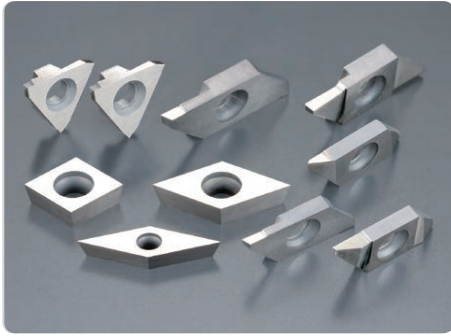


KM1

Best tool for PEEK material

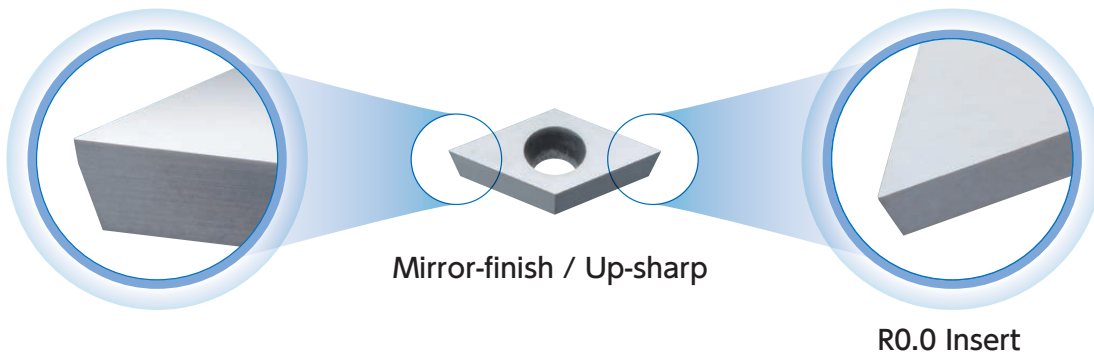


Features

- NTK's KM1 inserts are designed for other non-ferrous materials such as PEEK
- Extremely up-sharp edge and mirror insert surface creates excellent surface finishes
- R 0.0 corner radius inserts are available

Medical – Plunger tip		
Material: PEEK		
Insert	Competitor Carbide: VCGTFN	NTK Carbide: VCGW2208H KM1
Speed	300 SFM	Same
Feed	.0025 IPR	Same
Depth of Cut	.098 inches	Same
Coolant	Dry	Air
Tool life	40 pcs.	65 pcs.
Result	KM1 increased productivity with exceptional ground edge.	

Special component – Internal plunger		
Material: PEEK		
Insert	NTK: DCGW 32.508H KM1	
Holder	SDJCR1212X11N	
Speed	442 SFM	
Feed	.002 IPR	
Depth of Cut	.045"	
Length of cut	2.18"	
Coolant	Dry	
Result	Excellent surface finish.	






Cover all applications



Front turning	Back turning	Cut-off	Grooving / side turning	Threading
CC DC VC	TBP	CTP CTPA	GTMH GTPA	TTP

Grade	Work material	Application	Cutting Speed (SFM)	Feed (IPR)	Depth of Cut (inch)	DRY	WET
KM1	PEEK Copper Brass Aluminum Plastics	Turning	160-300 (160-650)	.0004-.004	-.100	●	●


Front turning

Shape	Item Number	ISO Item Number	IC	R	KM1
 CCGW..	CCGW 21.501 H M	CCGW 060200 H	1/4	.001	●
	CCGW 21.504 H M	CCGW 060201 H	1/4	.004	●
	CCGW 21.508 H M	CCGW 060202 H	1/4	.008	●
	CCGW 32.501 H M	CCGW 09T300 H	3/8	.001	●
	CCGW 32.504 H M	CCGW 09T301 H	3/8	.004	●
	CCGW 32.508 H M	CCGW 09T302 H	3/8	.008	●
 DCGW..	DCGW 21.501 H M	DCGW 070200 H	1/4	.001	●
	DCGW 21.504 H M	DCGW 070201 H	1/4	.004	●
	DCGW 21.508 H M	DCGW 070202 H	1/4	.008	●
	DCGW 32.501 H M	DCGW 11T300 H	3/8	.001	●
	DCGW 32.504 H M	DCGW 11T301 H	3/8	.004	●
	DCGW 32.508 H M	DCGW 11T302 H	3/8	.008	●
 VCGW..	VCGW 2201 H M	VCGW 110300 H	1/4	.001	●
	VCGW 2204 H M	VCGW 110301 H	1/4	.004	●
	VCGW 2208 H M	VCGW 110302 H	1/4	.008	●

