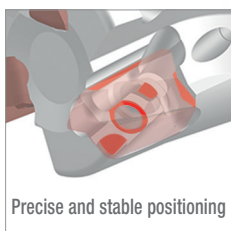


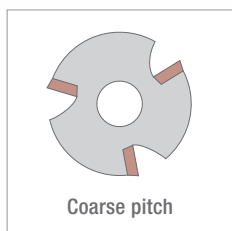


# DOUBLEREK ACTION

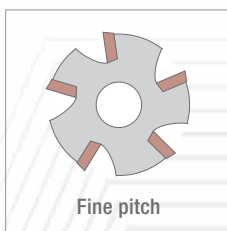
Per spallamenti di elevata precisione con accuratezza superiore



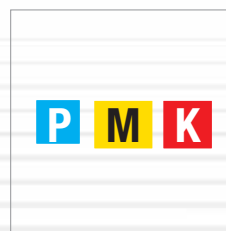
Precise and stable positioning



Coarse pitch



Fine pitch



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

Inserti: NT-DRK10  
Corpi fresa: NT-DRK10

Inserti: NT-DRK17  
Corpi fresa: NT-DRK17

**nikko**TOOLS

**(uemme)**  
TOOLS for EQUIPMENT

VALIDITA': 31/12/2024

# DOUBLEREK

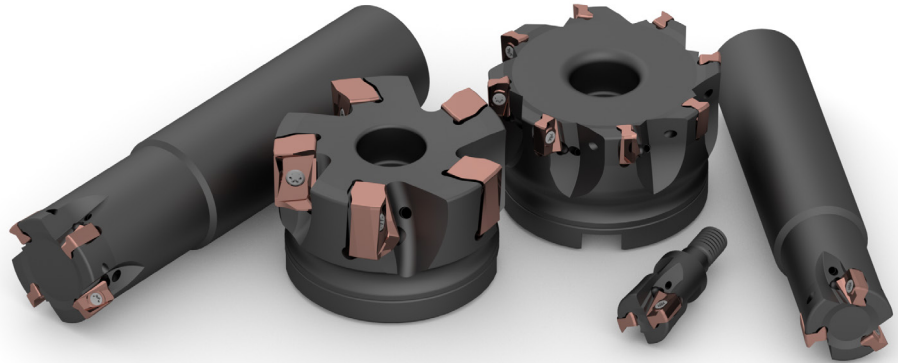
High productivity high precision double sided shoulder milling system

## APPLICATION

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

## ISO APPLICATION FIELDS

**P M K**

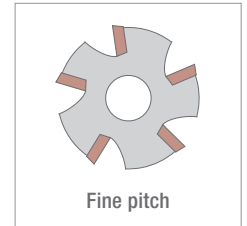
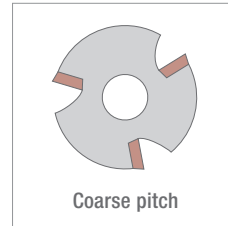
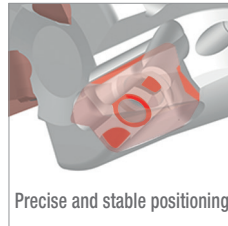


## ADVANTAGES AND CHARACTERISTICS

- Available in big and small dimensions allow axial removals up to 15 mm.
- Super positive rake with helical geometry, extremely smooth cutting action.
- Fully ground inserts for precision machining and excellent finishes.
- Thickness greater than conventional inserts of the same size ensures better heat dissipation and excellent mechanical strength
- Secure and reliable installation guarantees better precision especially at tough conditions

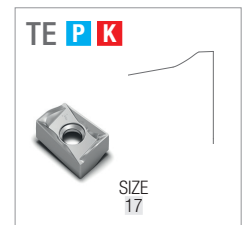
### ● Cutter bodies

- Arbor type
- Cylindrical type
- Screw-in type
- Extension sleeves (steel/carbide 10xD)
- From D16 to D125



### ● Inserts

- 4 cutting edges
- Edge length 10 and 17
- Cemented carbide grades with CVD and PVD coatings
- Geometries: GP, TE



A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

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# NT-DRK

## DoubleRek

- Double-sided precision shoulder milling system, with coolant through
- Low resistance robust helical shoulder milling system, provides precision, good surface and reliability
- Tolerance of tool diameter (with Nikko inserts installed) 0/-0.2
- Steel and carbide arbors available for screw-in type holders

