (mm)</p> 	 <p>SS9</p> <p>Main application area: Depth of cut: $a_p = 0.4 - 4.0$ mm Feed: $f = 0.1 - 0.4$ mm/rev</p>
SS10 	 <ul style="list-style-type: none"> Finishing to semi-finishing Neutral land for greater edge strength Medium to high feed rates Slight to moderate interrupted cuts 	<p>Depth of cut (mm)</p> 	 <p>SS10</p> <p>Main application area: Depth of cut: $a_p = 0.5 - 3.0$ mm Feed: $f = 0.1 - 0.6$ mm/rev</p>
SS11 	 <ul style="list-style-type: none"> Multi-purpose geometry for machining of sticky materials 	<p>Depth of cut (mm)</p> 	 <p>SS11</p> <p>Main application area: Depth of cut: $a_p = 1 - 6$ mm Feed: $f = 0.15 - 0.5$ mm/rev</p>
SS12 	 <ul style="list-style-type: none"> General machining Wide range of materials Positive cutting angle Medium feed rates and medium depths of cut 	<p>Depth of cut (mm)</p> 	 <p>SS12</p> <p>Main application area: Depth of cut: $a_p = 0.5 - 6.0$ mm Feed: $f = 0.13 - 0.56$ mm/rev</p>