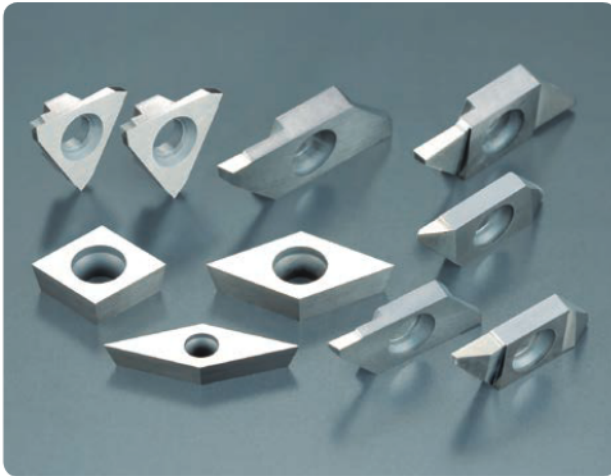


KM1

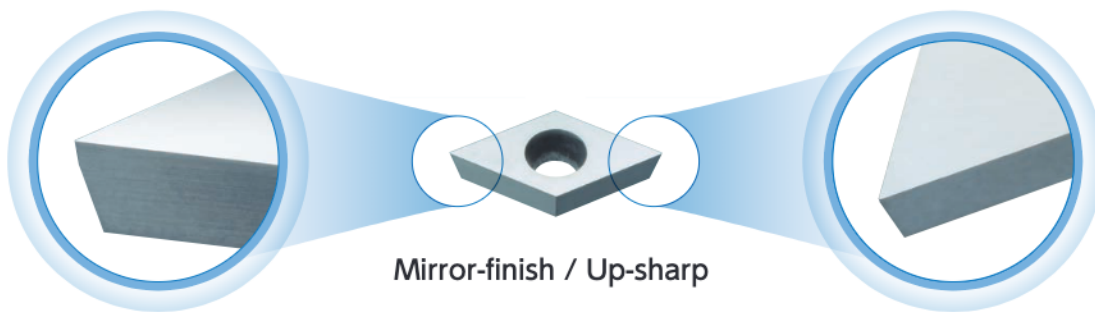
Best tool for PEEK material



Features

- NTK's KM1 inserts are designed for other non-ferrous materials such as PEEK
- Extremely up-sharp edge and mirror insert surface creates excellent surface finishes
- R 0.0 corner radius inserts are available

Special component – Internal plunger		
Material: PEEK		
Insert	NTK: DCGW 32.508H KM1	
Holder	SDJCR1212X11N	
Speed	442 SFM	
Feed	.002 IPR	
Depth of Cut	.045"	
Length of cut	2.18"	
Coolant	Dry	
Result	Excellent surface finish.	

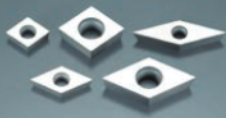


Mirror-finish / Up-sharp

R0.0 Insert

Cover all applications

Front turning



CC DC VC

Back turning



TBP

Cut-off



CTP CTPA

Grooving / side turning



GTMH GTPA

Threading



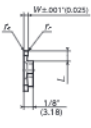
TTP

Grade	Work material	Application	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)	DRY	WET
KM1	PEEK Copper Brass Aluminum Plastics	Turning	160-300 (160-650)	.0004-.004	-.100	●	●

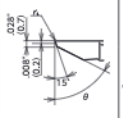
Front turning

Shape	Item Number	ISO Item Number	IC	R	KM1
 CCGW..	CCGW 21.501 H 	CCGW 060200 H	1/4	.001	●
	CCGW 21.504 H 	CCGW 060201 H	1/4	.004	●
	CCGW 21.508 H 	CCGW 060202 H	1/4	.008	●
	CCGW 32.501 H 	CCGW 09T300 H	3/8	.001	●
	CCGW 32.504 H 	CCGW 09T301 H	3/8	.004	●
	CCGW 32.508 H 	CCGW 09T302 H	3/8	.008	●
 DCGW..	DCGW 21.501 H 	DCGW 070200 H	1/4	.001	●
	DCGW 21.504 H 	DCGW 070201 H	1/4	.004	●
	DCGW 21.508 H 	DCGW 070202 H	1/4	.008	●
	DCGW 32.501 H 	DCGW 11T300 H	3/8	.001	●
	DCGW 32.504 H 	DCGW 11T301 H	3/8	.004	●
	DCGW 32.508 H 	DCGW 11T302 H	3/8	.008	●
 VCGW..	VCGW 2201 H 	VCGW 110300 H	1/4	.001	●
	VCGW 2204 H 	VCGW 110301 H	1/4	.004	●
	VCGW 2208 H 	VCGW 110302 H	1/4	.008	●

