



DOUBLE3GON ACTION

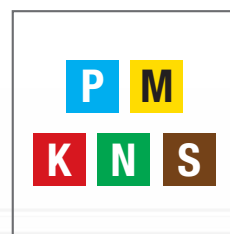
per lavorazioni affidabili ed economiche



inserti a 6 taglienti
affidabili ed economici

SC: Sharp
GP: General
Te: Reinforced
AL: Aluminium
RE 0.4-0.8-1.2

4 rompitrucoli e
3 raggi disponibili



ampia selezione di
gradi e rivestimenti

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

Inserti: WNEX04
Corpi fresa: NT-WX04H

Inserti: WNEX08
Corpi fresa: NT-WX08H

nixkoTOOLS

uemme
TOOLS and EQUIPMENT

DOUBLE3GON

High economical trigonal shoulder milling system for universal processes

APPLICATION

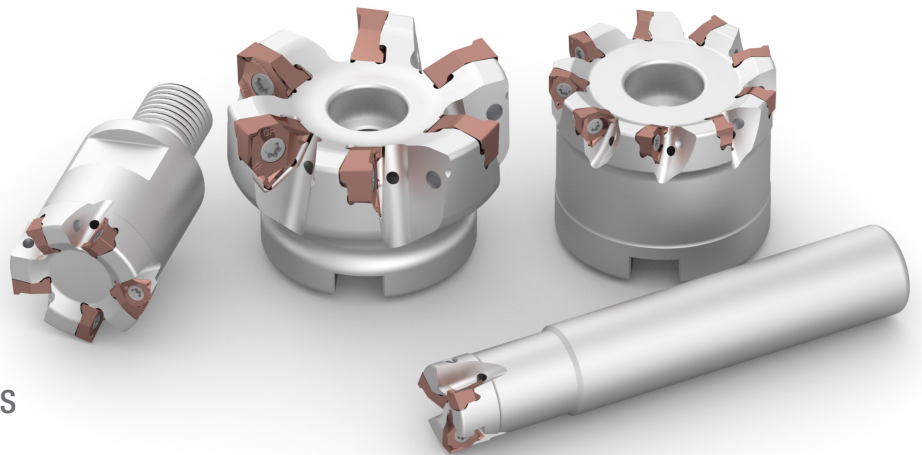
- Shoulder milling
- Shoulders with repeated passes
- Long overhang shoulder milling

ISO APPLICATION FIELDS

P M K N S

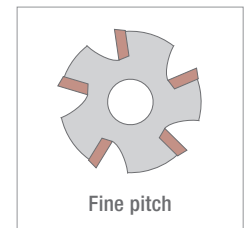
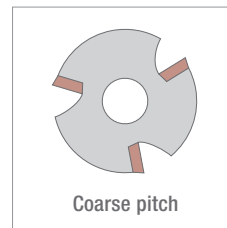
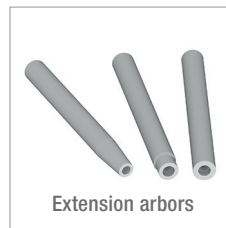
ADVANTAGES AND CHARACTERISTICS

- High precision in making 90° side milling
- Reduced cost per edge than conventional shoulder milling systems.
- Very robust system because of the negative trigonal and reliable installation.
- Full range of carbide geometries, radii and grades.
- «Ultra-precise» cutter bodies with special surface treatment to ensure longer life.



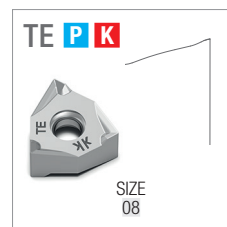
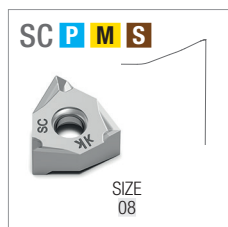
• Cutter bodies

- Arbor type
- Cylindrical type
- Screw-in type
- Extension sleeves (steel/carbide 10xD)
- From D20 to D160



• Inserts

- 6 cutting edges
- Edge length 04 and 08
- Cemented carbide grades with CVD and PVD coatings
- Geometries: SC, GP, TE, AL



A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

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NT-WX

Double3Gon

- Double sided trigonal type shoulder milling system, with coolant through
- Tolerance of tool diameter (with Nikko inserts installed) 0/-0.2
- Steel and carbide arbors available for screw-in type holders
- High-Quality Swiss screws guarantee more reliability in your machining

