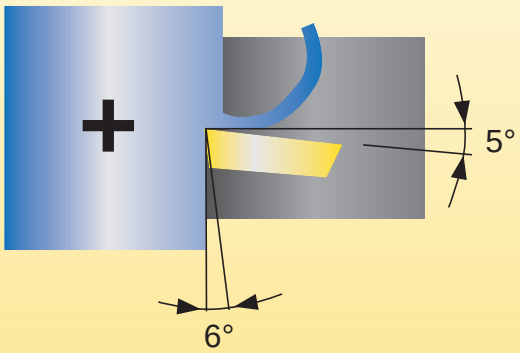
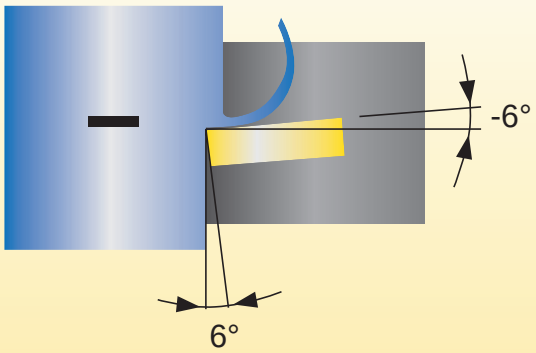
STELLRAM

Top Rake

Positive: Produces low shearing stress and may eliminate vibration during finish machining, machining of long workpieces, or poor workholding.





Negative: Produces larger shearing stress which causes a high chip strain. It is much stronger in comparison to the positive rake and requires good workpiece and tool stability.

Effective Cutting Angle

The position of the insert seat determines the cutting rake:

- This can be negative or 0°.
- The effective cutting angle is also determined by the insert geometry located on the seat, as this could be flat face or a chip breaker and it could change the effective cutting angle.
- The effective cutting angle is the sum of the angle in the insert seat and the geometry of the seated inserts.

