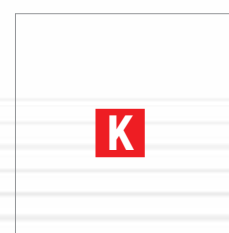
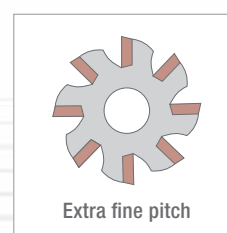
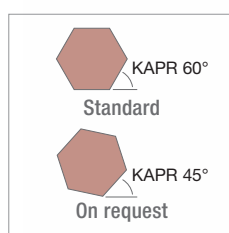




DOUBLEHEX ACTION

Sistema di fresatura sicuro ed economico per ghisa



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

Inserti: HN..09

Corpi fresa: NT-HN09

nikkoTOOLS

uemme
TOOLS and EQUIPMENT

VALIDITA': 31/12/2024

DOUBLEHEX

Safe and high economical milling system for cast iron

APPLICATION

- Roughing or semi-finishing face milling of cast iron
- Adapted for interrupted surfaces
- Adapted for remove the casted hard skins

ISO APPLICATION FIELDS

K

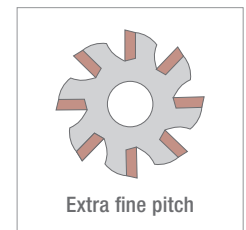
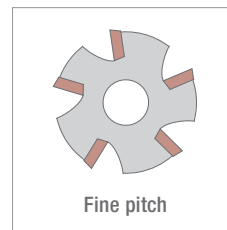
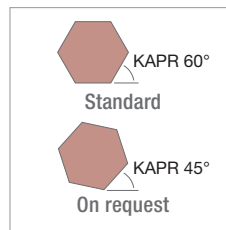
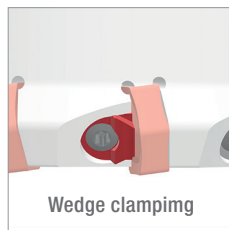
ADVANTAGES AND CHARACTERISTICS

- Fine pitch and extra-fine pitch type cutters available. Dense teeth in the cutter body allows higher table feeds with exceptional productivity.
- Precise inserts in tol.E or in tol.M, high precision or high economical solutions available.
- 3 different chipbreakers combined with both PVD and CVD grades.
- Inserts also available in solid PCBN and Silicon Nitride.
- Extremely competitive cost per cutting edge.



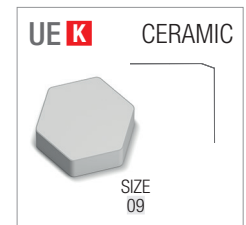
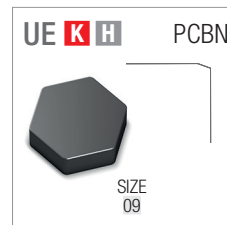
• Cutter bodies

- Arbor type
- From D80 to D160



• Inserts

- 12 edges
- Edge length 09 with APMX = 6 mm
- Carbide grades with PVD and CVD coatings, solid PCBN and ceramic
- Geometries: GL, GG, GH, Advanced



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

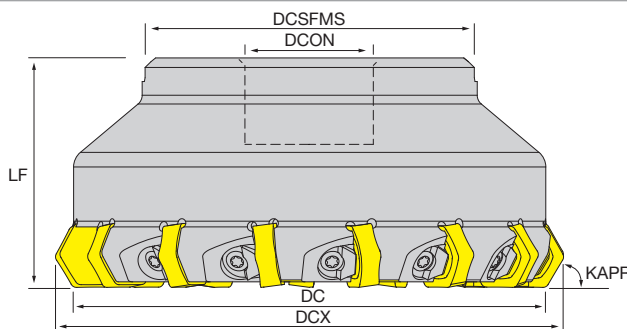
F - ACCESSORIES

G - SPARE PARTS

NT-HN

DoubleHex

- Double-sided face milling cutters specially for cast iron
- For hexagonal inserts with 12 cutting edges
- Kapr 60° and 45° upon request
- Extra fine pitch available



Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	DCX	WT	MIID
KAPR 60°											
NT-HN09 D080-F27-Z08	●	80	8	27	50	-	60	-	90	1.28 Kg	HN0X0905
NT-HN09 D080-F27-Z10	●	80	10	27	50	-	60	-	90	1.23 Kg	HN0X0905
NT-HN09 D100-F32-Z10	●	100	10	32	50	-	80	-	110	1.87 Kg	HN0X0905
NT-HN09 D100-F32-Z14	●	100	14	32	50	-	80	-	110	1.80 Kg	HN0X0905
NT-HN09 D125-F40-Z12	●	125	12	40	63	-	88	-	135	3.55 Kg	HN0X0905
NT-HN09 D125-F40-Z15	●	125	15	40	63	-	88	-	135	3.33 Kg	HN0X0905
NT-HN09 D160-F40-Z15	●	160	15	40	63	-	120	-	170	5.10 Kg	HN0X0905
NT-HN09 D160-F40-Z20	●	160	20	40	63	-	120	-	170	4.98 Kg	HN0X0905
KAPR 45°											
NT-HN0945 D080-F27-Z10	●	80	10	27	50	-	60	-	92.4	1.30 Kg	HN0X0905

