

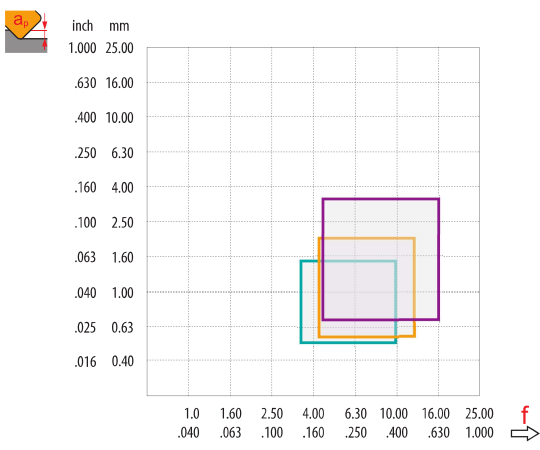









Bar peeling indexable inserts have different cutting-edge geometries in order to create chips with the required shape necessary for smooth removal from the inside of the cutting head. This is one of the most important factors affecting the efficiency of the bar machining process. The wide variety of materials to be machined encourages tool manufacturers to continuously improve both tool geometries and carbide grades.

Detailed information about insert geometry


Different to turning inserts, where the chip breaker has the same design on each insert shape, bar peeling chip breakers differ according to insert shape and size.

Please be aware, the graphs below show ranges of feed per one revolution of peeling head with four cassettes.


MM	 LNGF 300715-MM			<table border="1"> <thead> <tr> <th>P</th> <th>M</th> <th>K</th> <th>N</th> <th>S</th> <th>H</th> </tr> </thead> <tbody> <tr> <td><input checked="" type="checkbox"/></td> <td><input type="checkbox"/></td> <td><input type="checkbox"/></td> <td><input type="checkbox"/></td> <td><input checked="" type="checkbox"/></td> <td><input type="checkbox"/></td> </tr> <tr> <td>f</td> <td colspan="5">3.60 – 16.00</td> </tr> <tr> <td>a_p</td> <td colspan="5">0.50 – 3.50</td> </tr> </tbody> </table>	P	M	K	N	S	H	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	f	3.60 – 16.00					a_p	0.50 – 3.50					 <p>LNGF 30, LNGF 36, LNGF 40</p>
	P	M		K	N	S	H																						
	<input checked="" type="checkbox"/>	<input type="checkbox"/>		<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>																						
f	3.60 – 16.00																												
a_p	0.50 – 3.50																												
 LNGF 361220-MM		<table border="1"> <thead> <tr> <th>P</th> <th>M</th> <th>K</th> <th>N</th> <th>S</th> <th>H</th> </tr> </thead> <tbody> <tr> <td><input checked="" type="checkbox"/></td> <td><input type="checkbox"/></td> <td><input type="checkbox"/></td> <td><input type="checkbox"/></td> <td><input checked="" type="checkbox"/></td> <td><input type="checkbox"/></td> </tr> <tr> <td>f</td> <td colspan="5">4.00 – 12.00</td> </tr> <tr> <td>a_p</td> <td colspan="5">3.00 – 16.00</td> </tr> </tbody> </table>	P	M	K	N	S	H	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	f	4.00 – 12.00					a_p	3.00 – 16.00					 <p>RNGH 38, RNGH 50</p>		
P	M	K	N	S	H																								
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>																								
f	4.00 – 12.00																												
a_p	3.00 – 16.00																												
 LNGF 401035-MM		<table border="1"> <thead> <tr> <th>P</th> <th>M</th> <th>K</th> <th>N</th> <th>S</th> <th>H</th> </tr> </thead> <tbody> <tr> <td><input checked="" type="checkbox"/></td> <td><input type="checkbox"/></td> <td><input type="checkbox"/></td> <td><input type="checkbox"/></td> <td><input checked="" type="checkbox"/></td> <td><input type="checkbox"/></td> </tr> <tr> <td>f</td> <td colspan="5">4.80 – 12.00</td> </tr> <tr> <td>a_p</td> <td colspan="5">1.00 – 8.00</td> </tr> </tbody> </table>	P	M	K	N	S	H	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	f	4.80 – 12.00					a_p	1.00 – 8.00					 <p>WNGF 20</p>		
P	M	K	N	S	H																								
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>																								
f	4.80 – 12.00																												
a_p	1.00 – 8.00																												

