

GMM type Cut-Off Inserts

TMR Chipbreaker

Achieves a high feed rate with stable chip control

- **Stable chip control at medium to high feed rates**

- Special curved wall controls the curl diameter of chips
- Depression in center of cutting edge improves chip control

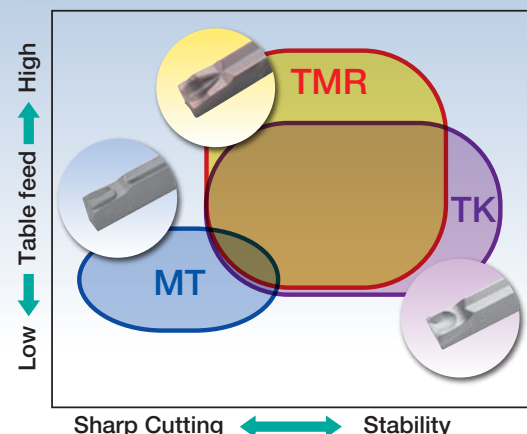
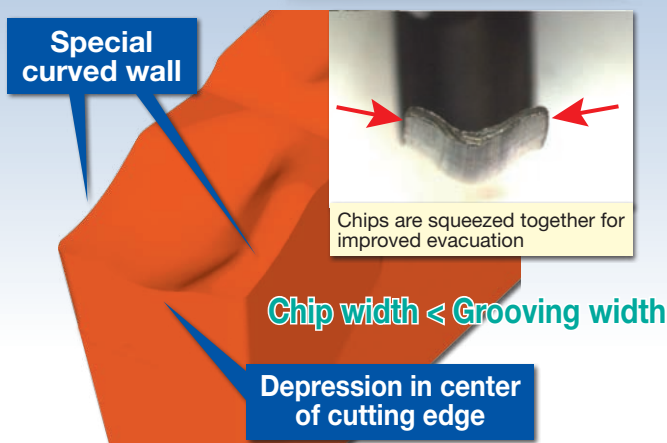
Advancing Productivity

2-Edges

- **Good chip control even when cutting speed (spindle revolution) is increased**

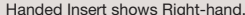
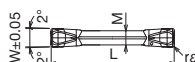
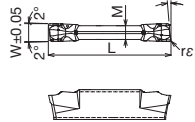
■ Chipbreaker Advantages

■ Chipbreaker map



Stock Items

The TMR chipbreaker provides stable chip control at high feed rates even in sticky work piece materials such as SCM415

Shape		Description	Dimension(mm)					Angle	PVD Coated	Tool-holder
			W	r ϵ	L	H	M	θ	PR1115	
 		GMM2020-TMR	2.0	0.2	20	4.3	1.5	-		KGM ^{R/L}
	GMM2520-TMR	2.5	1.9							
	GMM3020-TMR	3.0	0.25	2.3						
 R-hand		GMM2020R-TMR-6D	2.0	0.2	20	4.3	1.5	6		
	GMM2520R-TMR-6D	2.5	1.9							
	GMM3020R-TMR-6D	3.0	0.25	2.3						

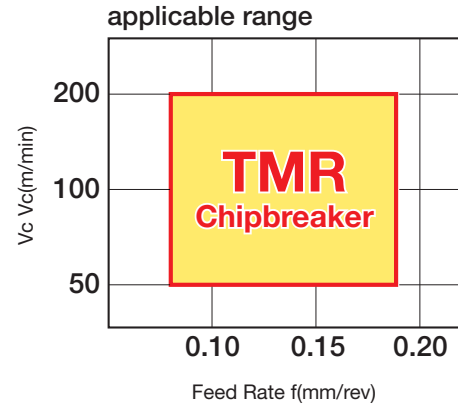
Edge Preparation: Chamfer+hone

The TMR chipbreaker provides stable chip control even when high feed rates are required.

Good chip control even when cutting speed (spindle revolution) is increased.

(SCM415:ø30:Constant spindle revolution)

Description	n=1060min ⁻¹ (Vc=100m/min)		n=2120min ⁻¹ (Vc=200m/min)	
	f=0.12mm/rev	f=0.18mm/rev	f=0.12mm/rev	f=0.18mm/rev
GMM 3020-TMR				
GMM 3020R-TMR-6D R-hand				



Recommended Cutting Conditions

Workpiece Material	Vc (m/min)	f (mm/rev)
Carbon Steel	60~200	0.08~0.18
Alloy Steel	60~150	
Stainless Steel	50~140	

Workpiece surface roughness

The TMR chipbreaker provides good surface finish on the work piece end face even at high feed rates.

