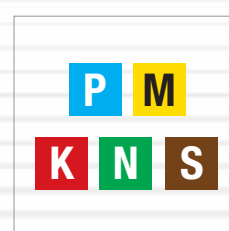
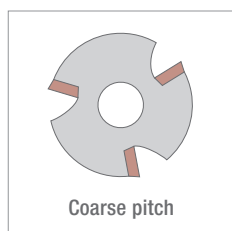




# OKTOPLUS ACTION

per spianatura economica con inserto ottagonale



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

Inserti: OD...06  
Corpi fresa: NT-OD06

Inserti: OFKT05  
Corpi fresa: NT-OF05

**nikko**TOOLS

**uemme**  
TOOLS and EQUIPMENT

VALIDITA': 31/12/2024

# OKTOPLUS

Multi-edge face mill to optimize production economy

## APPLICATION

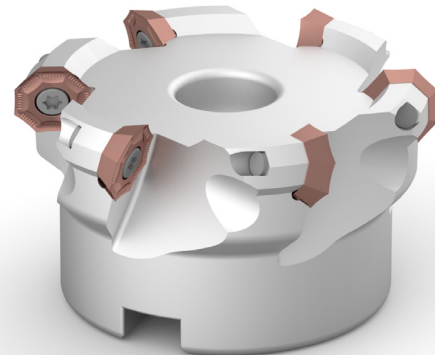
- Finishing / semi-finishing / rough face milling
- Removal of the crusted surfaces
- General milling of interrupted surfaces

## ISO APPLICATION FIELDS

**P M K N S**

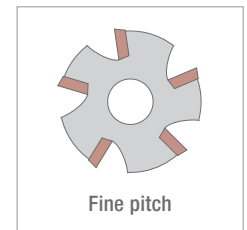
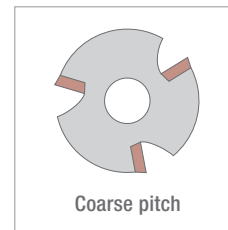
## ADVANTAGES AND CHARACTERISTICS

- Super-positive cutter with a very gentle cutting action.
- Great performance even on circular interpolation milling.
- Excellent performance on difficult to machine materials (ISO M and ISO S).
- Extremely complete range of chipbreakers in both ground (E tolerance) and pressed (M tolerance) versions.



## • Cutter bodies

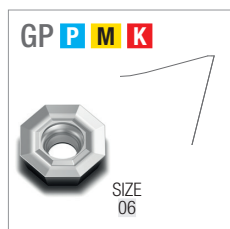
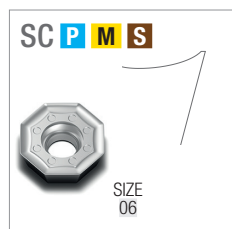
- Arbor type with coolant
- From D50 to D160



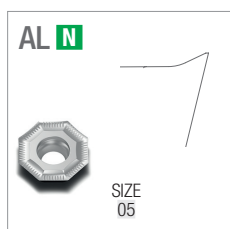
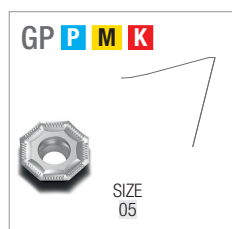
## • Inserts

- 8 cutting edges
- Edge length 06 with APMX = 4 mm and 05 with APMX = 3
- Cemented carbide grades with CVD and PVD coatings
- Geometries: SC, GP, TE, AL, WU

### OKTOPLUS OD



### OKTOPLUS OF



A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

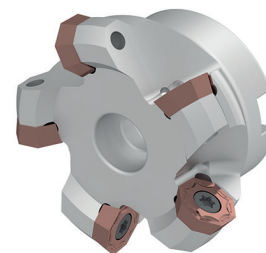
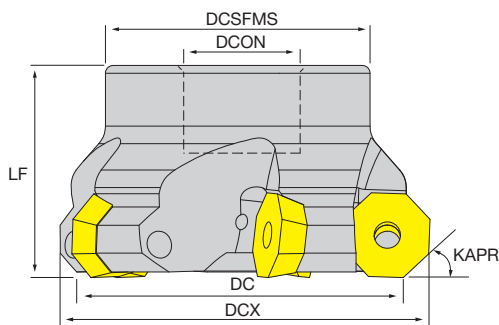
F - ACCESSORIES

