

Negative M-Class Chipbreaker for Rough and Heavy Cutting

# NMH Chipbreaker



- Achieves distinguished stable machining
- High efficiency and longer tool life
- Constant chip control

# Chipbreaker for Rough and Heavy Cutting

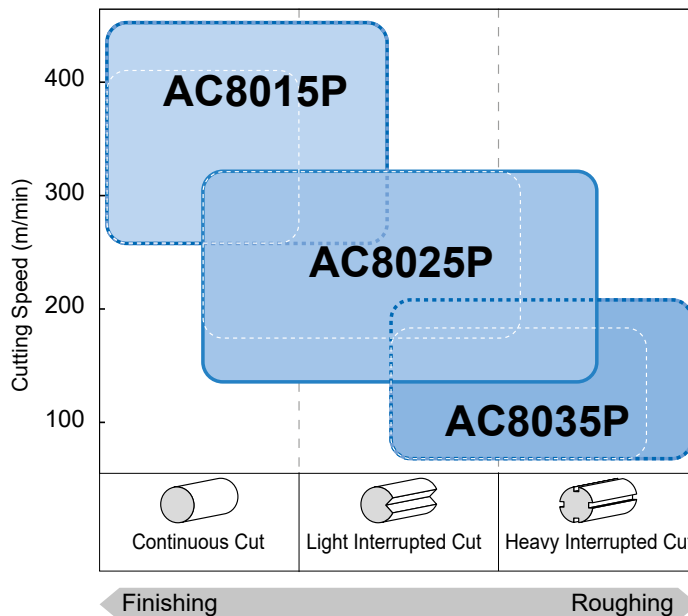
## NMH Type



### ■ Features

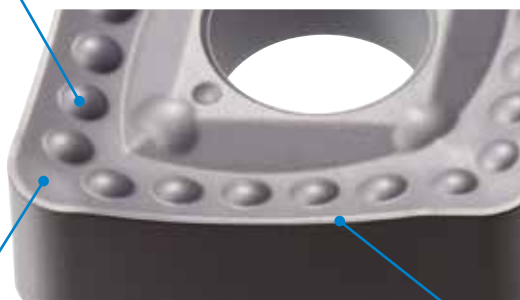
- Negative M-class chipbreaker for rough and heavy cutting.
- Original breaker design maintains excellent chip control and long tool life for rough cutting applications.
- Excellent breakage resistance aids stable machining.

### ■ Application Range

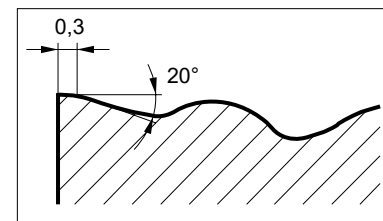


### ■ NMH Type Chipbreaker

Bumpy geometry design creates constant chip control providing improved crater wear resistance and longer cutting distance.



Cross-Section of Chipbreaker

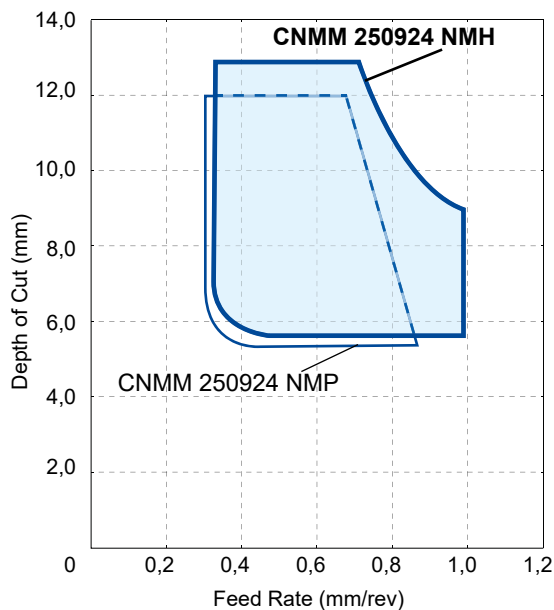
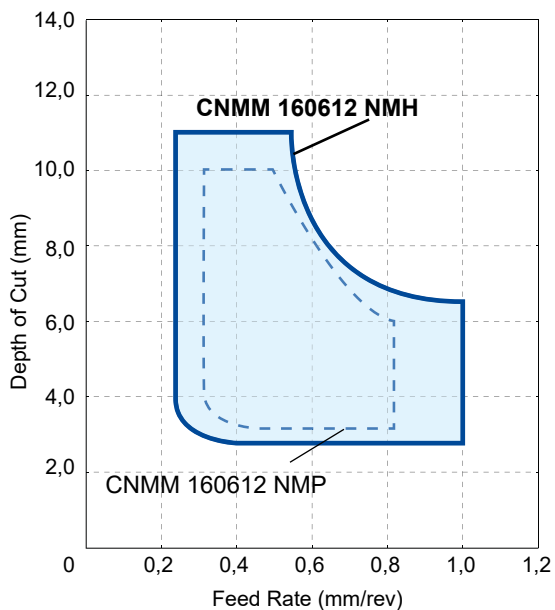


Optimized 3D-design of chip pocket for good chip control and improved stability of cutting edge at corner radius.

