

Body

Model. No.	Figure Fig.	Blades	Dimensions (mm)							α°
			ϕD	ϕD_s	ϕd	ϕd_n	L	ℓ_s	ℓ_n	
BM4524T	①	1	25.20	4.49	10	26	67	45	22	45°
BM4524TL	②	1	25.20	4.49	10	26	110	88	22	45°
BM4531T	③	1	33.6	11.57	12	33	75	50	25	45°
BM4538T	④	1	39.83	18.17	12	40	75	50	25	45°
BM4552T	⑤	1	53.91	32.17	13	54	80	55	25	45°
BM4566T	⑥	1	67.94	46.17	13	68	80	55	25	45°
BM3029T	⑦	1	30.2	5.52	10	30	74	45	29	30°
BM6021T	⑧	1	21.77	6.60	10	23	69	45	24	60°



- ※ 1 piece TM32GUR HSS Insert is supplied as standard accessory
- ※ Clamp Screw, lock pin and wrench are supplied as standard accessory

Cutting Conditions

Model. No.	TM32GUR HSS	TM32GUR HSS TiAlN	TM32GSR HSS	TM32GSR HSS TiAlN
	Rotation Speed (r.p.m.)			
BM4524T	160~320	200~400	160~320	200~400
BM4524TL	160~320	200~400	160~320	200~400
BM4531T	130~280	150~350	130~280	150~350
BM4538T	130~280	150~350	130~280	150~350
BM4552T	80~120	100~150	80~120	100~150
BM4566T	40~80	50~100	40~80	50~100
BM3029T	160~320	200~400	160~320	200~400
BM6021T	160~320	200~400	160~320	200~400

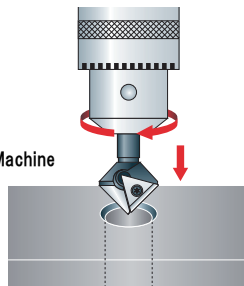
- Depending on the Machine's rigidity, above conditions may not be Suitable.
- In case of soft material like Aluminum, Copper etc., reduce rotation speed accordingly
- In case the chattering is occurred, rotation speed will have to be reduced and use cutting oil
- Please use our original Insert for our tool
- According to the shape, clamp condition and volume of chamfering amount the above cutting condition have to be adjusted. For large amount chamfering, the rate will have to be reduced

Processing Example

[$\phi 12\text{mm}$ Bore mouth chamfering]

- Body : BM4524T
- Insert : TM32GUR HSS

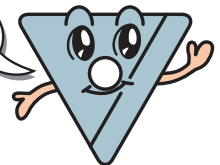
- Material : SUS304
- Rotation Speed : 320r.p.m.
- Use machine : Bench type Drilling Machine



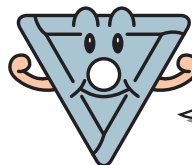
Result

Good ! No deburring even after more than 1000 time processing

Blade length is 2-3mm longer than TM32GSR and can be widely processed



TM32GUR



TM32GSR

TM32GUR have 2-usable corners (front and rear) but TM32GSR have 6-usable corners. Saving production cost !

Insert

Figure	Model No.	Material	Blade Shape	Coating	Usable Corner	Quantity per box
	TM32GUR HSS	HSS	Sharp edge	None	2	3
	TM32GUR HSS TiAlN	HSS	Sharp edge	TiAlN	2	3
	TM32GSR HSS	HSS	Sharp edge	None	6	3
	TM32GSR HSS TiAlN	HSS	Sharp edge	TiAlN	6	3



Please do not take reverse tightening when mounting insert. Poor accuracy or breakage of insert could be occurred
Please make sure that reverse tightening is made or not