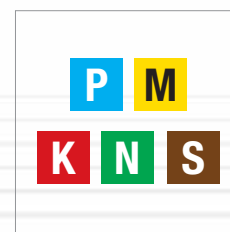
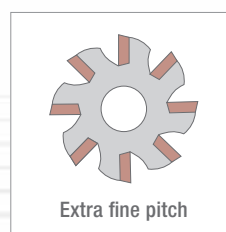
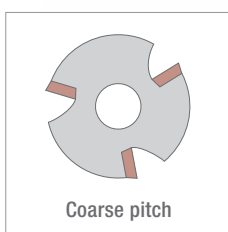




# DOUBLE4FACE ACTION

Il meglio per la fresatura a spianare a 45°



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

Inserti: SNEX12, SNMX12

Corpi fresa: NT-SX12H

**nikko**TOOLS

**uemme**  
TOOLS and EQUIPMENT

VALIDITA': 31/12/2024

# DOUBLE4FACE

First choice for high productivity face milling

## APPLICATION

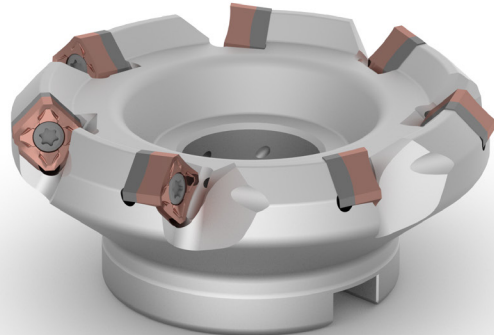
- Finishing / semi-finishing / rough face milling
- Removal of the crusted surfaces
- General milling of interrupted surfaces

## ISO APPLICATION FIELDS

**P M K N S**

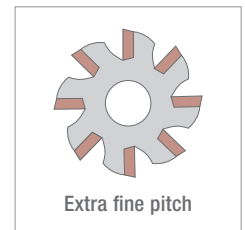
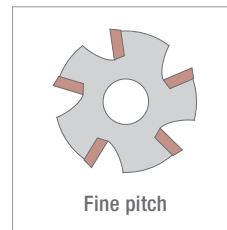
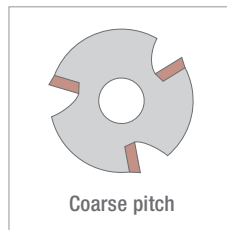
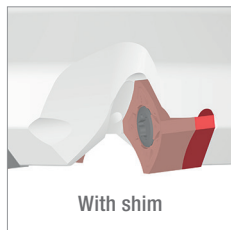
## ADVANTAGES AND CHARACTERISTICS

- Curved geometry generates low cutting force and smooth cutting process.
- Shim style cutter in the entire range guarantees high stability and operational.
- Complete grades covering ISO P, M, K, N, S materials (with both PVD and CVD coating).
- Accurate inserts in tolerance E or pressed inserts in tolerance M - available both high precision and high economical solutions.



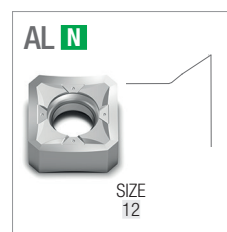
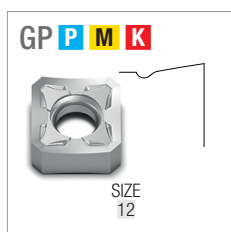
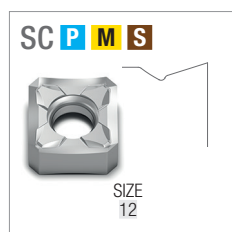
### • Cutter bodies

- Arbor type with shim
- From D50 to D160



### • Inserts






- 8 cutting edges
- Edge length 12 with APMX = 3 mm
- Cemented carbide grades with CVD and PVD coatings
- Geometries: SC, GP, TE, AL, WU wiper



<h1>NT-SX</h1>		
<p><b>Double4Face</b></p> <ul style="list-style-type: none"> <li>• Double-sided face milling cutters, Kapr 45°</li> <li>• With shims to protect the insert seats</li> <li>• For double-sided square inserts with 8 cutting edges</li> <li>• With coolant through</li> </ul>		

Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	DCX	WT	MIID
NT-SX12H D050-F22-Z04	●	50	4	22	40	-	48	-	64	0.48 Kg	SNoX1205
NT-SX12H D050-F22-Z05	●	50	5	22	40	-	48	-	64	0.46 Kg	SNoX1205
NT-SX12H D063-F22-Z05	●	63	5	22	50	-	52	-	77	0.69 Kg	SNoX1205
NT-SX12H D063-F22-Z06	●	63	6	22	50	-	52	-	77	0.67 Kg	SNoX1205
NT-SX12H D080-F27-Z06	●	80	6	27	50	-	60	-	94	1.29 Kg	SNoX1205
NT-SX12H D080-F27-Z07	●	80	7	27	50	-	60	-	94	1.27 Kg	SNoX1205
NT-SX12H D080-F27-Z08	●	80	8	27	50	-	60	-	94	1.25 Kg	SNoX1205
NT-SX12H D100-F32-Z07	●	100	7	32	50	-	70	-	114	1.64 Kg	SNoX1205
NT-SX12H D100-F32-Z08	●	100	8	32	50	-	70	-	114	1.62 Kg	SNoX1205
NT-SX12H D100-F32-Z09	●	100	9	32	50	-	70	-	114	1.59 Kg	SNoX1205
NT-SX12H D125-F40-Z10	●	125	10	40	63	-	80	-	139	2.92 Kg	SNoX1205
NT-SX12H D160-F40-Z12	●	160	12	40	63	-	85	-	174	4.36 Kg	SNoX1205

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

Spare parts	Insert screws	Flag wrenches	Shim	Shim screws	L wrench
NT-SX12H D <del>000</del> -F <del>00</del> -Z <del>00</del>					
	NT-ST40136T15	NT-FTB15	NT-SH009	NT-SR009	NT-WR040

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

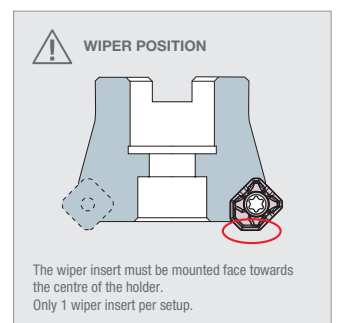
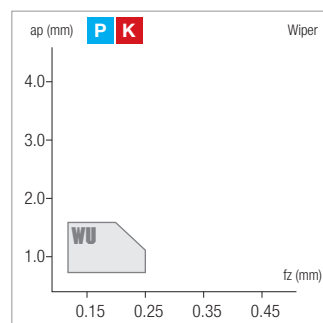
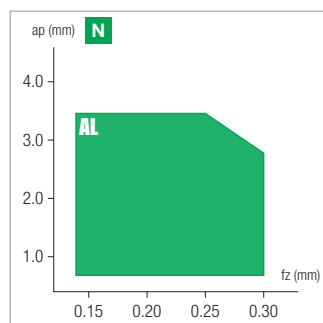
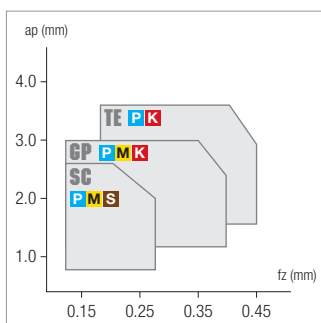
F - ACCESSORIES

G - SPARE PARTS

<h1>SN</h1>	HC: Coated carbide HF: Micrograin carbide CVD: Chemical vapour deposition PVD: Physical vapour deposition																		
	<h2>Double4Face</h2>	HC CVD	HC CVD	HC CVD	HF PVD	HF PVD	HF PVD	HF PVD	HF PVD	HF PVD	HF								
<ul style="list-style-type: none"> <li>• Double-sided face milling inserts</li> <li>• 8 cutting edges</li> <li>• Curved design effectively reduces cutting force</li> <li>• Kapr 45°</li> <li>• Diverse carbide grades with PVD and CVD coating grades available, covering a wide range of applications</li> <li>• 3D geometries, sharp/ universal/ reinforced/ wiper types available</li> </ul>	Stable machining, light cut ● 1 <sup>st</sup> choice ○ suitable General machining, medium cut ● 1 <sup>st</sup> choice ○ suitable Unstable machining, heavy cut ⚡ 1 <sup>st</sup> choice ⚡ suitable	<b>Dimensions</b> 		<b>ISO</b>							<b>Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> choice)</b>								
			<b>P</b>	130 300		100 260	100 260		100 280										
			<b>M</b>		90 210	60 180	60 180			80 200									
			<b>K</b>	180 360	160 320			140 300											
			<b>N</b>											300 1100					
		<b>S</b>		30 70					20 60										
		<b>H</b>																	

