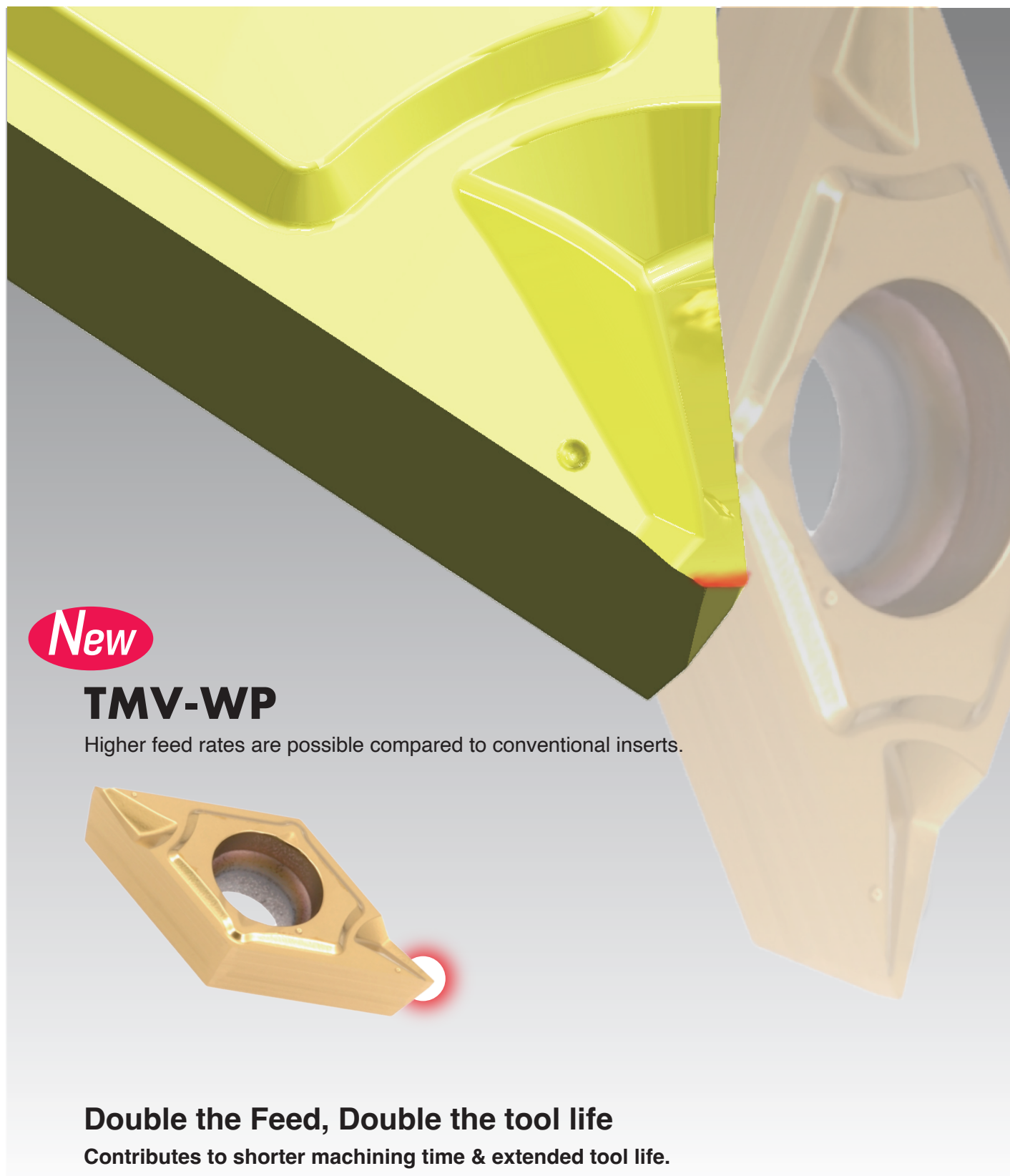


ISO insert with wiper **TMV-WP**

For External machining | CNC automatic lathes



New

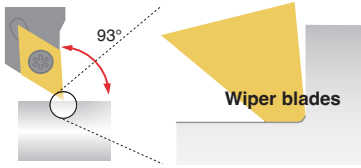
TMV-WP

Higher feed rates are possible compared to conventional inserts.

