





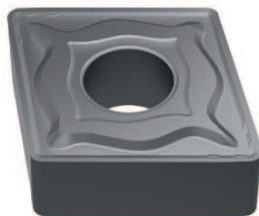
## Negative Turning Chipbreakers: Recommendations

Material Group * = 1st choice	Medium / Roughing		Finishing		Sharper edge X Stronger edge
	Continuous cut 	Interrupted cut 	Continuous cut 	Interrupted cut 	
P	NX * _NMG NN NM	NX NN NM *	_NMP NN NX * _NMG NN	NX _NMG NN * NM	↑ sharper ↓ stronger
M	_NMP NN NX * _NMG NN	NX * _NMG NN	_NMP NN * NX _NMG NN	NX * _NMG NN	↑ sharper ↓ stronger
K	_NMG NN NM * (Mat Group B) _NMA * (Mat Group 7)	_NMG NN NM * (Mat Group B) _NMA * (Mat Group 7)	_NMG NN * (Mat Group 8) NM _NMA * (Mat Group 7)	_NMG NN NM * (Mat Group B) _NMA * (Mat Group 7)	↑ sharper ↓ stronger
S	_NMP NN NX * _NMG NN	NX * _NMG NN	_NMP NN * NX _NMG NN	NX * _NMG NN	↑ sharper ↓ stronger
H	_NMG NN NM *	_NMG NN NM * _NMA	_NMG NN * NM	_NMG NN NM * _NMA	↑ sharper ↓ stronger
N (>8%Si)	_NMP NN NX * _NMG NN	NX _NMG NN *	_NMP NN NX * _NMG NN	NX _NMG NN *	↑ sharper ↓ stronger

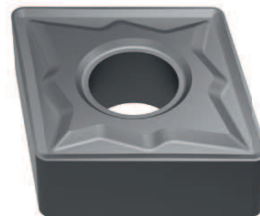
### Multi-Mat™ Chipbreakers



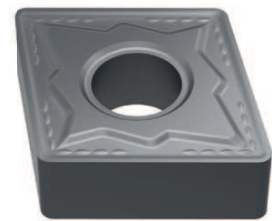
\_NMP NN



NX



\_NMG NN



NM

Light Cut,  
Stable Conditions

Roughing,  
Unstable Conditions

### Additional dedicated geometries

\_NMA  
(Cast Iron Mat Group 7)ALU  
(Aluminium <8% Si)