G - SPARE PARTS

# NT-OD

## OktoPlus OD

- Positive general face milling cutters
- For octagonal inserts with 8 cutting edges
- Kapr 43°
- With coolant through



Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	DCX	WT	MIID
NT-OD06H D050-F22-Z04	●	50	4	22	40	-	48	-	60	0.34 Kg	OD∞0605
NT-OD06H D063-F22-Z05	●	63	5	22	40	-	50	-	73	0.52 Kg	OD∞0605
NT-OD06H D080-F27-Z06	●	80	6	27	50	-	60	-	90	1.05 Kg	OD∞0605
NT-OD06H D100-F32-Z07	●	100	7	32	50	-	70	-	110	1.48 Kg	OD∞0605
NT-OD06H D125-F40-Z08	●	125	8	40	63	-	80	-	135	2.60 Kg	OD∞0605
NT-OD06H D160-F40-Z10	●	160	10	40	63	-	85	-	170	3.96 Kg	OD∞0605

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

Spare parts	Insert screws	Flag wrenches
NT-OD06H D∞∞-F∞∞-Z∞∞	 NT-ST50110T20	 NT-FTB20

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

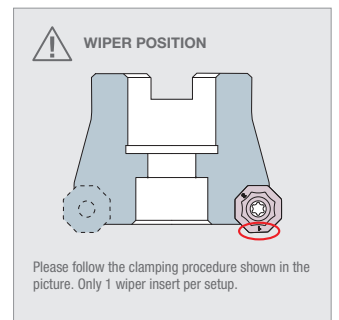
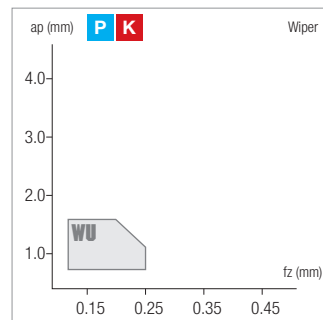
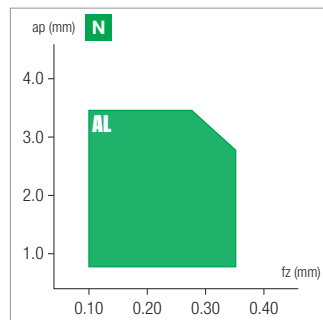
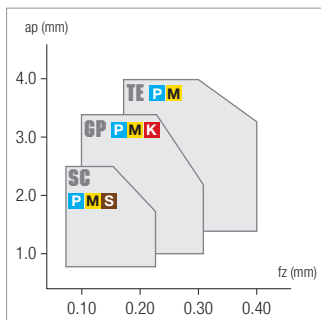
F - ACCESSORIES

G - SPARE PARTS

<h1>OD</h1>	HC: Coated carbide HF: Micrograin carbide CVD: Chemical vapour deposition PVD: Physical vapour deposition						HC	HF	HF	HF	HF	HF					
							CVD	PVD	PVD	PVD	PVD	PVD					
<h2>OktoPlus OD</h2>							<b>JG7515</b>	<b>JP5520</b>	<b>JP5530</b>	<b>JP7525</b>	<b>JP9535</b>	<b>JU6520</b>					
<ul style="list-style-type: none"> <li>Positive general face milling inserts</li> <li>8 cutting edges</li> <li>Kapr 43°</li> <li>Diverse carbide grades with PVD and CVD coating grades available, covering a wide range of applications</li> <li>Sharp/universal/robust/wiper geometries 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>	100 260	100 260									
						<b>M</b>	60 180	60 180		80 200							
						<b>K</b>	180 360		140 300								
						<b>N</b>				300 1100							
						<b>S</b>				20 60							
						<b>H</b>											