Screw-in

Cylindrical



Arbor

Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	KAPR	WT	MIID
SCREW-IN											
NT-WX04H D020-M10-Z03	●	20	3	10.5	28	-	-	M10	90°	0.05 Kg	WNEX0403
NT-WX04H D025-M12-Z03	○	25	3	12.5	30	-	-	M12	90°	-	WNEX0403
NT-WX04H D025-M12-Z04	●	25	4	12.5	30	-	-	M12	90°	0.09 Kg	WNEX0403
NT-WX04H D032-M16-Z04	○	32	4	17	40	-	-	M16	90°	-	WNEX0403
NT-WX04H D032-M16-Z05	●	32	5	17	40	-	-	M16	90°	0.20 Kg	WNEX0403
CYLINDRICAL											
NT-WX04H D020-S16-Z03	●	20	3	16	110	20	-	-	90°	0.16 Kg	WNEX0403
NT-WX04H D020-S20-Z03	●	20	3	20	110	28	-	-	90°	0.23 Kg	WNEX0403
NT-WX04H D025-S20-Z04	●	25	4	20	120	22	-	-	90°	0.27 Kg	WNEX0403
NT-WX04H D025-S25-Z04	●	25	4	25	120	30	-	-	90°	0.40 Kg	WNEX0403
NT-WX04H D032-S25-Z05	●	32	5	25	130	25	-	-	90°	0.47 Kg	WNEX0403
NT-WX04H D032-S32-Z05	●	32	5	32	130	40	-	-	90°	0.72 Kg	WNEX0403
ARBOR											
NT-WX04H D040-F16-Z05	○	40	5	16	40	-	35	-	90°	-	WNEX0403
NT-WX04H D040-F16-Z07	●	40	7	16	40	-	35	-	90°	0.22 Kg	WNEX0403
NT-WX04H D050-F22-Z06	○	50	6	22	40	-	47	-	90°	-	WNEX0403
NT-WX04H D050-F22-Z09	●	50	9	22	40	-	47	-	90°	0.38 Kg	WNEX0403
NT-WX04H D063-F22-Z08	○	63	8	22	40	-	47	-	90°	-	WNEX0403
NT-WX04H D063-F22-Z10	○	63	10	22	40	-	47	-	90°	-	WNEX0403
NT-WX08H D050-F22-Z04	●	50	4	22	40	-	47	-	90°	0.31 Kg	WNEX0806
NT-WX08H D050-F22-Z05	●	50	5	22	40	-	47	-	90°	0.33 Kg	WNEX0806
NT-WX08H D063-F22-Z06	●	63	6	22	40	-	47	-	90°	0.43 Kg	WNEX0806
NT-WX08H D063-F22-Z07	●	63	7	22	40	-	47	-	90°	0.42 Kg	WNEX0806
NT-WX08H D063-F27-Z06	●	63	6	27	40	-	47	-	90°	0.63 Kg	WNEX0806
NT-WX08H D080-F27-Z07	●	80	7	27	50	-	62.1	-	90°	0.99 Kg	WNEX0806

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

Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	KAPR	WT	MIID
NT-WX08H D080-F27-Z09	●	80	9	27	50	-	62.1	-	90°	0.96 Kg	WNEX0806
NT-WX08H D100-F32-Z08	●	100	8	32	50	-	77.1	-	90°	-	WNEX0806
NT-WX08H D100-F32-Z11	●	100	11	32	50	-	77.1	-	90°	1.45 Kg	WNEX0806
NT-WX08H D125-F40-Z11	●	125	11	40	63	-	80	-	90°	2.38 Kg	WNEX0806
NT-WX08H D160-F40-Z12	●	160	12	40	63	-	85	-	90°	3.86 Kg	WNEX0806

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Spare parts	Insert screws	Flag wrenches
		
NT-WX04H D 000-000 -Z 00	NT-ST25056T08HQ	NT-FTB08
NT-WX08H D 000-000 -Z 00	NT-ST40110T15HQ	NT-FTB15

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F - ACCESSORIES

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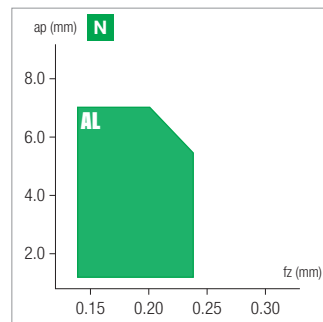
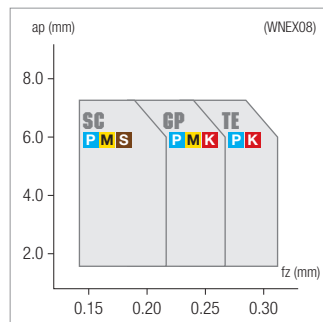
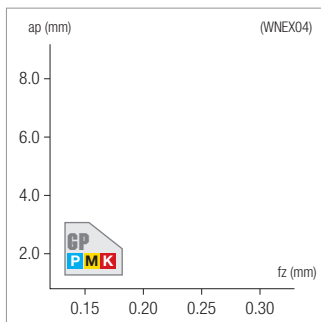
F - ACCESSORIES