GEOMETRY OF PEELING INSERTS


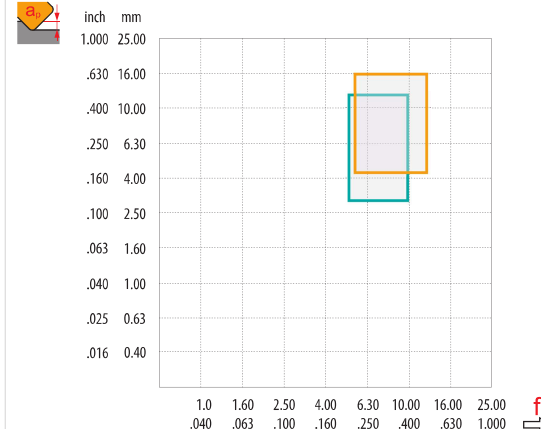
MR




RNGH 381200-MR



RNGH 5018M0-MR

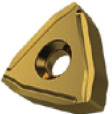



P	M	K	N	S	H
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


? RNGH 38, RNGH 50


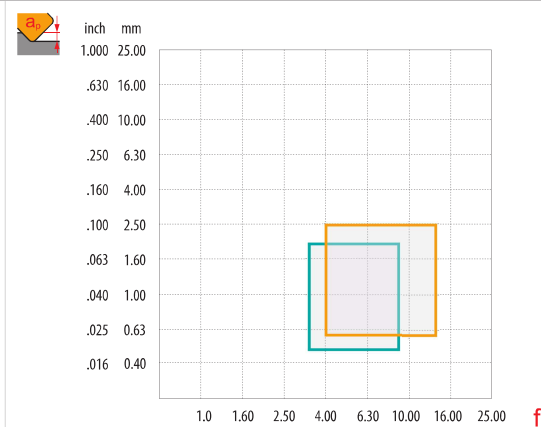
PF




TNGJ 220720-PF



TNGJ 281025-PF





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a_p	0.50 – 2.50				




? TNGJ 22, TNGJ 28


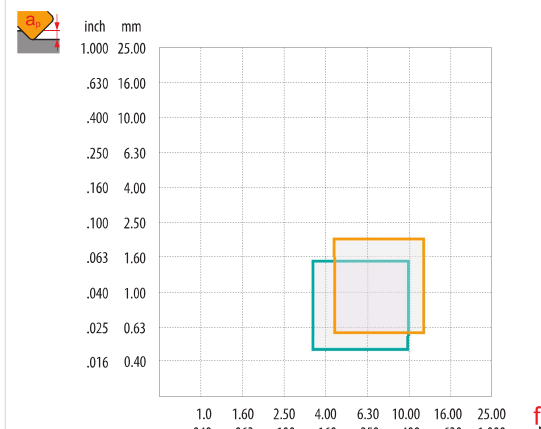
PM




LNGF 300715-PM



LNGF 361220-PM





P	M	K	N	S	H
