

Chamfer Cutter

INCH

METRIC

JCM & CMTPR type - 45 degree



Fig. 1

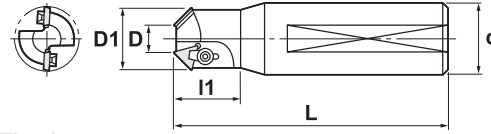
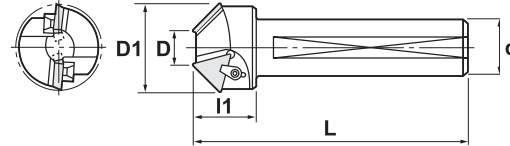


Fig. 2



Specifications - Inch

CATALOG NUMBER	STK	DIMENSIONS						INSERT	Q	PARTS		
		D	D1	L	I1	d	FIG.			Screw	Wrench	Clamp/Clamp Set
JCM-2050	•	.500	1.02	4.72	1.18	1.25	1	TPMN-221 / TPGN-221	2	-	LW-025	DCM-1
JCM-2075	•	.750	1.49	4.72	1.59	1.25	2	TPMN-322 / TPGN-322	2	-	LW-030	DCM-5
JCM-2112	•	1.12	2.09	4.72	1.59	1.25	2	TPMN-432 / TPGN-432	2	SLS-3	LW-040	DCM-2

Note: All cutters are supplied without inserts.

Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS						INSERT	Q	PARTS		
		D	D1	L	I1	d	FIG.			Screw	Wrench	Clamp/Clamp Set
CMTPR122S32	•	12	25.8	120	30	32	1	TPMN110304 TPGN110304	2	-	LW-025	DCM-1
CMTPR182S32	•	18	37.9	120	40	32	2	TPMN160308 TPGN160308	2	-	LW-030	DCM-5
CMTPR282S32	•	28	55.6	120	40	32	2	TPMN220408 TPGN220408	2	SLS-3	LW-040	DCM-2

Note: All cutters are supplied without inserts.

Inserts

	CATALOG NUMBER		DIMENSIONS			COATED			UNCOATED		
	ANSI	ISO	A	T	R	JC5040	JC215V	JC730U	NIT	UMS	KT9
	TPMN-221	TPMN110304	.250	.125	.015	•	•	•	•	•	•
TPMN-322(T)	TPMN160308(T)	.375	.125	.031	•	•	•	•	•	•	
TPMN-432 (T)	TPMN220408(T)	.500	.187	.031	•	•	•	•	•	•	
TPGN-221	TPGN110304	.250	.125	.015						•	
TPGN-322	TPGN160308	.375	.125	.031						•	
TPGN-432	TPGN220408	.500	.187	.031						•	

Recommended Cutting Data - Inch

WORK MATERIAL	INSERT GRADE	SPEED (SFM)	FEED RATE (IPT)
Carbon Steel	JC5040, JC215V, UMS	400	.006
Alloy Steel	JC5040, JC215V, UMS	300	.008
Stainless Steel	JC730U, JC215V, UMS	250	.006
Cast Iron	JC215V, KT9	300	.008

Recommended Cutting Data - Metric

WORK MATERIAL	INSERT GRADE	SPEED (m/min)	FEED RATE (mm/tooth)
Carbon Steel	JC5040, JC215V, UMS	100-150	0.1 - 0.2
Alloy Steel	JC5040, JC215V, UMS	60-120	0.1 - 0.3
Cast Iron	JC215V, KT9	80-100	0.1 - 0.2