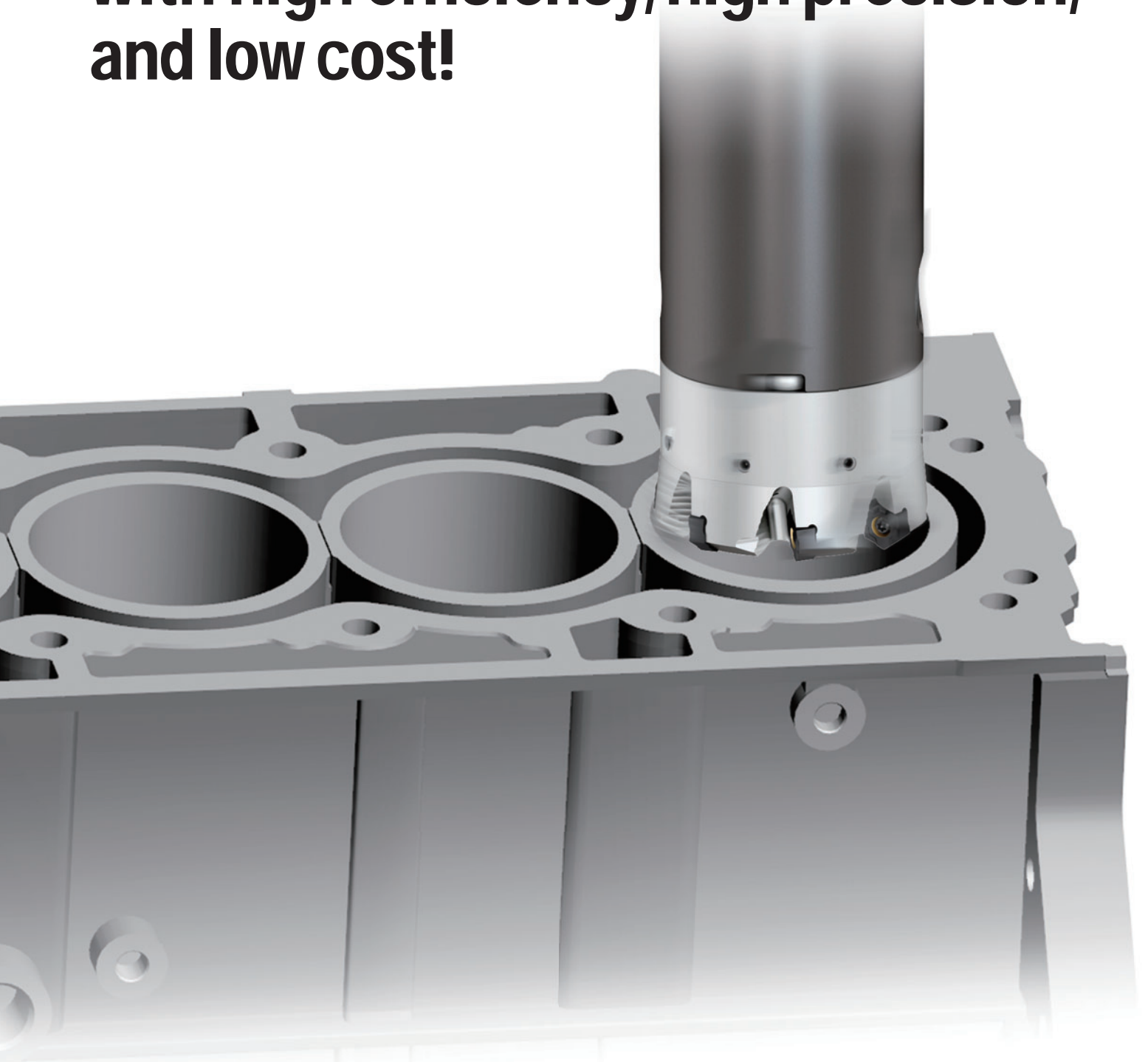


Boring Cutter

BMR

New
Product

**For cylinder block,
Hexagonal double-sided inserts
with high efficiency, high precision,
and low cost!**



Boring Cutter

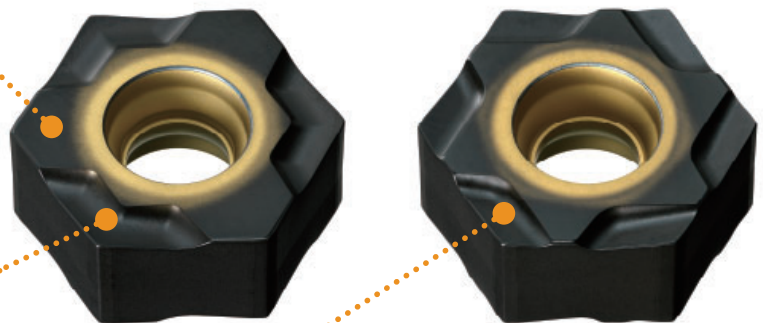
BMR

Inventory maintained of highly rigid
6-corner type and economical
12-corner type inserts



High Clamping Rigidity

High feed processing possible with improved fracture resistance.



Double Positive Breaker

Reduced cutting resistance. Supports open deck work. Effective finished surface due to wiper edge.

12-Corner Type with Right Hand

Economical 12-corner type that preserves comparable insert rigidity of the 6-corner type by securing the seating surface directly below where the cutting force is absorbed.

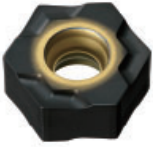
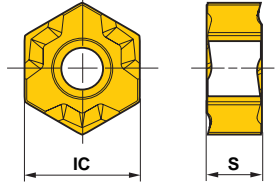
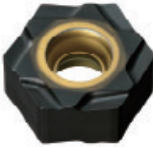
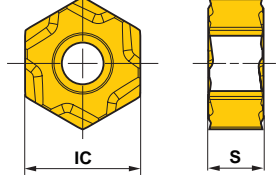


Body with Peripheral Cutting Edge Run-out Regulator

With peripheral cutting edge regulating function for possible use of economical M-class inserts.

* The bodies are only available by special order.

INSERT


Shape	Order Number	Grade	Hand	Cutting edge	Stock	Dimensions (mm)		Geometry
						IC	S	
	HNMX1206EN06-R	MC5015	–	6	●	12.7	6.0	
	HNMX1206ER12-R	MC5015	R	12	●	12.7	6.0	

RECOMMENDED CUTTING CONDITIONS

Work Material	Tensile Strength	Grade	Cutting Speed v_c (m/min)	Feed per Tooth f_z (mm/t.)	Cutting depth a_e (mm)
K Gray Cast Iron	≤350MPa	MC5015	200 (150–250)	0.2 (0.1–0.25)	≤3.0

* With feed per cutter, settings are set small for finished surface roughness and large for ideal product life.

APPLICATION EXAMPLES

Cutter Body	BMR ø85 (7 inserts)	
Insert (Grade)	HNMX1206EN06-R(MC5015)	
Workpiece	FC Cutting diameter : ø85 Cutting depth : 140mm	
Cutting Conditions	Revolution (min-1)	750
	Cutting Speed (m/min)	200
	Feed (mm/t.)	0.2
	Table Feed (mm/min)	1050
	Depth of Cut (mm)	2.0
Cutting mode		Wet
Results	Improve machining efficiency by 2.2x and approximately 5x longer tool life, under conventional conditions. Stable cutting with favorable finished surface roughness and achievable cylindricity.	

The above application examples are customer's application examples, so it can be different from the recommended conditions.

For Your Safety

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When attaching inserts or spare parts, please use only the correct wrench or driver. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

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 (Tools specifications subject to change without notice.)