

Information Chart for Carbide Inserts Hunter Brake Lathes

Insert Number	Insert Description	Nose Radius	Features, Advantages and Selling Ideas	Considerations & Potential Drawbacks
BL Bench Lathe POSITIVE RAKE INSERTS				
221-639-3	Positive Rake Angle 4 pack, standard on BL Lathes	0.015" tip	<ul style="list-style-type: none"> ▪ One side, 3 cutting edges total ▪ Lower pressure on work-piece contact allows deeper cuts. ▪ Less susceptible to vibration/chatter than negative rake inserts. ▪ Works well on non-rigid work-piece setups and composite rotor designs. ▪ Recommended for flywheels, hard spots and heat checks, etc. ▪ Very low cost per insert in comparison to competition. ▪ Standard on BL Lathes 	<ul style="list-style-type: none"> ▪ Tip life is shortest of all choices. ▪ May not be inverted to use tips on opposite side. ▪ 3 sides positive vs. 6 sides negative ▪ Surface finish may not be as smooth as 0.030" nose radius. ▪ Not recommended for on-car lathes
221-640-3	Positive Rake Angle, 24 pack	0.015" tip	<ul style="list-style-type: none"> ▪ Same as above ▪ Part number for reordering quantities. ▪ Good value. 	<ul style="list-style-type: none"> ▪ Same as above
221-538-3	Positive Rake, 6 pack	0.030" tip	<ul style="list-style-type: none"> ▪ One side, 3 cutting edges total ▪ Higher tip pressure at work-piece over 0.015" radius. ▪ Surface finish may be better than 0.015" nose radius ▪ Slight increase in potential for vibration/chatter over 0.015" radius, but less sensitive than negative rake. ▪ Uses the same insert holder as the positive rake 0.015" insert. ▪ 	<ul style="list-style-type: none"> ▪ Same as above ▪ Higher cost insert ▪ May not be inverted to use tips on opposite side. ▪ Not recommended for on-car lathes
BL Bench Lathe NEGATIVE RAKE INSERTS				
221-580-2	Negative Rake Angle 4 pack	0.030" tip	<ul style="list-style-type: none"> ▪ Two sides, 6 cutting edges total, may be inverted. ▪ Longer tip life than positive rake ▪ Higher tip pressure at work-piece over 0.015" radius ▪ Recommended for machining cast iron. ▪ Works well on rigid work-piece setups. ▪ Traditional brake lathe insert is very common 	<ul style="list-style-type: none"> ▪ Higher cost inserts ▪ Any parts store has "Ammco" style inserts and may use inferior carbide. ▪ Requires negative rake insert holders. ▪ Not recommended for on-car lathes
221-617-2	Negative Rake Angle 24 pack	0.030" tip	<ul style="list-style-type: none"> ▪ Same as above ▪ Part number for reordering quantities. 	<ul style="list-style-type: none"> ▪ Same as above
OCL On-Car Lathe MICRO-ROUND INSERTS				
221-626-3	Micro-Round 10 pack	0.250" round	<ul style="list-style-type: none"> ▪ Extremely long tip life. Low maintenance. High tech. ▪ Robust design can take crashes into work-piece under rotation without breaking. ▪ Rotation gives approximately six positions. ▪ Excellent surface finishes. ▪ Works well on rigid lathe and work-piece setups. ▪ Self-cleaning chip-breaker design. ▪ Requires micro-round insert holders supplied standard with on-car lathes 	<ul style="list-style-type: none"> ▪ Higher cost per insert ▪ Very high pressure due to large nose radius may increase vibration/chatter. ▪ Larger design round nose inserts not recommended. ▪ Not recommended for Bench Lathes ▪ Can not be inverted to use under side.