Screw-in

Cylindrical



Arbor

Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	KAPR	WT	MIID
<b>SCREW-IN</b>											
NT-DRK10 D016-M08-Z02	●	16	2	8.5	25	-	-	M8	90°	0.03 Kg	NT-DRK10
NT-DRK10 D020-M12-Z03	●	20	3	10.5	30	-	-	M10	90°	0.05 Kg	NT-DRK10
NT-DRK10 D025-M16-Z03	●	25	3	12.5	35	-	-	M12	90°	0.10 Kg	NT-DRK10
NT-DRK10 D032-M16-Z04	●	32	4	17	43	-	-	M16	90°	0.22 Kg	NT-DRK10
<b>CYLINDRICAL</b>											
NT-DRK10 D016-S16-Z02	●	16	2	16	100	25	-	-	90°	0.13 Kg	NT-DRK10
NT-DRK10 D020-S20-Z03	●	20	3	20	110	30	-	-	90°	0.23 Kg	NT-DRK10
NT-DRK10 D025-S25-Z03	●	25	3	25	120	35	-	-	90°	0.41 Kg	NT-DRK10
NT-DRK10 D032-S32-Z04	●	32	4	32	130	45	-	-	90°	0.74 Kg	NT-DRK10
NT-DRK17 D032-S32-Z02	●	32	2	32	130	45	-	-	90°	0.69 Kg	NT-DRK17
NT-DRK17 D040-S32-Z03	●	40	3	32	150	40	-	-	90°	0.89 Kg	NT-DRK17
<b>ARBOR</b>											
NT-DRK10 D032-F16-Z04	●	32	4	16	35	-	30	-	90°	0.10 Kg	NT-DRK10
NT-DRK10 D040-F16-Z05	●	40	5	16	40	-	30	-	90°	0.18 Kg	NT-DRK10
NT-DRK10 D050-F22-Z05	●	50	5	22	40	-	40	-	90°	0.31 Kg	NT-DRK10
NT-DRK10 D050-F22-Z07	●	50	7	22	40	-	40	-	90°	0.30 Kg	NT-DRK10
NT-DRK10 D063-F22-Z06	●	63	6	22	40	-	55	-	90°	0.62 Kg	NT-DRK10
NT-DRK10 D063-F22-Z08	●	63	8	22	40	-	55	-	90°	0.62 Kg	NT-DRK10
NT-DRK10 D080-F27-Z07	●	80	7	27	50	-	63	-	90°	1.26 Kg	NT-DRK10
NT-DRK10 D080-F27-Z10	●	80	10	27	50	-	63	-	90°	1.24 Kg	NT-DRK10
NT-DRK17 D050-F22-Z04	●	50	4	22	40	-	45	-	90°	0.29 Kg	NT-DRK17
NT-DRK17 D063-F22-Z05	●	63	5	22	40	-	56	-	90°	0.54 Kg	NT-DRK17
NT-DRK17 D063-F22-Z06	●	63	6	22	40	-	56	-	90°	0.51 Kg	NT-DRK17
NT-DRK17 D080-F27-Z06	●	80	6	27	50	-	63	-	90°	1.13 Kg	NT-DRK17
NT-DRK17 D080-F27-Z07	●	80	7	27	50	-	63	-	90°	1.10 Kg	NT-DRK17

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

Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	KAPR	WT	MIID
NT-DRK17 D100-F32-Z07	●	100	7	32	50	-	78	-	90°	1.71 Kg	NT-DRK17
NT-DRK17 D100-F32-Z09	●	100	9	32	50	-	78	-	90°	1.71 Kg	NT-DRK17
NT-DRK17 D125-F40-Z08	●	125	8	40	63	-	80	-	90°	3.20 Kg	NT-DRK17
NT-DRK17 D125-F40-Z10	●	125	10	40	63	-	80	-	90°	3.15 Kg	NT-DRK17