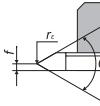
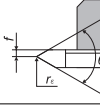
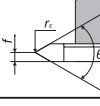
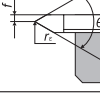
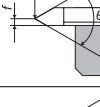
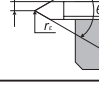
Grooving / Side turning

Shape	Item Number	Groove Width W (Inch) (mm)	Max Depth of Cut (Inch) (mm)	r_e (Inch)	KM1
 GTMH.. <small>W±.001(0.025)</small> <small>1.18° (3.18)</small>	GTMH32100R $\frac{1}{2}$ SSH M	.039 1.00	.063 1.6	.002	●
	GTMH32150R $\frac{1}{2}$ SSH M	.059 1.50	.106 2.7	.002	●
	GTMH32200R $\frac{1}{2}$ SSH M	.079 2.00	.106 2.7	.002	●
 GTPA.. <small>r_e</small> <small>276/17.0</small> <small>276/17.0</small>	GTPA20FRN01	.079 2.00	.236 6.0	-.004	○
	GTPA25FRN01	.098 2.50	.236 6.0	-.004	○


Back turning

Shape	Item Number	Max Depth of Cut b (Inch) (mm)	θ	r_e (Inch)	KM1	
					R	L
 TBP.. <small>.008 (0.2)</small> <small>.008 (0.2)</small> <small>.008 (0.2)</small>	TBP60FR $\frac{1}{2}$ V M	.209 5.3	60°	0.00	●	
	TBP60FR $\frac{1}{2}$ V05 M	.209 5.3	60°	.002	●	
	TBP60FR $\frac{1}{2}$ V10 M	.209 5.3	60°	.004	●	

Threading

Shape	Item Number	Hand	θ	f	r_e (Inch)	Pitch (TPI) (mm)	KM1	
	TTP60FR4AS M	Right	60°	.016	(.002) MAX Flat	127-34 0.2-0.75	○	
	TTP60FR8AS M		60°	.031	(R.002)	63-21 0.4-1.25	○	
	TTP60FR4BS M		60°	.016	(.002) MAX Flat	127-34 0.2-0.75	○	
	TTP60FR8BS M		60°	.031	(R.002)	63-21 0.4-1.25	○	
	TTP60FR-NS M		60°	.049	(R.004)	25-17 1.0-1.5	○	
	TTP60FL4AS M		Left	60°	.016	(.002) MAX Flat	127-34 0.2-0.75	○
	TTP60FL8AS M			60°	.031	(R.002)	63-21 0.4-1.25	○
	TTP60FL4BS M			60°	.016	(.002) MAX Flat	127-34 0.2-0.75	○
	TTP60FL8BS M	60°		.031	(R.002)	63-21 0.4-1.25	○	
	TTP60FL-NS M	60°		.049	(R.004)	25-17 1.0-1.5	○	

Cut off

Shape	Item Number	Hand	Max. Cut-off Dia. ϕD (Inch) (mm)	w (Inch)	θ	r_e (Inch)	KM1	
 CTP FR./FL.. Right-Hand Flat top <small>W±.001(0.025)</small> <small>1.18° (3.18)</small> Left-Hand Flat top <small>W±.001(0.025)</small> <small>1.18° (3.18)</small>	CTP10FRV M	Right	.472 12.0	.039	20°	0.0	●	
	CTP15FRV M		.472 12.0	.059	20°	0.0	●	
	CTP20FRV M		.472 12.0	.079	20°	0.0	●	
	CTP15FRNV M		.472 12.0	.059	0°	0.0	●	
	CTP20FRNV M		.472 12.0	.079	0°	0.0	●	
	CTP15FLKV M		Left	.433 11.0	.059	20°	0.0	●
	CTP15FLNV M	.472 12.0		.059	0°	0.0	●	
	CTP20FLNV M	.472 12.0		.079	0°	0.0	●	
	CTPA20FRV M	Right		.630 16.0	.079	20°	0.0	●
	CTPA20FRNV M			.630 16.0	.079	0°	0.0	●
	CTPA20FLKV M			Left	.571 14.5	.079	20°	0.0
	CTPA20FLNV M	.630 16.0	.079		0°	0.0	●	