Double the Feed, Double the tool life
Contributes to shorter machining time & extended tool life.

I Performance

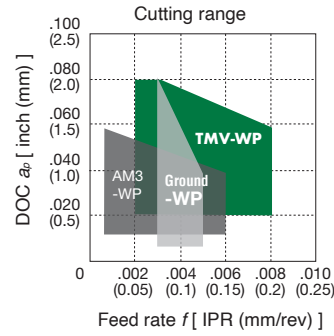
Achieves superior surface finish.
Maintains good surface finish even at high feed rate, enhancing productivity for workpieces requiring high machining accuracy.



Please use 93 degree set angle toolholder.

* The wiper function is effective when the cutting edge is parallel to the workpiece surface.

I Function range



Allows for a wider cutting range, higher feed and deeper cuts.

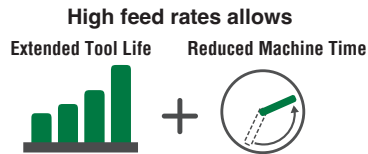
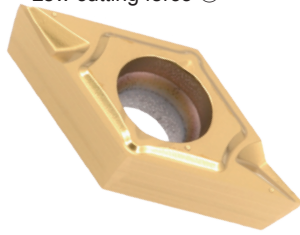
I Recommendation

Conventional: Mold chipbreaker AM3-WP	Conventional: Ground - Chipbreaker S/U-WP
Toughness	Sharpness

New 1st recommendation **TMV-WP**

Good chip control
Low cutting force

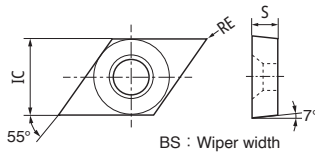
Chipbreaker shape suitable for high feed rates achieves excellent chip control and low cutting force.



I Practical example

Insert	TMV-WP	
Workpiece	SUS303	
Cutting conditions	Cutting speed	250 SFM (77 m/min)
	Feed rate	.002 IPR (0.06 mm/rev)
	DOC	.070 inch (1.7 mm)
	Coolant	WET
Results	<p>Number of workpiece (pcs/corner)</p> <p>NTK Competitor</p> <p>Tool life 1.6 times</p>	
	<p>Machining Time</p> <p>NTK 6.6 sec Competitor 9.5 sec</p> <p>2.9s reduced</p>	

I Lineup



Recommended Grade : 1st 2nd

P	Steel				
M	Stainless steel				
N	Nonferrous metals				
S	Heat-resistant alloys				

Shape	Designation		IC		S		RE		BS		PVD Coated grade			
	inch	Metric	inch	mm	inch	mm	inch	mm	inch	mm	650	ST4	DM4	TM4
New TMV	DCGT32.504MRTMV-WP	DCGT11T301MRTMV-WP	.375	9.525	.156	3.97	.003	0.08	(.012)	(0.3)				
	DCGT32.508MRTMV-WP	DCGT11T302MRTMV-WP					.007	0.18						

Above shows Right-handed insert

Standard item Made-to-order products

I TMV Chipbreaker centerline height

Item number (inch / mm)			Centerline height from the reference surface (Blue)			Centerline height from the reference surface (Red)	
inch	mm		inch	mm		inch	mm
DCGT32.504MR-TMV	DCGT11T301MRTMV-WP		.020"	0.51		.003"	0.08
DCGT32.508MR-TMV	DCGT11T302MRTMV-WP		.021"	0.53		.004"	0.10



Tungaloy-NTK America Inc.

3726 N Ventura Drive, Arlington Heights, IL 60004, U.S.A.

Contact us producttechnicalsupport@tungaloy-ntk.com