	Designation	BS	IC	S	D1	LE	Stock						
GENERAL	<b>GP P M K</b> 	1.8	15.875	3.56	5.5	5						▽	●
	ODMT060508-GP	1.8	15.875	3.56	5.5	5	●	▽	●	●	●		
LOW FORCE	<b>SC P M S</b> 	1.8	15.875	3.56	5.5	5		▽	▽			●	
REINFORCED	<b>TE P K</b> 	1.8	15.875	3.56	5.5	5		▽					
	ODMT060508-TE	1.8	15.875	3.56	5.5	5	○	▽	●	●			
ALUMINIUM	<b>AL N</b>  polished surface periphery ground	1.8	15.875	3.56	5.5	5							●
WIPER	<b>WU P K</b>  2 edges	6.4	15.875	3.56	5.5	5		▽	●	●			

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



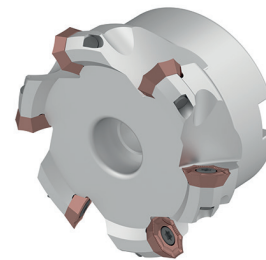
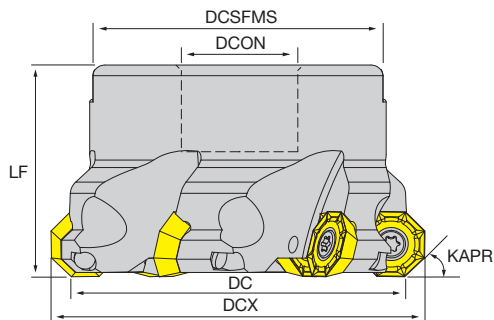
A - TURNING  
 B - THREADING  
 C - GROOVING  
 D - MILLING  
 E - DRILLING  
 F - ACCESSORIES  
 G - SPARE PARTS

A - TURNING

# NT-OF

## OktoPlus OF

- Positive general face milling cutters
- For octagonal inserts with 8 cutting edges
- Kapr 43°
- With coolant through



B - THREADING

Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	DCX	WT	MIID
NT-OF05H D050-F22-Z05	●	50	5	22	40	-	46.8	-	58	0.34 Kg	OF <sub>∞</sub> 05T3
NT-OF05H D063-F22-Z06	●	63	6	22	40	-	56	-	71	0.58 Kg	OF <sub>∞</sub> 05T3
NT-OF05H D080-F27-Z07	●	80	7	27	50	-	60	-	88	0.91 Kg	OF <sub>∞</sub> 05T3
NT-OF05H D100-F32-Z08	▲	100	8	32	50	-	70	-	108	1.40 Kg	OF <sub>∞</sub> 05T3

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

C - GROOVING

Spare parts	Insert screws	Flag wrenches
NT-OF05H D <sub>∞∞∞</sub> -F <sub>∞∞</sub> -Z <sub>∞∞</sub>	 NT-ST40110T15HQ	 NT-FTB15

D - MILLING

E - DRILLING

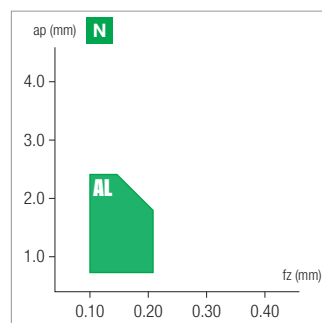
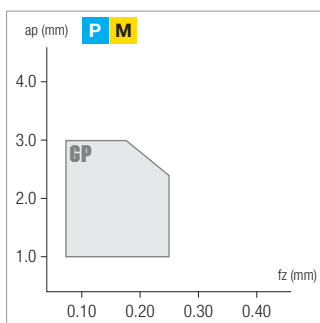
F - ACCESSORIES

G - SPARE PARTS

<h1>OFKT</h1>	HC: Coated carbide HF: Micrograin carbide CVD: Chemical vapour deposition PVD: Physical vapour deposition			HC	HF	HF				
				CVD	PVD					
OktoPlus OF				<b>JC7530</b>	<b>JP5540</b>	<b>JU6520</b>				
<ul style="list-style-type: none"> <li>Positive general face milling inserts</li> <li>8 cutting edges</li> <li>Kapr 43°</li> <li>Diverse carbide grades with PVD and CVD coating grades available, covering a wide range of applications</li> <li>Sharp/universal/robust/wiper geometries 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>	80 220							
		<b>M</b>	60 180							
		<b>K</b>	160 320							
		<b>N</b>		300 1100						
		<b>S</b>	20 50							
<b>H</b>										

