

**HORIZON RK - LK "CHIP CURLER" GROOVING INSERTS**



*15° to 18° Positive Rakes Lower Cutting Forces and Reduce Built-Up Edge Problems*

*Sharp Cutting Edges for Tough, Gummy Materials like Stainless, Titanium and Inconel®*

*Free Cutting Action - Great for Small Diameters and Thin Walled Parts*

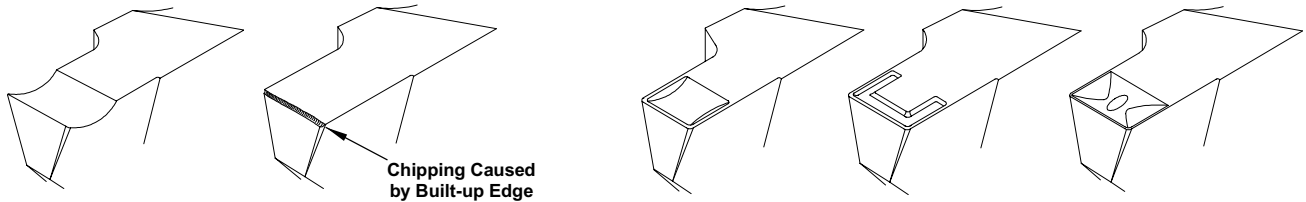
*Uncoated Inserts for Aluminum and Plastics have Polished Chip Curlers*

*Available in Standard Depth, Deep Depth and Face Grooving Inserts*

**Chip Curler Inserts**

**Standard Inserts**

**Competitive Chipbreaker Inserts**

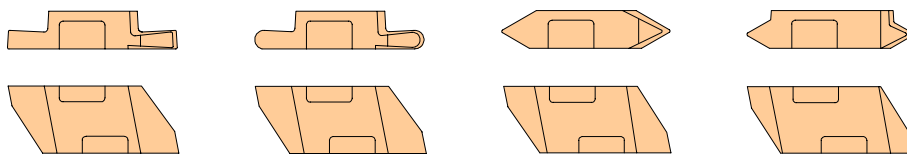


Horizon Precision Ground "Chip Curler" Inserts prevent Edge Built-up in tough, gummy materials. Sharp, positive rake edges lower cutting forces providing easy chip flow.

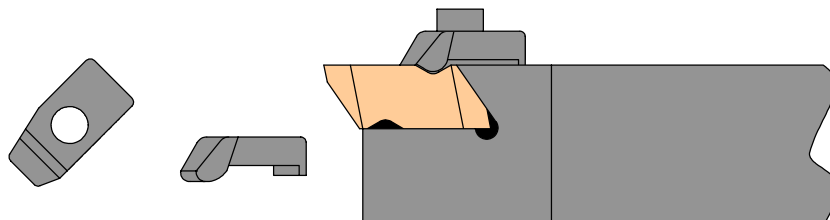
Recommended Feeds for tough materials - .0005 to .003 IPR. Softer Materials can be machined at higher feeds. Uncoated Inserts for Aluminum and Plastic have polished rakes.

Molded Chipbreaker Inserts are designed for machining Medium to High Carbon Steels at feed rates over .005 per rev. Most of these Inserts have a .003 to .010 wide land in front of the chipbreaker.

The area of chip contact rarely exceeds the land width at feeds under .005 IPR. At lighter feed rates performance difference is minimal between chipbreaker Inserts and standard flat top styles.



**Threading and Grooving Inserts are available with TL® Style Notches on Special Order**



**Changing Clamps allows the use of Industry Standard Inserts in TL® Holders - See pages 31 - 33**