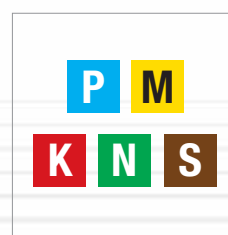
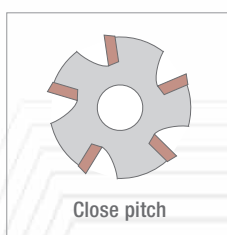
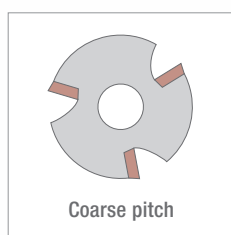
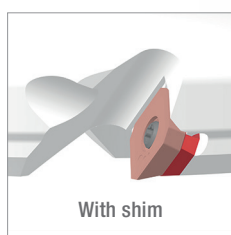




4FACEPLUS ACTION

Sistema di fresatura a spianare per utilizzo generico



Acquista 30 inserti e ottieni il corpo fresa allo sconto speciale del 60%

Inserti: SEET13, SEMT13, SEEW13

Corpi fresa: NT-SE13

nikkoTOOLS

uemme
TOOLS and EQUIPMENT

VALIDITA': 31/12/2024

4FACEPLUS

Face milling system for multiple use general purpose operations

APPLICATION

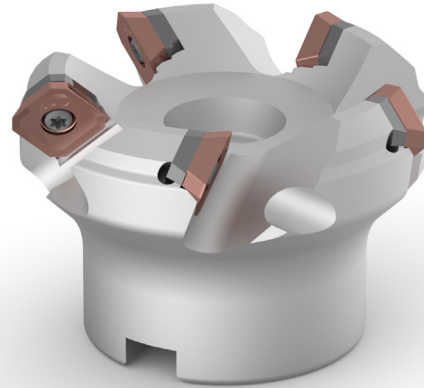
- Finishing / semi-finishing / rough face milling
- Removal of the crusted surfaces
- General milling of interrupted surfaces
- Machining of linear and helical ramping

ISO APPLICATION FIELDS

P M K N S

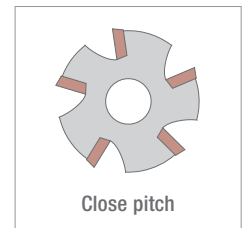
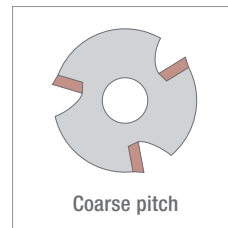
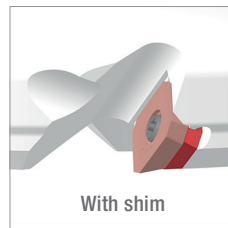
ADVANTAGES AND CHARACTERISTICS

- High productivity and easy to use
- Light cutting action with low power consumption
- Available in E tol. (ground type) and M tol. (pressed type)
- Available with wiper geometry for good surface finish



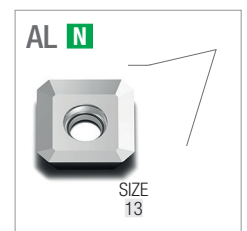
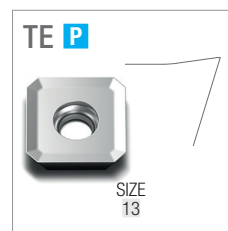
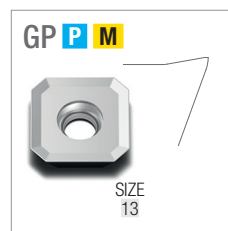
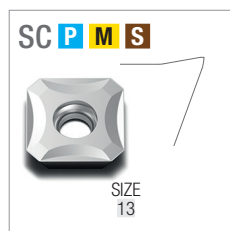
● Cutter bodies

- Arbor type with shim
- From D50 to D200



● Inserts

- 4 cutting edges
- Edge length 13 with APMX = 6mm
- Cemented carbide grades with CVD and PVD coatings
- Geometries: SC, GP, TE, AL, GG, GH, Flat, WU



<h1>NT-SE</h1>		
<h2>4FacePlus</h2>		
<ul style="list-style-type: none"> • Positive general face milling cutters • With shims to protect the insert seats • Kapr 45°, without coolant through 		

Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	DCX	WT	MIID
NT-SE13 D040-F16-Z03	○	40	3	16	40	-	35	-	53	-	SE0013T3
NT-SE13 D050-F22-Z04	●	50	4	22	40	-	40	-	63	0.41 Kg	SE0013T3
NT-SE13 D050-F22-Z05	●	50	5	22	50	-	40	-	63	0.39 Kg	SE0013T3
NT-SE13 D063-F22-Z05	●	63	5	22	50	-	50	-	76	0.71 Kg	SE0013T3
NT-SE13 D063-F22-Z06	●	63	6	22	50	-	50	-	76	0.70 Kg	SE0013T3
NT-SE13 D080-F27-Z06	●	80	6	27	50	-	60	-	93	1.06 Kg	SE0013T3
NT-SE13 D080-F27-Z08	●	80	8	27	50	-	60	-	93	1.02 Kg	SE0013T3
NT-SE13 D100-F32-Z07	●	100	7	32	50	-	80	-	113	1.56 Kg	SE0013T3
NT-SE13 D100-F32-Z10	●	100	10	32	50	-	80	-	113	1.54 Kg	SE0013T3
NT-SE13 D125-F40-Z08	●	125	8	40	63	-	100	-	138	2.92 Kg	SE0013T3
NT-SE13 D125-F40-Z12	●	125	12	40	63	-	100	-	138	3.04 Kg	SE0013T3
NT-SE13 D160-F40-Z10	●	160	10	40	63	-	100	-	173	4.06 Kg	SE0013T3
NT-SE13 D200-F60-Z12	●	200	12	60	63	-	130	-	213	6.34 Kg	SE0013T3

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

Spare parts	Insert screws	Flag wrenches	Shim	Shim screws	L wrench
NT-SE13 D000-F00-Z00	NT-ST35120T15	NT-FTB15	NT-SH004	NT-SR002	NT-WR035

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

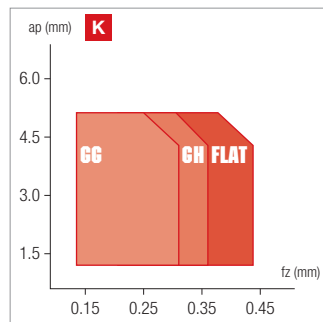
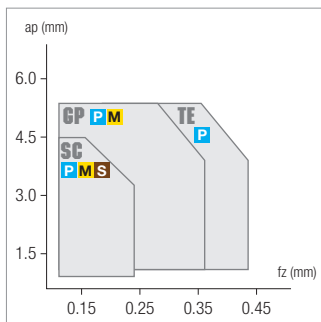
F - ACCESSORIES

G - SPARE PARTS

<h1>SE</h1>	HC: Coated carbide HF: Micrograin carbide HT: Cermet CVD: Chemical vapour deposition PVD: Physical vapour deposition										
	<h2>4FacePlus</h2>	HC CVD	HC CVD	HC CVD	HF PVD	HF PVD	HF PVD	HF PVD	HT	HF	
<ul style="list-style-type: none"> Positive general face milling inserts Diverse carbide grades with PVD and CVD coatings and also cermet grades available, covering a wide range of applications Sharp/universal/robust/cast iron featured/wiper geometries available 	Stable machining, light cut	● 1 st choice	○ suitable								
	General machining, medium cut	● 1 st choice	○ suitable	●	○	●	●	●	●	●	
	Unstable machining, heavy cut	⊕ 1 st choice	⊖ suitable	⊕	⊖	⊕	⊕	⊕	⊕	⊕	
	Dimensions	ISO									
		Vc(m/min) - suggested cutting speed range (bold: 1st choice)									
P		130 300		100 260	100 280	130 300					
M			90 210	60 180		80 200					
K		160 320	160 320		140 300						
N									300 1100		
S			30 70			20 60					
H											