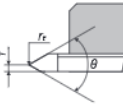
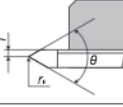
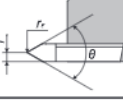
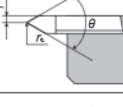
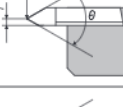
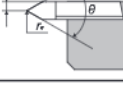
Grooving / Side turning

Shape	Item Number	Groove Width W (Inch) (mm)	Max Depth of Cut (Inch) (mm)	r _e (Inch)	KM1
 GTMH.. 	GTMH32100R _L SSH 	.039 1.00	.063 1.6	.002	●
	GTMH32150R _L SSH 	.059 1.50	.106 2.7	.002	●
	GTMH32200R _L SSH 	.079 2.00	.106 2.7	.002	●
 GTPA.. 	GTPA20FRN01	.079 2.00	.236 6.0	-.004	○
	GTPA25FRN01	.098 2.50	.236 6.0	-.004	○

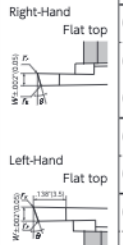
Back turning

Shape	Item Number	Max Depth of Cut b (Inch) (mm)	θ	r _e (Inch)	KM1	
 TBP.. 	TBP60FR _L V 	.209 5.3	60°	0.00	●	
	TBP60FR _L V05 	.209 5.3	60°	.002	●	
	TBP60FR _L V10 	.209 5.3	60°	.004	●	

Threading

Shape	Item Number	Hand	θ	f	r _e (Inch)	Pitch (TPI) (mm)	KM1
	TTP60FR4AS 	Right	60°	.016	(.002) MAX Flat	127-34 0.2-0.75	○
	TTP60FR8AS 		60°	.031	(R.002)	63-21 0.4-1.25	○
	TTP60FR4BS 		60°	.016	(.002) MAX Flat	127-34 0.2-0.75	○
	TTP60FR8BS 		60°	.031	(R.002)	63-21 0.4-1.25	○
	TTP60FR-NS 		60°	.049	(R.004)	25-17 1.0-1.5	○
	TTP60FL4AS 	Left	60°	.016	(.002) MAX Flat	127-34 0.2-0.75	○
	TTP60FL8AS 		60°	.031	(R.002)	63-21 0.4-1.25	○
	TTP60FL4BS 		60°	.016	(.002) MAX Flat	127-34 0.2-0.75	○
	TTP60FL8BS 		60°	.031	(R.002)	63-21 0.4-1.25	○
	TTP60FL-NS 		60°	.049	(R.004)	25-17 1.0-1.5	○

Cut off

Shape	Item Number	Hand	Max. Cut-off Dia. φ D (Inch) (mm)	w (Inch)	θ	r _e (Inch)	KM1
 CTP FR../FL.. 	CTP10FRV 	Right	.472 12.0	.039	20°	0.0	●
	CTP15FRV 		.472 12.0	.059	20°	0.0	●
	CTP20FRV 		.472 12.0	.079	20°	0.0	●
	CTP15FRNV 		.472 12.0	.059	0°	0.0	●
	CTP20FRNV 		.472 12.0	.079	0°	0.0	●
	CTP15FLKV 	Left	.433 11.0	.059	20°	0.0	●
	CTP15FLNV 		.472 12.0	.059	0°	0.0	●
	CTP20FLNV 		.472 12.0	.079	0°	0.0	●
	CTPA20FRV 	Right	.630 16.0	.079	20°	0.0	●
	CTPA20FRNV 		.630 16.0	.079	0°	0.0	●
	CTPA20FLKV 	Left	.571 14.5	.079	20°	0.0	●
	CTPA20FLNV 		.630 16.0	.079	0°	0.0	●