Designation		BS	IC	S	D1	LE	Stock											
<b>GENERAL</b> 	SNEX1205ANEN-GP	1.6	12.7	6.35	5.9	9.1	●					●	●	●	●			
	SNMX1205ANEN-GP	1.6	12.7	6.35	5.9	9.1	●	●	●		●	▲	●	▲				
<b>LOW FORCE</b> 	SNEX1205ANEN-SC	1.6	12.7	6.35	5.9	9.1	●		●		●	●	▲	●				
<b>REINFORCED</b> 	SNEX1205ANSN-TE	1.6	12.7	6.35	5.9	9.1	○				▽	●	●					
	SNMX1205ANSN-TE	1.6	12.7	6.35	5.9	9.1	▲	●			▽	●	●	▲				
<b>ALUMINIUM</b>  polished surface periphery ground	SNEX1205ANFN-AL	1.6	12.7	6.35	5.9	9.1												●
<b>WIPER</b>  2 edges	SNEX1205-WU	5.1	12.7	6.35	5.9	9.1	●					▽	●	●				

● 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
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
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
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC9540			JP5530			JP9535		
min	start	max	min	start	max	min	start	max	min	start	max	
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
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
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC7515			JC8520			JP7525		
min	start	max	min	start	max	min	start	max	min	start	max	
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	100%	180	230	280	160	200	240	140	180	220
			30%	200	260	320	180	230	280	160	210	260
			10%	220	290	360	200	260	320	180	240	300
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	100%	120	180	240	120	160	200	100	140	180
			30%	160	220	280	140	190	240	120	170	220
			10%	200	260	320	160	220	280	140	200	260
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	140	180	100	130	160	90	120	150
			30%	140	180	220	120	160	200	120	150	180
			10%	180	220	260	140	190	240	150	180	210
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JU6520								
min	start	max	min	start	max	min	start	max	min	start	max	
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						
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC9540			JP9535					
min	start	max	min	start	max	min	start	max	min	start	max	
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.

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

A - TURNING
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DESIGNATION	ae/DC	DEPTH OF CUT			FEED RATE		
		ap (mm)			fz (mm)		
		min	start	max	min	start	max
SNxX1205ANEN-GP	100%	1.00	<b>2.00</b>	3.00	0.13	<b>0.21</b>	0.29
	30%	1.00	<b>2.00</b>	3.00	0.16	<b>0.26</b>	0.36
	10%	1.00	<b>2.00</b>	3.00	0.20	<b>0.31</b>	0.42
SNEX1205ANEN-SC	100%	0.50	<b>1.50</b>	2.50	0.06	<b>0.12</b>	0.18
	30%	0.50	<b>1.50</b>	2.50	0.08	<b>0.15</b>	0.22
	10%	0.50	<b>1.50</b>	2.50	0.10	<b>0.18</b>	0.26
SNxX1205ANSN-TE	100%	1.00	<b>2.00</b>	3.00	0.16	<b>0.25</b>	0.34
	30%	1.00	<b>2.00</b>	3.00	0.20	<b>0.32</b>	0.44
	10%	1.00	<b>2.00</b>	3.00	0.24	<b>0.38</b>	0.52
SNEX1205ANFN-AL	100%	0.50	<b>1.50</b>	2.50	0.10	<b>0.20</b>	0.30
	30%	0.50	<b>1.50</b>	2.50	0.12	<b>0.25</b>	0.38
	10%	0.50	<b>1.50</b>	2.50	0.14	<b>0.28</b>	0.42
SNEX1205-WU	100%	0.50	<b>1.00</b>	1.50	0.06	<b>0.13</b>	0.20
	30%	0.50	<b>1.00</b>	1.50	0.08	<b>0.16</b>	0.24
	10%	0.50	<b>1.00</b>	1.50	0.10	<b>0.19</b>	0.28

# NOTE

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