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

Spare parts	Insert screws	Flag wrenches
		
NT-DRK10 D000-000-Z00	NT-ST25078P08	NT-FTP08
NT-DRK17 D000-000-Z00	NT-ST45111T15	NT-FTB15

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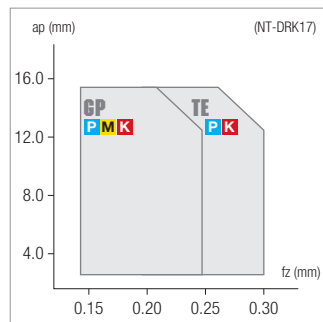
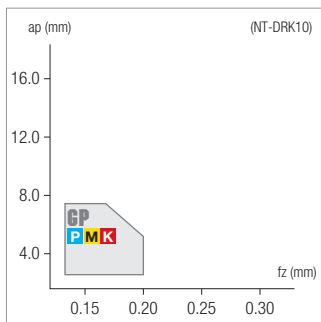
F - ACCESSORIES

G - SPARE PARTS

<h1>NT-DRK</h1>	HC: Coated carbide HF: Micrograin carbide CVD: Chemical vapour deposition PVD: Physical vapour deposition										
	<h2>DoubleRek</h2>	HC CVD	HC CVD	HC CVD	HF PVD	HF PVD	HF PVD	HF PVD	HF PVD		
<ul style="list-style-type: none"> <li>GP and TE are both helical geometries with reduced cutting resistance</li> <li>Precise and enhanced positioning guarantees more reliability in machining</li> <li>Available in diverse grades covering wide application range</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>									
	<p>4 edges</p>	<b>Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> choice)</b>									
<b>P</b>		130 300		100 260		100 280					
<b>M</b>		90 210		60 180		80 200		60 180			
<b>K</b>		180 360		160 320		140 300					
<b>N</b>											
<b>S</b>		30 70				20 60		20 50			
<b>H</b>											

	Designation	RE	IC	S	D1	BS	Stock												
<b>GENERAL</b>	 NT-DRK10R08K-GP	0.8	5.82	5.45	2.9	0.9	●	●	●	●	●	●	●						
	 NT-DRK17R08K-GP	0.8	11.2	10.94	5.2	3.2	●	●	●	●	●	●	●						
<b>REINFORCED</b>	 NT-DRK17R12K-TE	1.2	11.2	10.94	5.2	3.2	●	●	●	●	●								

● 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			JP9535			JP9545		
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	80	120	160	60	100	140
			30%	110	160	210	100	150	200	80	130	180
			10%	130	190	250	120	180	240	100	160	220
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	100%	70	100	130	60	90	120	50	80	110
			30%	80	110	140	70	100	130	60	90	120
			10%	90	120	150	80	110	140	70	100	130
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	100%	90	120	150	80	110	140	60	90	120
			30%	110	150	190	100	140	180	80	120	160
			10%	130	170	210	120	160	200	100	140	180
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		100%	80	110	140	70	100	130	60	90	120
			30%	90	120	150	80	110	140	70	100	130
			10%	100	130	160	90	120	150	80	110	140
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	JC9540			JP9535			JP9545		
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	20	25	30
			30%	40	50	60	30	40	50	30	35	40
			10%	50	60	70	40	50	60	40	45	50
S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		100%				40	50	60	30	40	50
			30%				50	60	70	40	50	60
			10%				60	70	80	50	60	70

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

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DESIGNATION	ae/Dc	DEPTH OF CUT			FEED RATE		
		ap (mm)			fz (mm)		
		min	start	max	min	start	max
NT-DRK10R08K-GP	100%	1.00	<b>2.50</b>	4.00	0.08	<b>0.10</b>	0.12
	30%	1.00	<b>4.00</b>	7.00	0.10	<b>0.13</b>	0.16
	10%	1.00	<b>4.00</b>	7.00	0.12	<b>0.16</b>	0.20
NT-DRK17R08K-GP	100%	1.00	<b>4.00</b>	7.00	0.11	<b>0.18</b>	0.21
	30%	1.00	<b>8.00</b>	15.00	0.14	<b>0.20</b>	0.26
	10%	1.00	<b>8.00</b>	15.00	0.16	<b>0.23</b>	0.30
NT-DRK17R12K-TE	100%	1.00	<b>4.00</b>	7.00	0.13	<b>0.19</b>	0.25
	30%	1.00	<b>8.00</b>	15.00	0.16	<b>0.23</b>	0.30
	10%	1.00	<b>8.00</b>	15.00	0.20	<b>0.27</b>	0.34





**uemme s.r.l.**

Viale Lavoro e Industria  
25030 Coccaglio (BS)  
ITALIA

**info**

T | +39 030 7700112  
M | [Info@uemme.eu](mailto:Info@uemme.eu)  
S | [www.uemme.eu](http://www.uemme.eu)

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