

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

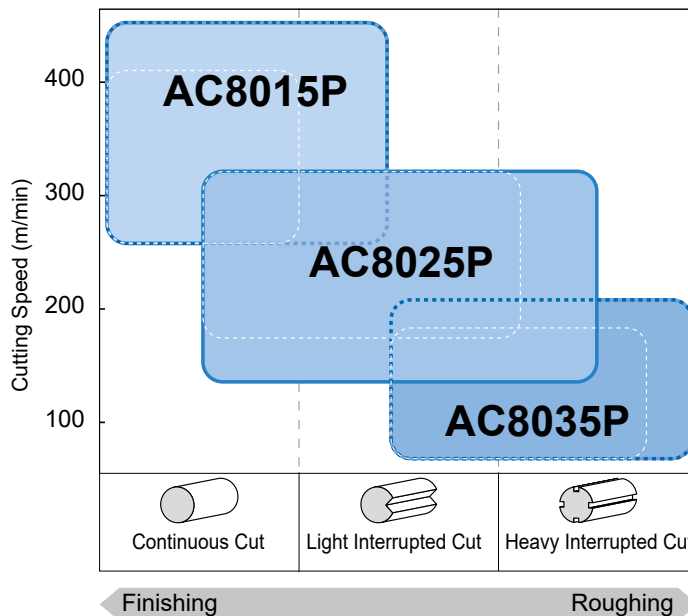
NMH Type



■ Features

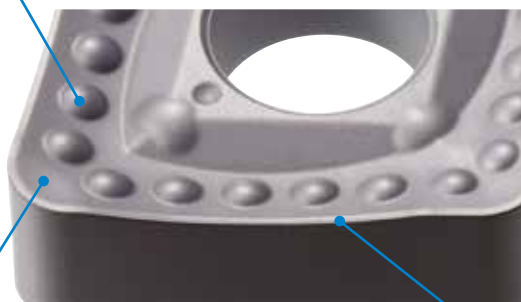
- Negative M-class chipbreaker for rough and heavy cutting.
- Original breaker design maintains excellent chip control and long tool life for rough cutting applications.
- Excellent breakage resistance aids stable machining.

■ Application Range



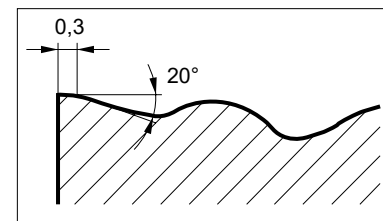
■ NMH Type Chipbreaker

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



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

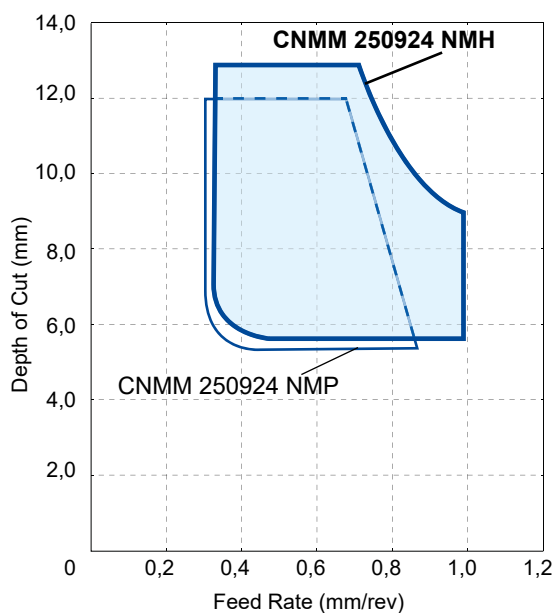
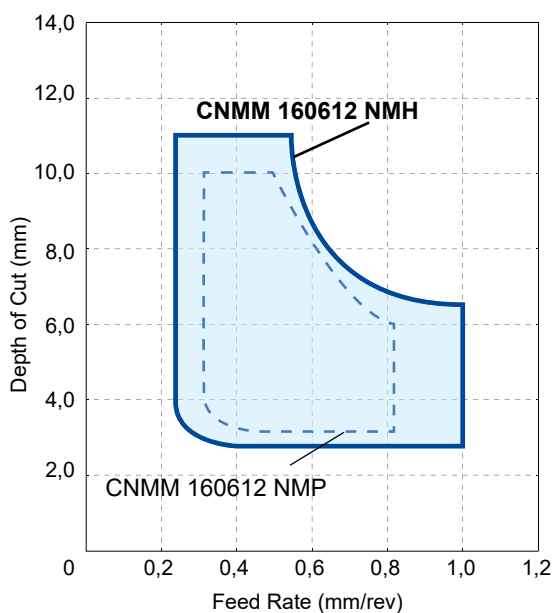
Cross-Section of Chipbreaker



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

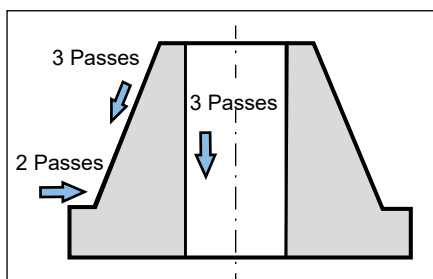
Chipbreaker for Rough and Heavy Cutting NMH Type

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

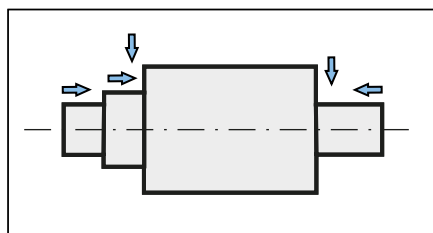


NMH
 No breakage,
 stable cutting.



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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