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



? LNGF 30, LNGF 36


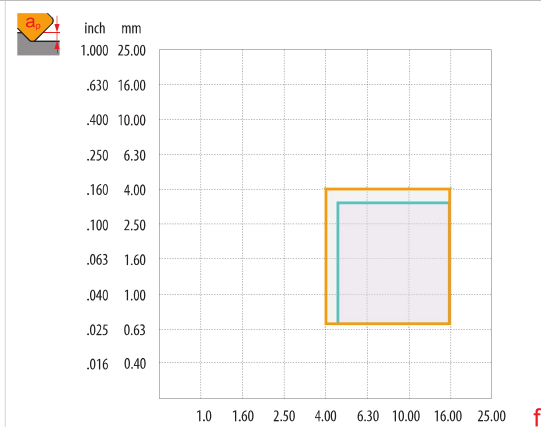
PM




LNGF 401035-PM

LNXR 381240-PM



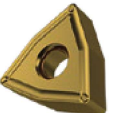

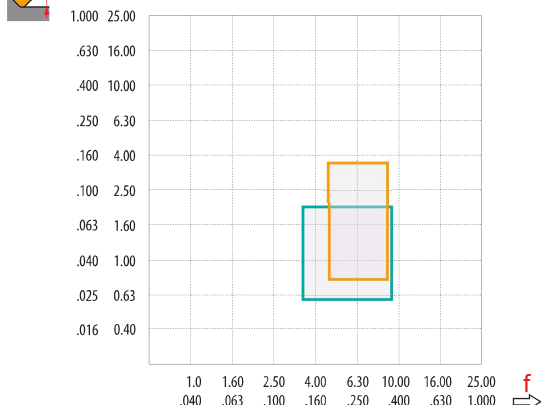
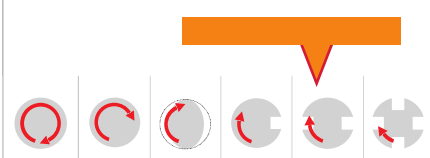


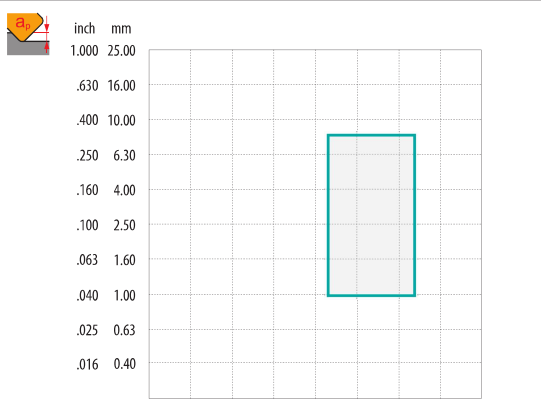
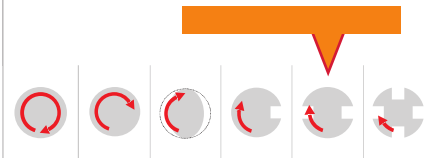


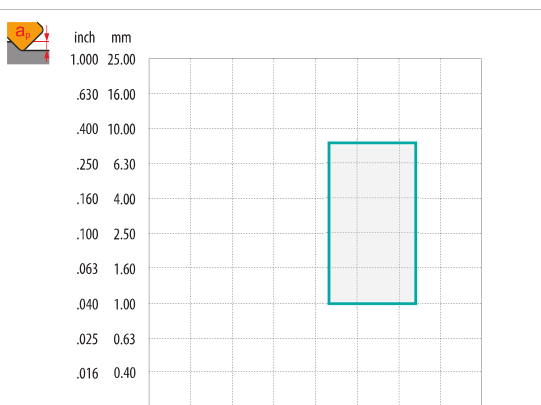
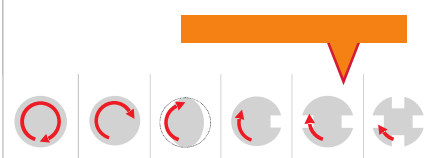
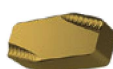

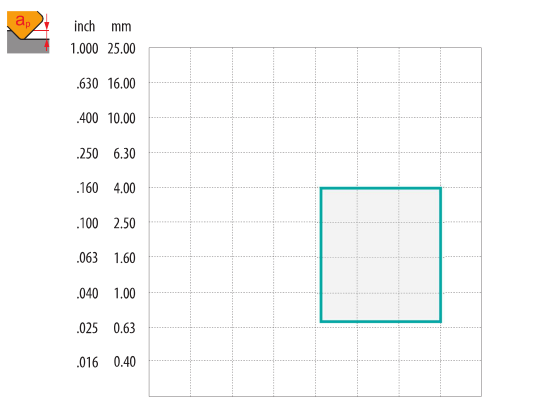
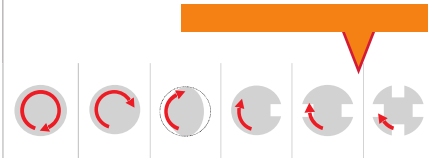



