

# GUIDE TO METAL CHIPS

## Types and Weights



**FINE CHIPS:** Free flowing, small (granular) chips. Commonly produced in milling, broaching, hobbing and gear cutting applications.



**BROKEN CHIPS:** Usually sixes and nines, occasional string to one foot in length produced in drilling, boring and screw machine applications. Non-balling—loose, free-flowing material.



**LIGHT TURNINGS:** Balled turnings and strings. Commonly produced from turning operations. May contain a high percentage of broken chips. But will conform to the size of container used in handling.



**HEAVY TURNINGS:** Snarly, compressed balls of turnings produced by machining hardened materials or created by method of handling. Usually contains a low percentage of broken chips and fines.

### Nominal weights per cubic foot

TYPE	STEEL	CAST IRON	BRASS	ALUMINUM
Solid Stock (Ref. only)	490 lbs.	482 lbs.	558 lbs.	169 lbs.
Fine Chips	85-160	125-180	150-200	50-60
Broken Chips	55-75	70-120	65-100	20-25
Light Turnings (Loose)	10-25	—	15-30	5-10
Heavy Turnings (Tight)	30-45	—	35-60	10-15

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