

For Drilling Machine

For Customers Purchased

Clamp Screw
M-1

Wrench
MA-1

New type



Old type.

To customers who only purchase tools and parts

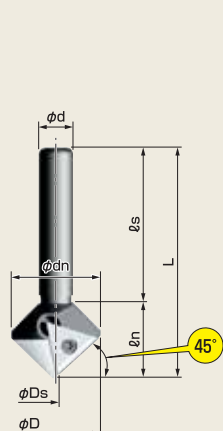
Lock pin
L-6Wrench
K-3

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

Please check it

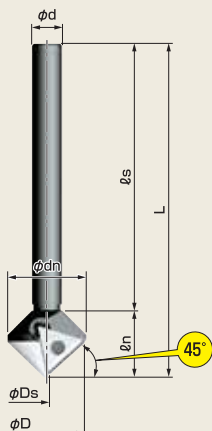
4 BM4538T, 5 BM4552T, 6 BM4566T
 There are new type and old type.

- Fantastic machining with HSS insert and breaker originally designed by us
 Line-up 30°, 45° and 60° fantastic angle processing are ensured



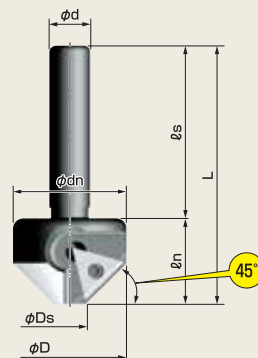
1 BM4524T

TM32GUR : $\phi 5\text{mm} \sim \phi 24\text{mm}$
 TM32GSR : $\phi 5\text{mm} \sim \phi 21\text{mm}$



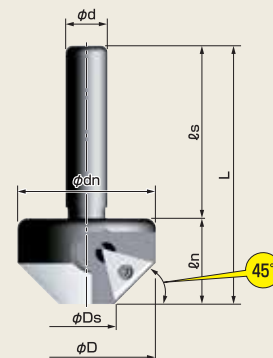
2 BM4524TL

TM32GUR : $\phi 5\text{mm} \sim \phi 24\text{mm}$
 TM32GSR : $\phi 5\text{mm} \sim \phi 21\text{mm}$



3 BM4531T

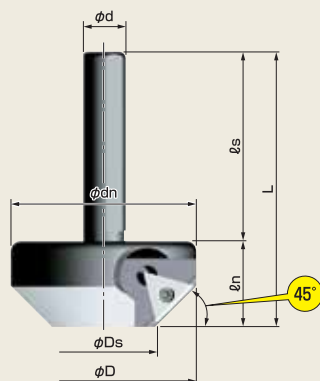
TM32GUR : $\phi 12\text{mm} \sim \phi 31\text{mm}$
 TM32GSR : $\phi 12\text{mm} \sim \phi 28\text{mm}$



4 BM4538T

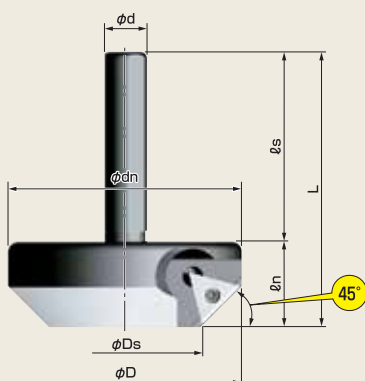
TM32GUR : $\phi 19\text{mm} \sim \phi 38\text{mm}$
 TM32GSR : $\phi 19\text{mm} \sim \phi 36\text{mm}$

※ Please purchase a commercially available product separately.