P	M	K	N	S	H
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f	4.00 – 16.00				
a_p	0.70 – 4.00				



? LNGF 40, LNXR 38

GEOMETRY OF PEELING INSERTS

PM	 <p>TNGJ 220720-PM</p> 	 <p>WNGU 150935-PM</p> 		<table border="1"> <thead> <tr> <th>P</th> <th>M</th> <th>K</th> <th>N</th> <th>S</th> <th>H</th> </tr> </thead> <tbody> <tr> <td>■</td> <td>■</td> <td>■</td> <td>■</td> <td>■</td> <td>■</td> </tr> <tr> <td>f</td> <td colspan="5">3.60 – 9.00</td> </tr> <tr> <td>a_p</td> <td colspan="5">0.50 – 3.50</td> </tr> </tbody> </table>	P	M	K	N	S	H	■	■	■	■	■	■	f	3.60 – 9.00					a_p	0.50 – 3.50					 <p>? TNGJ 22, WNGU 15</p>
	P			M	K	N	S	H																					
■	■	■	■	■	■																								
f	3.60 – 9.00																												
a_p	0.50 – 3.50																												
PM	 <p>WNMF 201380-PM</p> 		<table border="1"> <thead> <tr> <th>P</th> <th>M</th> <th>K</th> <th>N</th> <th>S</th> <th>H</th> </tr> </thead> <tbody> <tr> <td>■</td> <td>■</td> <td>■</td> <td>■</td> <td>■</td> <td>■</td> </tr> <tr> <td>f</td> <td colspan="5">4.80 – 12.00</td> </tr> <tr> <td>a_p</td> <td colspan="5">0.50 – 8.00</td> </tr> </tbody> </table>	P	M	K	N	S	H	■	■	■	■	■	■	f	4.80 – 12.00					a_p	0.50 – 8.00					 <p>? WNMF 20</p>	
	P		M	K	N	S	H																						
■	■	■	■	■	■																								
f	4.80 – 12.00																												
a_p	0.50 – 8.00																												
PR	 <p>WNMJ 201480-PR WNXJ 201380-PR</p> 		<table border="1"> <thead> <tr> <th>P</th> <th>M</th> <th>K</th> <th>N</th> <th>S</th> <th>H</th> </tr> </thead> <tbody> <tr> <td>■</td> <td>■</td> <td>■</td> <td>■</td> <td>■</td> <td>■</td> </tr> <tr> <td>f</td> <td colspan="5">4.80 – 12.00</td> </tr> <tr> <td>a_p</td> <td colspan="5">1.00 – 8.00</td> </tr> </tbody> </table>	P	M	K	N	S	H	■	■	■	■	■	■	f	4.80 – 12.00					a_p	1.00 – 8.00					 <p>? WNMJ 20, WNXJ 20</p>	
	P		M	K	N	S	H																						
■	■	■	■	■	■																								
f	4.80 – 12.00																												
a_p	1.00 – 8.00																												
PR	 <p>LNXR 381240-PR</p> 		<table border="1"> <thead> <tr> <th>P</th> <th>M</th> <th>K</th> <th>N</th> <th>S</th> <th>H</th> </tr> </thead> <tbody> <tr> <td>■</td> <td>■</td> <td>■</td> <td>■</td> <td>■</td> <td>■</td> </tr> <tr> <td>f</td> <td colspan="5">4.80 – 16.00</td> </tr> <tr> <td>a_p</td> <td colspan="5">0.70 – 4.00</td> </tr> </tbody> </table>	P	M	K	N	S	H	■	■	■	■	■	■	f	4.80 – 16.00					a_p	0.70 – 4.00					 <p>? LNXR 38</p>	
	P		M	K	N	S	H																						
■	■	■	■	■	■																								
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