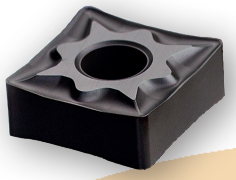
PRAMET

CHIP-BREAKERS

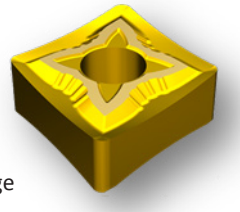
Turning



NF Chip-breaker

Sharp and positive chip-breaker, specially designed for stainless steel
- Excellent chip formation ability
- Low cutting forces increase suitability in unstable machine set-ups
- High productivity
- High durability and reliability as a result of combination materials
- Insert shapes

ISO	T6310	T7335	T9315	T9325	H07
CNMG	●	●	●	●	●
DNMG	●	●	●	●	●
SNMG	●	●	●	●	●
TNMG	●	●	●	●	●
VNMG	●		●	●	
WNMG	●	●	●	●	●

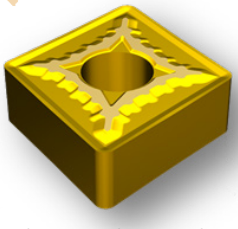


SF Chip-breaker

Sharp positive geometry with inclination cutting edge
- Finishing machining
- Very low cutting forces
- Continuous cut
- Suitable for materials with poor machinability, such as stainless steels, mild steels and high temperature alloys

ISO	T6310	T7335	T8315	T8330	H07
CNGG	●		●	●	●
CNMG	●	●	●	●	●
DNMG	●	●	●	●	●
SNMG	●	●	●	●	●
TNMG	●	●	●	●	●
VNMG	●		●	●	
WNMG	●	●	●	●	●

SM Chip-breaker



Wear-resistant and universal positive geometry
- Medium machining
- High productivity
- Continuous and interrupted cut
- Suitable for materials with poor machinability, such as stainless steels, mild steels and high temperature alloys

ISO	T6310	T7335	T9315	T9325	T8330
CNMG	●	●	●	●	●
DNMG	●	●	●	●	●
SNMG	●	●	●	●	●
TNMG	●	●	●	●	●
VNMG	●	●	●	●	●
WNMG	●	●	●	●	●

New Grades for turning of difficult-to-machine materials

T6310 Grade
- High reliability due to special new sintering process
- High wear resistance (new substrate with high strength and hardness)
- PVD coating using Triple Coating Technology: Multi-layer TiAlN + top layer AlTiSiN with High hardness

H07 Grade
- Special uncoated material for turning titanium and its alloys.
- Fine-grain substrate with low cobalt content.

Ask about our complete array of turning holders

Drilling

SD Chip-breaker

ISO	D8330	D8345	D9335
SCET	●		●
XPET		●	

2xD, 3xD and 4xD drills available

The new Pramet SD (soft drilling) chip breaker is for use with either Pramet's SCET or XPET ranges, allowing for both inner and outer insert use. The chip breaker is specifically designed to improve stability and productivity when drilling long-chip materials, in particular mild steel and stainless steel.
- Positive geometry with stabilizer
- For low carbon and soft stainless steels
- Geometry designed for dilling in solid material
- Optimum contact of the chip with the face increases durability of the inserts
- Low cutting forces