

CHIPBREAKER

Wear resistance **★ ★ ★**

Chipping resistance **★ ★ ★**





Edge material: M42 Cobalt high-speed steel

Hardness : Hv 950

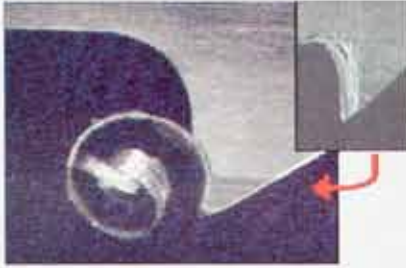
Designed to reduced heat generated at increased chip load. With reduced tooth stripping and breaking this equates to the lowest possible cost per square inch of metal cutting.

Applicability

 Break-in area / 1000 cm²

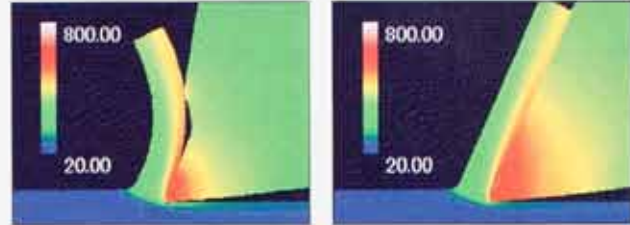
Bundled small diameter material	Mild steel, Non-ferrous metal			Tool steel, Prehardened steel			Hot work die steel, Stainless steel		
Small <100 mm	Small <150 mm	Medium 150-400 mm	Large >400 mm	Small <100 mm	Medium 150-400 mm	Large >400 mm	Small <100 mm	Medium 100-400 mm	Large >400 mm
									
<ul style="list-style-type: none"> • 1.0301, 1.1274, 1.0102 • 1.1161, 1.1260 • 1.7218 • 1.5066, 1.5223 	<ul style="list-style-type: none"> • 1.5406, 1.5419 • 1.6955 • 1.0711, 1.0718 			<ul style="list-style-type: none"> • 1.1545, 1.1663 • 1.2833, 1.2341 • 1.2735, 1.2330 • 1.2545, 1.2714 • 1.2303, 1.2510 • 1.2842, 1.2379 • 1.2080, 1.3355, 1.3357 • 1.3501, 1.3505 			<ul style="list-style-type: none"> • 1.2343, 1.2344 • 1.2581, 1.2587 • 1.4571, 1.4300 • 1.4301, 1.4006 • 1.4021, 1.4016 • 1.4542, 1.4564 		

Features



- Reduced heat generated at increased chip loads
- Prevents scoring on gullet surface
- Reduced chip weld
- Reduced backing fatigue

Benefit

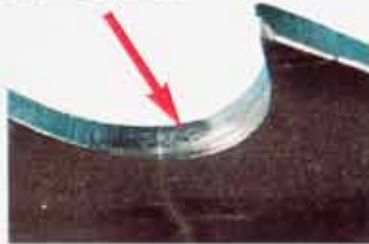


Reduced red heat area versus conventional blades

- Higher cutting rates
- Increased blade life
- Reduced tooth stripping
- Reduced blade breakage

Tooth Selection

Scoring by chips



	Width of cut							
	100	200	300	400	500	600	800	1000
Structural Steel	3/4		2/3		1.5/2			1.1/1.5
Mildsteel	3/4		2/3		1.5/2			1.1/1.5
Die, Tool Steel	3/4		2/3		1.5/2			1.1/1.5
Stainless Steel	3/4		2/3		1.5/2			1.1/1.5
Nickel Alloy		2/3		1.5/2				1.1/1.5

Line-up of products

Band width (mm)	Band thickness (mm)	Pitch			
		1.1/1.5	1.5/2	2/3	3/4
27	0.9				●
34	1.1			●	●
41	1.3		X	●	●
54	1.3		X	X	
	1.6	X	X	●	
67	1.6	X	X		

X in planning ● standard

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