

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

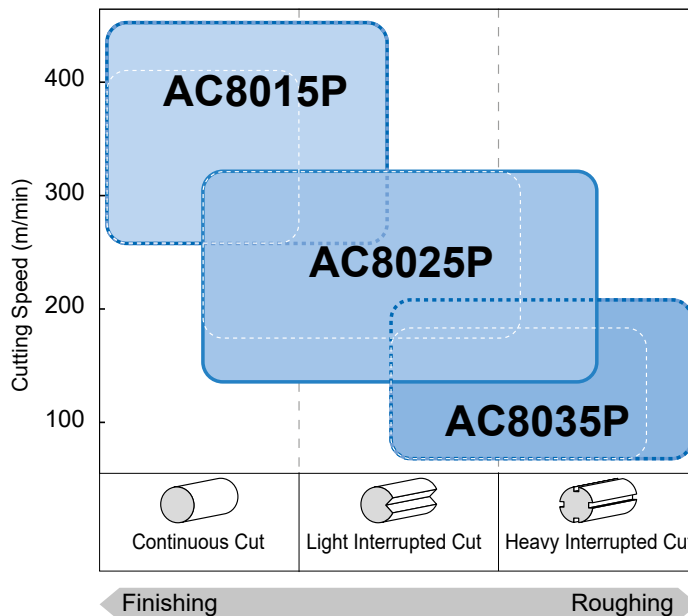
## NMH Type



### ■ Features

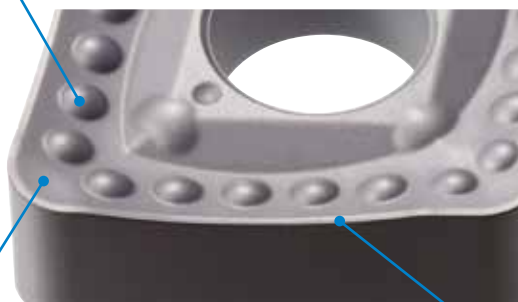
- Negative M-class chipbreaker for rough and heavy cutting.
- Original breaker design maintains excellent chip control and long tool life for rough cutting applications.
- Excellent breakage resistance aids stable machining.

### ■ Application Range

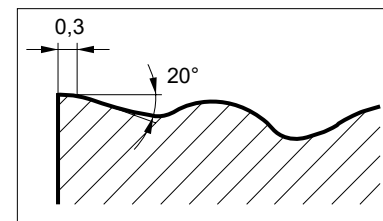


### ■ NMH Type Chipbreaker

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



Cross-Section of Chipbreaker

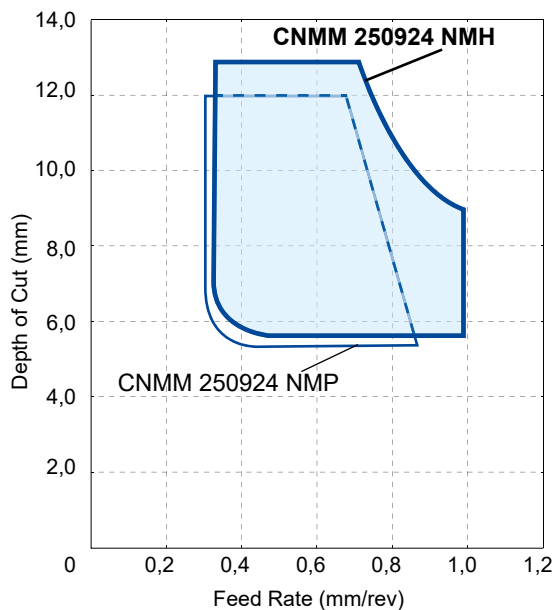
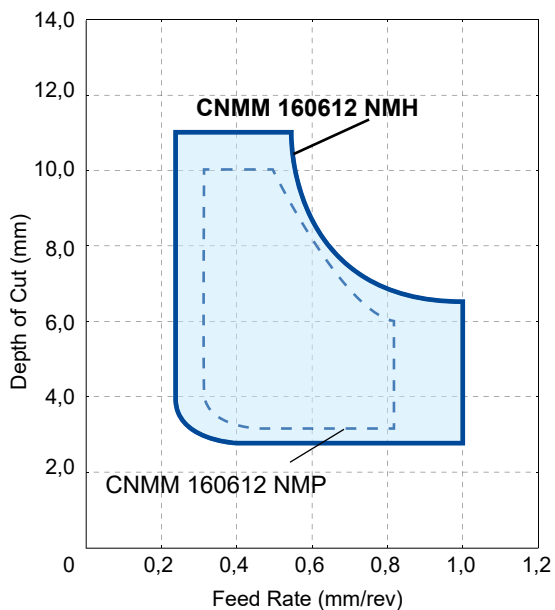


Optimized 3D-design of chip pocket for good chip control and improved stability of cutting edge at corner radius.

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

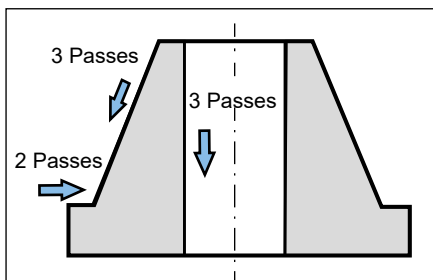
# Chipbreaker for Rough and Heavy Cutting NMH Type

## 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

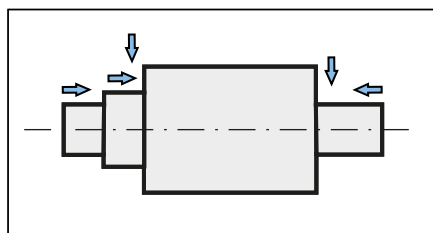


**NMH**  
 No breakage,  
 stable cutting.



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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