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<h1>WNE X</h1>	HC: Coated carbide HF: Micrograin carbide CVD: Chemical vapour deposition PVD: Physical vapour deposition											
	<h2>Double3Gon</h2>	HC CVD	HC CVD	HC CVD	HC CVD	HF PVD	HF PVD	HF PVD	HF PVD	HF PVD	HF PVD	HF PVD
<ul style="list-style-type: none"> • Double-sided trigonal inserts offering 6 edges! • Stable sitting in the pocket guarantees more reliability in machining • Available in diverse grades covering wide application range 	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	80 220		100 260	100 280		
	M				90 210	60 180	60 180			80 200		
	K	180 360	160 320	160 320				140 300				
	N										300 1100	
	S				30 70		20 50					
H												

	Designation	RE	IC	S	D1	BS	Stock																
GENERAL 	WNE X040304R-GP	0.4	6.7	3.3	3.1	0.9																	
	WNE X040308R-GP	0.8	6.7	3.3	3.1	0.9																	
	WNE X080608R-GP	0.8	12.5	6.5	4.6	1.5	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
LOW FORCE 	WNE X080604R-SC	0.4	12.5	6.5	4.6	1.8																	
	WNE X080608R-SC	0.8	12.5	6.5	4.6	1.5																	
REINFORCED 	WNE X080608R-TE	0.8	12.5	6.5	4.6	1.5	●	▽															
	WNE X080612R-TE	1.2	12.5	6.5	4.6	1.1																	
ALUMINIUM <p>polished surface periphery ground</p>	WNE X080608R-AL	0.8	12.5	6.5	4.6	1.4																●	

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	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC8520			JP5530			JP5540		
					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	80	120	160
				30%	200	240	280	160	200	240	120	160	200
				10%	260	280	300	220	240	260	180	200	220
	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	60	100	140
				30%	160	200	240	120	160	200	100	140	180
				10%	220	240	260	180	200	220	160	180	200
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			
				30%	120	160	200	100	130	160			
				10%	200	220	240	140	170	200			
C - GROOVING	P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	100%	90	130	170	60	100	140	60	100	140
				30%	110	160	210	80	130	180	80	130	180
				10%	130	190	250	100	160	220	100	160	220
	P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	100%	70	100	130				50	80	110
				30%	80	110	140				60	90	120
				10%	90	120	150				70	100	130
D - MILLING	M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	100%	90	120	150	60	90	120	60	90	120
				30%	110	150	190	80	120	160	80	120	160
				10%	130	170	210	100	140	180	100	140	180
	M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		100%	80	110	140				60	90	120
				30%	90	120	150				70	100	130
				10%	100	130	160				80	110	140
E - DRILLING	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
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	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
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	25	30			
				30%	40	50	60	30	35	40			
				10%	50	60	70	40	45	50			
	S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		100%				30	40	50			
				30%				40	50	60			
				10%				50	60	70			

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

JP8725							
min	start	max					
100	150	200					
160	210	260					
220	250	280					
90	130	170					
130	170	210					
190	210	230					
80	110	140					
120	150	180					
160	190	220					

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DESIGNATION	ae/DC	DEPTH OF CUT			FEED RATE		
		ap (mm)			fz (mm)		
		min	start	max	min	start	max
WNEX040300R-GP	100%	0.60	1.00	1.40	0.05	0.10	0.15
	30%	0.60	1.80	3.00	0.06	0.12	0.18
	10%	0.60	1.80	3.00	0.07	0.14	0.20
WNEX080600R-GP	100%	1.00	2.50	4.00	0.11	0.18	0.21
	30%	1.00	4.00	7.00	0.14	0.20	0.26
	10%	1.00	4.00	7.00	0.16	0.23	0.30
WNEX080600R-SC	100%	1.00	2.50	4.00	0.08	0.13	0.18
	30%	1.00	4.00	7.00	0.10	0.16	0.22
	10%	1.00	4.00	7.00	0.12	0.20	0.26
WNEX080600R-TE	100%	1.00	2.50	4.00	0.13	0.19	0.25
	30%	1.00	4.00	7.00	0.16	0.23	0.30
	10%	1.00	4.00	7.00	0.20	0.27	0.34
WNEX080608R-AL	100%	1.00	2.50	4.00	0.08	0.14	0.20
	30%	1.00	4.00	7.00	0.10	0.17	0.24
	10%	1.00	4.00	7.00	0.12	0.20	0.28