Negative land improves notch wear resistance and stability of cutting edge.

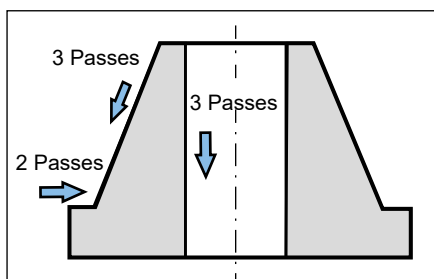
# Chipbreaker for Rough and Heavy Cutting NMH Type

## Application Range of 1606... and 2509...NMH Inserts



## Application Example

### Flange Parts



Material: 25CrMo4Q+H  
 Insert: SNMM 190616 NMH AC8025P  
 Cutting Conditions:  $v_c = 145$  m/min,  $f = 0,8$  mm/rev,  $a_p = 5,0$  mm, wet

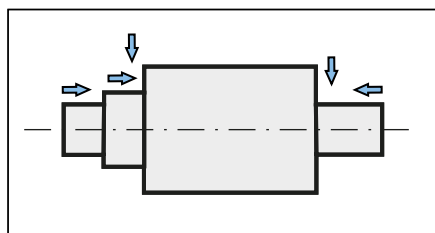


**NMH**  
 No breakage,  
 stable cutting.



Competitor

### Shaft



Material: GGG40  
 Insert: CNMM 250924 NMH AC8025P  
 Cutting Conditions:  $v_c = 200$  m/min,  $f = 0,6$  mm/rev,  $a_p = 8,0$  mm, wet



**NMH**  
 6 pcs/Cutting edge





Conventional  
 4 pcs/Cutting edge

# Chipbreaker for Rough and Heavy Cutting


## NMH Type

### ■ Stock Items

#### ◇ 80° Diamond Type

| Shape   | Cat. No.        | Stock   |         |         | Dimensions (mm)  |           |              |             |
|---|-----------------|---------|---------|---------|------------------|-----------|--------------|-------------|
|   |                 | AC8015P | AC8025P | AC8035P | Inscribed Circle | Thickness | Screw Hole Ø | Nose Radius |
|  | CNMM 160612 NMH | ●       | ●       | ●       | 15,875           | 6,35      | 6,35         | 1,2         |
|   | 160616 NMH      | ●       | ●       | ●       |                  |           |              | 1,6         |
|   | CNMM 190612 NMH | ●       | ●       | ●       | 19,05            | 6,35      | 7,94         | 1,2         |
|   | 190616 NMH      | ●       | ●       | ●       |                  |           |              | 1,6         |
|   | 190624 NMH      | ●       | ●       | ○       |                  |           |              | 2,4         |
|  | CNMM 250924 NMH | ●       | ●       | ○       | 25,4             | 9,52      | 9,12         | 2,4         |
|   | 250932 NMH      | ○       | ○       | ○       |                  |           |              | 3,2         |

#### ○ Square Type

| Shape   | Cat. No.        | Stock   |         |         | Dimensions (mm)  |           |              |             |
|---|-----------------|---------|---------|---------|------------------|-----------|--------------|-------------|
|   |                 | AC8015P | AC8025P | AC8035P | Inscribed Circle | Thickness | Screw Hole Ø | Nose Radius |
|  | SNMM 190612 NMH | ●       | ●       | ●       | 19,05            | 6,35      | 7,94         | 1,2         |
|   | 190616 NMH      | ●       | ●       | ●       |                  |           |              | 1,6         |
|   | 190624 NMH      | ○       | ○       | ○       |                  |           |              | 2,4         |
|   | SNMM 250724 NMH | ●       | ●       | ○       | 25,4             | 9,52      | 9,12         | 2,4         |
|   | SNMM 250924 NMH | ●       | ●       | ○       |                  |           |              | 2,4         |

● Euro Stock ○ Japan Stock



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