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(54) **FINISH DEPTH TURNING INSERT COMPRISING A CHIP CONTROL ARRANGEMENT**

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(52) **U.S. Cl.**

CPC ***B23B 27/1607*** (2013.01); ***B23B 27/143*** (2013.01); *B23B 27/22* (2013.01); *B23B 2200/081* (2013.01); *B23B 2200/321* (2013.01); *Y10T 407/235* (2015.01); *Y10T 407/24* (2015.01)

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See application file for complete search history.

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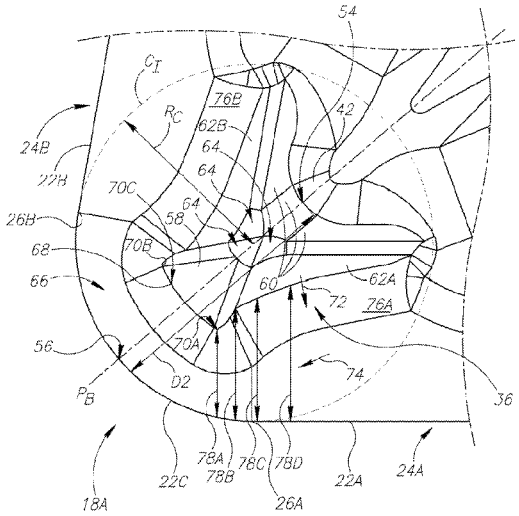
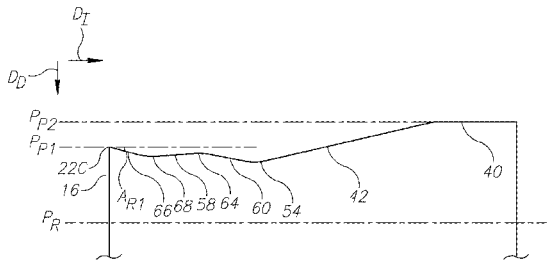
(57) **ABSTRACT**

A finish depth turning insert includes a chip control arrangement. The chip control arrangement includes a medium protuberance for medium depth machining operations and a finish protuberance for finish depth machining operations. The finish protuberance is located between the medium protuberance and a corner of the insert. The finish protuberance also includes a front finish deflector surface and first and second relief surfaces extending towards the medium protuberance from the front finish deflector surface.

26 Claims, 6 Drawing Sheets