Designation		BS	IC	S	D1	LE	Stock				
GENERAL	<b>GP P M K</b> 	1.1	12.7	3.97	4.4	4	▽	●			
	<b>OFKT05T305-GP</b>										
ALUMINIUM	<b>AL N</b>  polished surface periphery ground	1.1	12.7	3.97	4.4	4		●			
	<b>OFKT05T305-AL</b>										

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



A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

	ISO 513	MATERIAL	HARDNESS HB	ae/DC	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%	100	140	180	80	120	160			
				30%	160	200	240	120	160	200			
				10%	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%	80	120	160	60	100	140			
				30%	120	160	200	100	140	180			
				10%	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%	60	90	120						
				30%	100	130	160						
				10%	140	170	200						
C - GROOVING	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP5530			JP5540			JP9535		
					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%	60	100	140	60	100	140	80	120	160
	P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	100%				50	80	110	60	90	120
				30%				60	90	120	70	100	130
				10%				70	100	130	80	110	140
	M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	100%	60	90	120	60	90	120	80	110	140
				30%	80	120	160	80	120	160	100	140	180
				10%	100	140	180	100	140	180	120	160	200
D - MILLING	M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		100%				60	90	120	70	100	130
				30%				70	100	130	80	110	140
				10%				80	110	140	90	120	150
E - DRILLING	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC7515			JP7525					
					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	140	180	220			
	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			
F - ACCESSORIES	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JU6520								
					min	start	max	min	start	max	min	start	max
	N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGA)		100%	300	400	500						
	N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		100%	200	250	300						
				30%	300	350	400						
				10%	400	450	500						
G - SPARE PARTS	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP5540			JP9535					
					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%	20	25	30	20	30	40			
	S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		30%	30	35	40	30	40	50			
				10%	40	45	50	40	50	60			
				100%	30	40	50	40	50	60			
	S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		30%	40	50	60	50	60	70			
				10%	50	60	70	60	70	80			
				100%	30	40	50	40	50	60			

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
OFKT05T305-GP	100%	1.00	<b>2.00</b>	3.00	0.08	<b>0.12</b>	0.16
	30%	1.00	<b>2.00</b>	3.00	0.10	<b>0.15</b>	0.20
	10%	1.00	<b>2.00</b>	3.00	0.12	<b>0.18</b>	0.24
ODoT060508-GP	100%	1.00	<b>2.50</b>	4.00	0.10	<b>0.18</b>	0.26
	30%	1.00	<b>2.50</b>	4.00	0.12	<b>0.22</b>	0.32
	10%	1.00	<b>2.50</b>	4.00	0.14	<b>0.26</b>	0.38
ODKT060508-SC	100%	0.50	<b>2.00</b>	3.50	0.08	<b>0.14</b>	0.20
	30%	0.50	<b>2.00</b>	3.50	0.10	<b>0.17</b>	0.24
	10%	0.50	<b>2.00</b>	3.50	0.12	<b>0.20</b>	0.28
ODoT060508-TE	100%	1.00	<b>2.50</b>	4.00	0.12	<b>0.21</b>	0.30
	30%	1.00	<b>2.50</b>	4.00	0.14	<b>0.26</b>	0.38
	10%	1.00	<b>2.50</b>	4.00	0.16	<b>0.30</b>	0.44
OFKT05T305-AL	100%	0.50	<b>1.50</b>	2.50	0.08	<b>0.11</b>	0.14
	30%	0.50	<b>1.50</b>	2.50	0.10	<b>0.14</b>	0.18
	10%	0.50	<b>1.50</b>	2.50	0.12	<b>0.17</b>	0.22
ODKT060508-AL	100%	0.50	<b>2.00</b>	3.50	0.08	<b>0.14</b>	0.20
	30%	0.50	<b>2.00</b>	3.50	0.10	<b>0.17</b>	0.24
	10%	0.50	<b>2.00</b>	3.50	0.12	<b>0.20</b>	0.28
ODKW060508-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	0.09	<b>0.18</b>	0.27

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS