Spartan Carbide Chipbreaker Description

DM (semi-finishing/negative insert)
Double-sided chipbreaker that reduces cutting force and workpiece adhesion, with a broad chipbreaking range for machining alloy steel.

PM (semi-finishing/negative insert)
Double-sided chipbreaker that has a higher toughness on the cutting edges than the DM style chipbreaker. It is suitable for semi-finishing under unfavorable conditions. Also good for machining cast iron with low cutting force.

DR (roughing/negative insert)
Double-sided chipbreaker that is used for light roughing, higher metal removal rate, and greater cutting edge security.

HF (finishing/positive insert)
Chipbreaker style with a tolerance suitable for internal and external finish machining for various materials such as steel, cast iron, etc.

EF (finishing/positive insert)
Chipbreaker style with a sharp edge for machining stainless steel and soft steel that reduces edge build up and work hardening, while improving surface finish.

HM (semi-finishing/positive insert)
Chipbreaker style suitable for boring and o.d., semi-finishing materials such as steel and cast iron, etc.

EM (semi-finishing/positive insert)
Chipbreaker style that has a higher toughness on the cutting edges then the EF style chipbreaker, used for higher feed and depth of cut.

HR (roughing/positive insert)
Chipbreaker style that is suitable for both boring and o.d. roughing of materials such as steel, stainless steel, cast iron, etc.

Not sure on grade or chipbreaker style? Please answer a few questions and our application engineers will recommend the right tool for your job.

*Brief description of application
*Current tool description/grade being used (if applicable)
*Material being machined
*Machine speed _____RPM/Machine feed rate
*Current failure mode (if applicable)

Spartan Carbide Tool Recommendation_____