Designation		BS	IC	S	D1	LE	Stock													
GENERAL 	SEET13T3AGEN-GP	1.2	13.4	3.97	4.4	8.8														
	SEMT13T3AGEN-GP	1.2	13.4	3.97	4.4	8.8	●	●	●											
GENERAL 	SEET13T3AGSN-GG	1.3	13.4	3.97	4.4	8.8														
	SEMT13T3AGSN-GG	1.3	13.4	3.97	4.4	8.8														
LOW FORCE 	SEET13T3AGEN-SC	1.7	13.4	3.97	4.4	8.8														
REINFORCED 	SEET13T3AGSN-TE	1.2	13.4	3.97	4.4	8.8														
	SEMT13T3AGSN-TE	1.2	13.4	3.97	4.4	8.8	●	●	●											
REINFORCED 	SEET13T3AGSN-GH	1.3	13.4	3.97	4.4	8.8														
	SEMT13T3AGSN-GH	1.3	13.4	3.97	4.4	8.8														

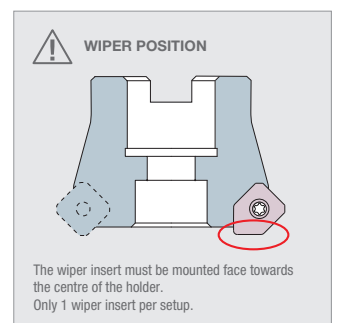
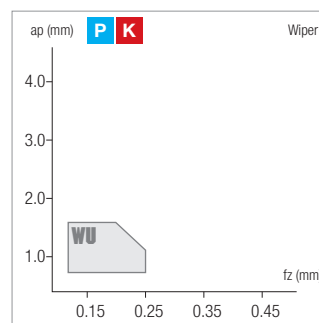
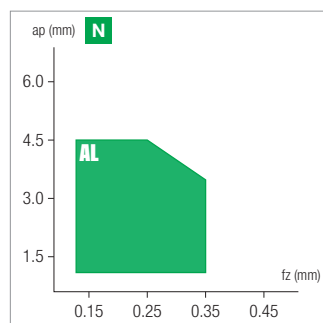
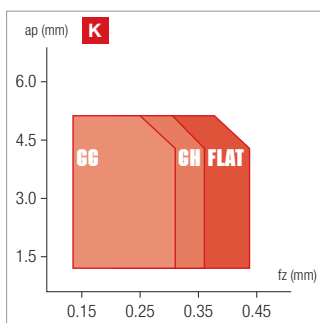
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion



<h1>SE</h1>	HC: Coated carbide HF: Micrograin carbide HT: Cermet CVD: Chemical vapour deposition PVD: Physical vapour deposition											
	HC CVD	HC CVD	HC CVD	HF PVD	HF PVD	HF PVD	HF PVD	HF PVD	HT	HF		
4FacePlus	JC7530	JC8520	JC9540	JP5530	JP7525	JP8725	JP9535	JU4525	JU6520			
<ul style="list-style-type: none"> Positive general face milling inserts Diverse carbide grades with PVD and CVD coatings and also cermet grades available, covering a wide range of applications Sharp/universal/robust/cast iron featured/wiper geometries available 	Stable machining, light cut ● 1 st choice ○ suitable											
	General machining, medium cut ● 1 st choice ○ suitable											
	Unstable machining, heavy cut ⚡ 1 st choice ⚡ suitable											
	Dimensions ISO Vc(m/min) - suggested cutting speed range (bold: 1 st choice)											
		P	130 300		100 260		100 280		130 300			
		M		90 210		60 180		80 200				
		K	160 320		160 320		140 300					
		N							300 1100			
		S		30 70				20 60				
		H										

Designation		BS	IC	S	D1	LE	Stock							
REINFORCED	Flat K flat type	SEEW13T3AGSN	7.5	13.4	3.97	4.4	8.8	▽						
	ALUMINIUM	AL N polished surface periphery ground	SEET13T3AGFN-AL	2.2	13.4	3.97	4.4	8.8						●
		WIPER	WU P K 1 edge	SEET13T3-WU	7.5	13.4	3.97	4.4	8.8			●	●	

● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion



	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC8520			JP5530			JP8725		
					min	start	max	min	start	max	min	start	max
A - TURNING	P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	100%	130	180	230	100	140	180	100	150	200
				30%	200	240	280	160	200	240	160	210	260
				10%	260	280	300	220	240	260	220	250	280
	P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	100%	100	140	180	80	120	160	90	130	170
				30%	160	200	240	120	160	200	130	170	210
				10%	220	240	260	180	200	220	190	210	230
B - THREADING	P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	100%	70	100	130	60	90	120	80	110	140
				30%	120	160	200	100	130	160	120	150	180
				10%	200	220	240	140	170	200	160	190	220
C - GROOVING	P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	100%	90	130	170	60	100	140	80	120	160
				30%	110	160	210	80	130	180	100	150	200
				10%	130	190	250	100	160	220	120	180	240
	P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	100%	70	100	130				60	90	120
				30%	80	110	140				70	100	130
				10%	90	120	150				80	110	140
D - MILLING	M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	100%	90	120	150	60	90	120	80	110	140
				30%	110	150	190	80	120	160	100	140	180
				10%	130	170	210	100	140	180	120	160	200
	M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		100%	80	110	140				70	100	130
				30%	90	120	150				80	110	140
				10%	100	130	160				90	120	150
E - DRILLING	K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	100%	160	200	240	140	180	220			
				30%	180	230	280	160	210	260			
				10%	200	260	320	180	240	300			
	K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	100%	120	160	200	100	140	180			
				30%	140	190	240	120	170	220			
				10%	160	220	280	140	200	260			
F - ACCESSORIES	K3 - K4	Austenitic and ADI cast iron (ex. 0.6660/GGL-NiCr 20 2/Ni-Resist 2, GJS-1000-5/ADI1000)	250 ÷ 500	100%	100	130	160	90	120	150			
				30%	120	160	200	120	150	180			
				10%	140	190	240	150	180	210			
G - SPARE PARTS	N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGA)		100%	300	400	500						
				30%	400	600	800						
				10%	500	800	1100						
	N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		100%	200	250	300						
				30%	300	350	400						
				10%	400	450	500						
	S1 - S2 - S3	Fe/Ni/Co based heat resistant alloys (ex. Hastelloy, Inconel 625, Inconel 718)		100%	30	40	50	20	30	40			
				30%	40	50	60	30	40	50			
				10%	50	60	70	40	50	60			
	S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		100%				40	50	60			
				30%				50	60	70			
				10%				60	70	80			

ae: radial depth of cut; DC: milling cutter diameter
Complete workpiece materials p. H1.

	DESIGNATION	ae/DC	DEPTH OF CUT			FEED RATE		
			ap (mm)			fz (mm)		
			min	start	max	min	start	max
A - TURNING	SEoT13T3AGEN-GP	100%	1.00	3.00	5.00	0.08	0.15	0.22
		30%	1.00	3.00	5.00	0.10	0.19	0.28
		10%	1.00	3.00	5.00	0.12	0.22	0.32
B - THREADING	SEET13T3AGEN-SC	100%	0.50	2.50	4.50	0.06	0.11	0.16
		30%	0.50	2.50	4.50	0.08	0.14	0.20
		10%	0.50	2.50	4.50	0.09	0.16	0.23
C - GROOVING	SEoT13T3AGSN-TE	100%	1.00	3.00	5.00	0.11	0.20	0.29
		30%	1.00	3.00	5.00	0.14	0.25	0.36
		10%	1.00	3.00	5.00	0.16	0.29	0.42
D - MILLING	SEoT13T3AGSN-GG	100%	0.50	2.50	4.50	0.10	0.18	0.26
		30%	0.50	2.50	4.50	0.12	0.22	0.32
		10%	0.50	2.50	4.50	0.14	0.26	0.38
E - DRILLING	SEoT13T3AGSN-GH	100%	1.00	3.00	5.00	0.13	0.23	0.33
		30%	1.00	3.00	5.00	0.16	0.28	0.40
		10%	1.00	3.00	5.00	0.19	0.33	0.47
F - ACCESSORIES	SEEW13T3AGSN	100%	1.00	3.00	5.00	0.14	0.24	0.34
		30%	1.00	3.00	5.00	0.18	0.30	0.42
		10%	1.00	3.00	5.00	0.21	0.35	0.49
G - SPARE PARTS	SEET13T3AGFN-AL	100%	0.50	2.50	4.50	0.06	0.11	0.16
		30%	0.50	2.50	4.50	0.08	0.14	0.20
		10%	0.50	2.50	4.50	0.09	0.16	0.23
	SEET13T3-WU	100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.09	0.18	0.27