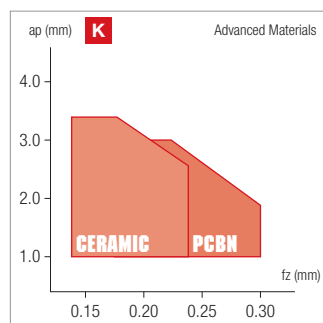
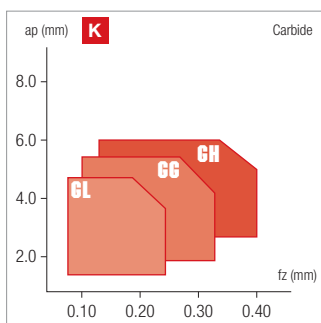
● stock standard, ○ non-standard stock, ▲ upcoming introduction, ▽ stock exhaustion

Spare parts	Wedge	Wedge screws	L wrench
NT-HN09 D 000 -F 00 -Z 00	NT-WD090	NT-SC090	NT-WR030

<h1>HN</h1>	HC: Coated carbide HF: Micrograin carbide BH: High volume CBN CN: Silicon nitride ceramic Si3N4 CVD: Chemical vapour deposition PVD: Physical vapour deposition				HC	HF	BH	CN	
	DoubleHex				JC7515	JP7525	NBHS500	NSN400	
<ul style="list-style-type: none"> • Double-sided face milling inserts specially for cast iron • Hexagonal inserts with 12 cutting edges • Coated carbide, CBN and ceramic grades available, covering a wide range of applications • Geometries featuring different applications on cast iron, from light to heavy cutting 	Stable machining, light cut	<input checked="" type="radio"/> 1 st choice	<input type="radio"/> suitable	<input checked="" type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input checked="" type="radio"/>	
	General machining, medium cut	<input checked="" type="radio"/> 1 st choice	<input type="radio"/> suitable	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	
	Unstable machining, heavy cut	<input type="radio"/> 1 st choice	<input type="radio"/> suitable	<input type="radio"/>	<input checked="" type="radio"/>	<input checked="" type="radio"/>	<input type="radio"/>	<input type="radio"/>	
	Dimensions	ISO			Vc(m/min) - suggested cutting speed range (bold: 1st choice)				
	P								
	M								
	K	180 360	140 300	800 2000	600 1200				
	N								
	S								
	H								

Designation		RE	IC	S	LE	AN	Stock													
GENERAL	GG K 	HNEX090520-GG	2	16.2	5.56	9.35	0°	<input checked="" type="radio"/>	<input checked="" type="radio"/>											
		HNMX090520-GG	2	16.2	5.56	9.35	0°	<input checked="" type="radio"/>	<input checked="" type="radio"/>											
LOW FORCE	GL K 	HNEX090510-GL	1	16.2	5.56	9.35	0°	<input checked="" type="radio"/>	<input checked="" type="radio"/>											
		HNEX090520-GL	2	16.2	5.56	9.35	0°	<input checked="" type="radio"/>	<input checked="" type="radio"/>											
REINFORCED	GH K 	HNEX090516-GH	1.6	16.2	5.56	9.35	0°	<input checked="" type="radio"/>	<input checked="" type="radio"/>											
		HNEX090530-GH	3	16.2	5.56	9.35	0°	<input checked="" type="radio"/>	<input checked="" type="radio"/>											
		HNMX090516-GH	1.6	16.2	5.56	9.35	0°	<input checked="" type="radio"/>	<input checked="" type="radio"/>											
ADVANCED	UE K PCBN full solid	HNEN090520S-UE	2	16.2	5.56	9.35	0°						<input checked="" type="radio"/>							
ADVANCED	UE K CERAMIC silicon nitride	HNEN090520T-UE	2	16.2	5.56	9.35	0°							<input checked="" type="radio"/>						
		HNEN090530T-UE	3	16.2	5.56	9.35	0°								<input checked="" type="radio"/>					

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



A - TURNING

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D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

A - TURNING

ISO 513	MATERIAL	HARDNESS HB	ae/DC	JG7515			JP7525			
				min	start	max	min	start	max	
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	100%	180	230	280	140	180	220	
			30%	200	260	320	160	210	260	
			10%	220	290	360	180	240	300	
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	100%	120	180	240	100	140	180	
			30%	160	220	280	120	170	220	
			10%	200	260	320	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	90	120	150	
			30%	140	180	220	120	150	180	
			10%	180	220	260	150	180	210	

B - THREADING

C - GROOVING

ISO 513	MATERIAL	HARDNESS HB	ae/DC	NBH550U			NSN400			
				min	start	max	min	start	max	
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	100%	800	1000	1200	400	600	800	
			30%	1000	1300	1600	550	750	950	
			10%	1200	1600	2000	800	900	1000	

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

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

DESIGNATION	ae/DC	DEPTH OF CUT			FEED RATE		
		ap (mm)			fz (mm)		
		min	start	max	min	start	max
HNx090520-GG	100%	1.00	3.00	5.00	0.10	0.25	0.40
	30%	1.00	3.00	5.00	0.13	0.32	0.51
	10%	1.00	3.00	5.00	0.16	0.38	0.60
HNEX090500-GL	100%	0.50	2.50	4.50	0.08	0.22	0.36
	30%	0.50	2.50	4.50	0.10	0.27	0.44
	10%	0.50	2.50	4.50	0.12	0.32	0.52
HNx090500-GH	100%	1.00	3.50	6.00	0.13	0.31	0.50
	30%	1.00	3.50	6.00	0.16	0.39	0.62
	10%	1.00	3.50	6.00	0.19	0.46	0.73
HNEN090500-UE	100%	1.00	2.00	3.00	0.13	0.28	0.43
	30%	1.00	2.00	3.00	0.16	0.35	0.54
	10%	1.00	2.00	3.00	0.20	0.41	0.62

A - TURNING

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