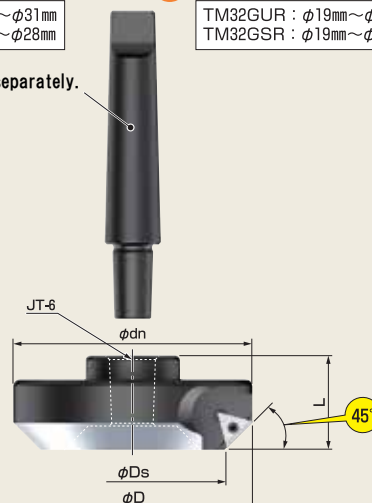
5 BM4552T

TM32GUR : $\phi 33\text{mm} \sim \phi 52\text{mm}$
 TM32GSR : $\phi 33\text{mm} \sim \phi 50\text{mm}$



6 BM4566T

TM32GUR : $\phi 47\text{mm} \sim \phi 66\text{mm}$
 TM32GSR : $\phi 47\text{mm} \sim \phi 64\text{mm}$



7 BM4580T-JT6

TM32GUR : $\phi 61\text{mm} \sim \phi 80\text{mm}$
 TM32GSR : $\phi 61\text{mm} \sim \phi 77\text{mm}$

BM4594T-JT6

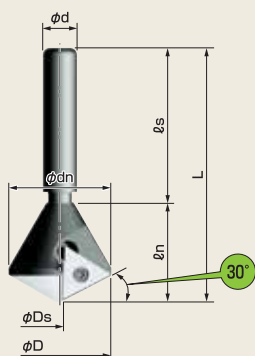
TM32GUR : $\phi 75\text{mm} \sim \phi 94\text{mm}$
 TM32GSR : $\phi 75\text{mm} \sim \phi 91\text{mm}$

BM45100T-JT6

TM32GUR : $\phi 81\text{mm} \sim \phi 100\text{mm}$
 TM32GSR : $\phi 81\text{mm} \sim \phi 97\text{mm}$

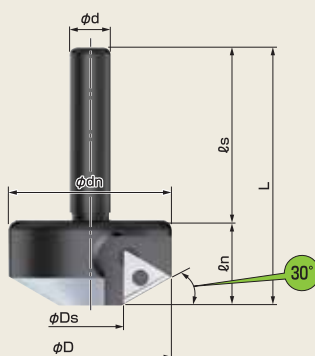
BM45108T-JT6

TM32GUR : $\phi 89\text{mm} \sim \phi 108\text{mm}$
 TM32GSR : $\phi 89\text{mm} \sim \phi 105\text{mm}$



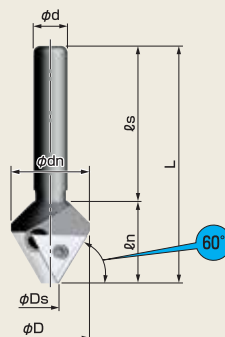
8 BM3029T

TM32GUR : $\phi 6\text{mm} \sim \phi 29\text{mm}$
 TM32GSR : $\phi 6\text{mm} \sim \phi 26\text{mm}$



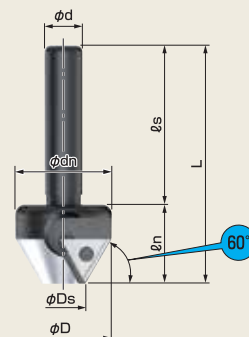
9 BM3047T

TM32GUR : $\phi 21\text{mm} \sim \phi 46\text{mm}$
 TM32GSR : $\phi 21\text{mm} \sim \phi 43\text{mm}$



10 BM6021T

TM32GUR : $\phi 7\text{mm} \sim \phi 21\text{mm}$
 TM32GSR : $\phi 7\text{mm} \sim \phi 19\text{mm}$



11 BM6030T

TM32GUR : $\phi 15\text{mm} \sim \phi 29\text{mm}$
 TM32GSR : $\phi 15\text{mm} \sim \phi 27\text{mm}$

Body

Model. No.	Figure	Blades	Dimensions (mm)							
			φD	φDs	φd	φdn	L	ℓs	ℓn	α°
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	33.06	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°
BM4580T-JT6	⑦	1	81.96	60.17	10	82	40	45	29	45°
NEW BM4594T-JT6	⑦	1	95.96	74.17		96	40			45°
BM45100T-JT6	⑦	1	101.96	80.16		101	40			45°
NEW BM45108T-JT6	⑦	1	109.96	88.17		110	40			45°
BM3029T	⑧	1	30.2	5.52	10	30	74	45	29	30°
BM3047T	⑨	1	47.39	21	12	47.5	75	50	25	30°
BM6021T	⑩	1	21.77	6.60	10	23	69	45	24	60°
BM6030T	⑪	1	30.38	15	12	30.4	75	50	25	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	TM32GSR AC16N
	Rotation Speed (r.p.m.)				
BM4524T	160~320	200~400	160~320	200~400	200~400
BM4524TL	160~320	200~400	160~320	200~400	200~400
BM4531T	130~280	150~350	130~280	150~350	150~350
BM4538T	130~280	150~350	130~280	150~350	150~350
BM4552T	80~120	100~150	80~120	100~150	100~150
BM4566T	40~80	50~100	40~80	50~100	50~100
BM4580T-JT6	20~50	20~50	20~50	20~50	20~50
BM4594T-JT6	20~50	20~50	20~50	20~50	20~50
BM45100T-JT6	20~50	20~50	20~50	20~50	20~50
BM45108T-JT6	20~50	20~50	20~50	20~50	20~50
BM3029T	160~320	200~400	160~320	200~400	200~400
BM3047T	130~280	150~350	130~280	150~350	150~350
BM6021T	160~320	200~400	160~320	200~400	200~400
BM6030T	130~280	150~350	130~280	150~350	150~350

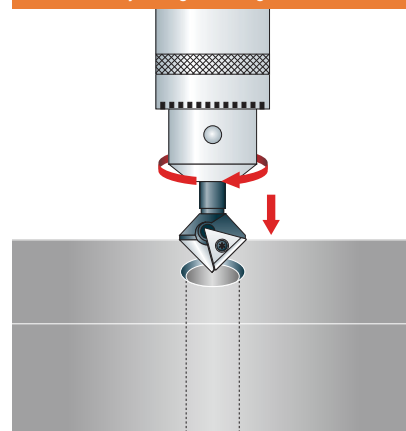
● Depending on the Machine's rigidity, above conditions may not be Suitable.

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

Chamfering and Deburring
by Drilling and Milling Machines

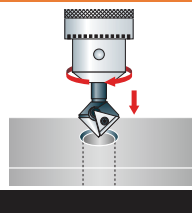
Model. No.	Capacity	
	TM32GUR	TM32GSR
BM4524T	φ5mm~φ24mm	φ5mm~φ21mm
BM4524TL	φ5mm~φ24mm	φ5mm~φ21mm
BM4531T	φ12mm~φ31mm	φ12mm~φ28mm
BM4538T	φ19mm~φ38mm	φ19mm~φ36mm
BM4552T	φ33mm~φ52mm	φ33mm~φ50mm
BM4566T	φ47mm~φ66mm	φ47mm~φ64mm
BM4580T-JT6	φ61mm~φ80mm	φ61mm~φ77mm
BM4594T-JT6	φ75mm~φ94mm	φ75mm~φ91mm
BM45100T-JT6	φ81mm~φ100mm	φ81mm~φ97mm
BM45108T-JT6	φ89mm~φ108mm	φ89mm~φ105mm
BM3029T	φ6mm~φ29mm	φ6mm~φ26mm
BM3047T	φ21mm~φ46mm	φ21mm~φ43mm
BM6021T	φ7mm~φ21mm	φ7mm~φ19mm
BM6030T	φ15mm~φ29mm	φ15mm~φ27mm

Processing Example

[φ12mm Bore mouth chamfering]

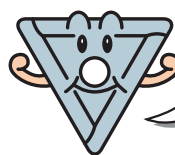
■ Body : BM4524T
■ Insert : TM32GUR HSS

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



Result

Good ! No deburring even after more than 1000 time processing



TM32GSR

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

TM32GUR



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
	NEW TM32GSR AC16N	Fine particles Carbide	Honing edge	AlCrN	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