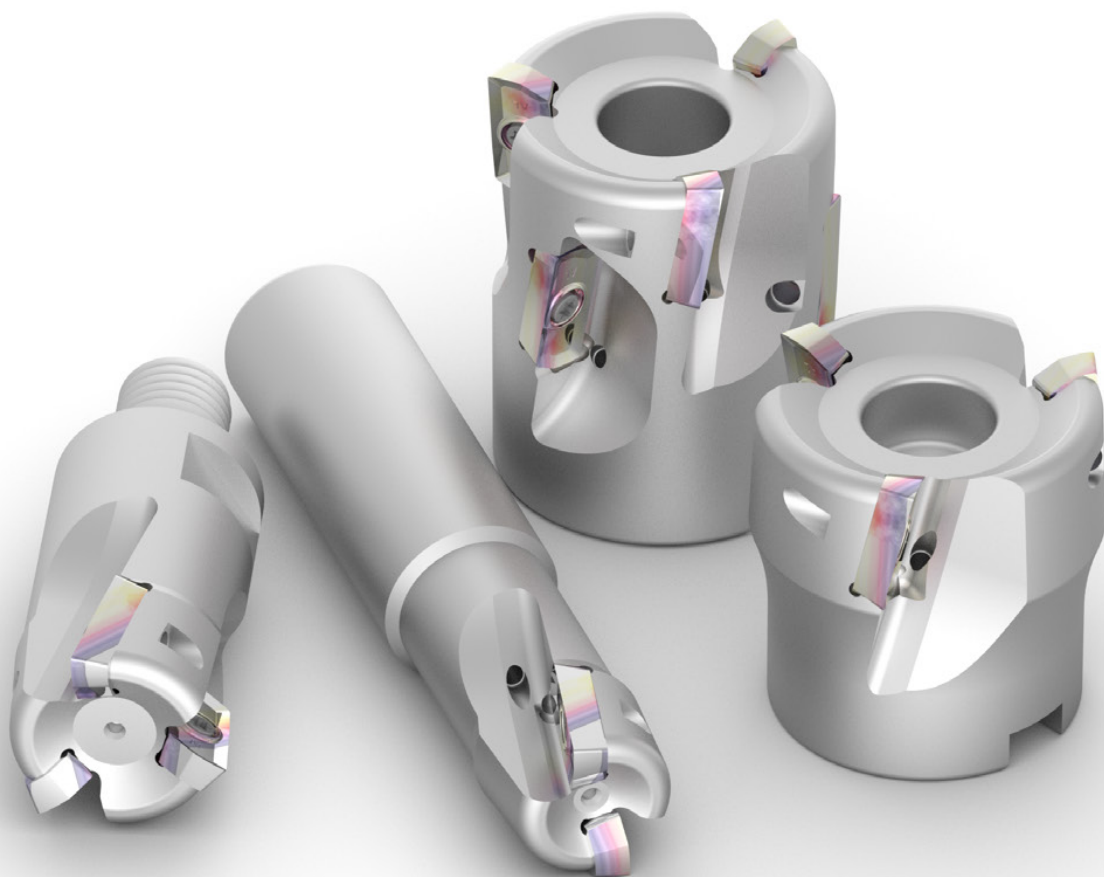


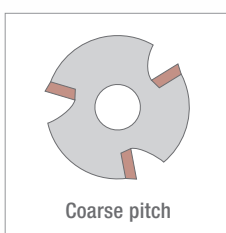


ALUREK ACTION

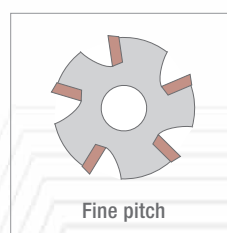
Sistema di fresatura sicuro ed economico per alluminio



Smart-Lock



Coarse pitch



Fine pitch



N

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

Inserti: NT-ALU9019

Corpi fresa: NT-ALU9019

nixkoTOOLS

uemme
TOOLS and EQUIPMENT

VALIDITA': 31/12/2023

ALUREK

Multi-functional shoulder milling cutters specially for non-ferrous materials

APPLICATION

- Shoulder milling
- Long overhang milling
- Profiling and Pocketing
- Linear and helical ramping

ISO APPLICATION FIELDS

N

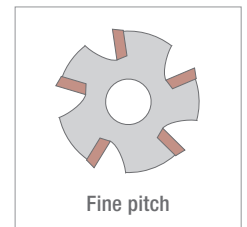
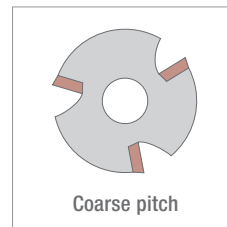
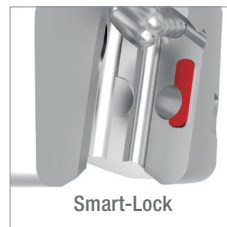
ADVANTAGES AND CHARACTERISTICS

- Inserts of helical geometry type can produce high precision 90°.
- PVD coated carbide inserts, an optimal cost-effective solution comparing with PCD milling.
- Different radii of inserts available.
- Smart-Lock at the back of the insert and on the cutter seats, guarantees a more reliable machining process and better surface finishing.
- Popular sizes of cutter bodies available with cylindrical shank, screw-in and arbor type connection, all with internal coolant.
- 10xD extensive sleeves available in both steel and carbide.



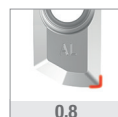
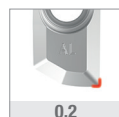
• Cutter bodies

- Arbor type
- Cylindrical type (up to 10xD)
- Screw-in type
- Extension sleeves (steel/carbide 10xD)
- From D25 to D50



• Inserts

- 2 cutting edges
- Edge length 19
- PVD coated carbide grade specially for N materials
- Geometries: AL
- With Smart-Lock



*Available upon request

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

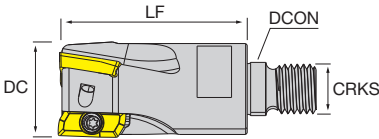
G - SPARE PARTS

NT-ALU90

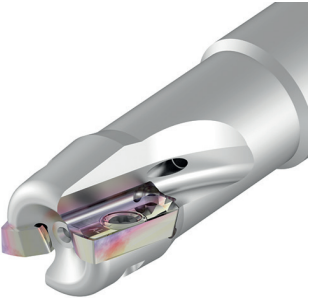
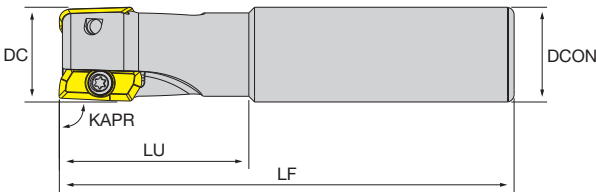
AluRek

- Highly positive and fine polished precision shoulder milling system tailored for aluminum and non-ferrous materials
- All with coolant through
- With Nikko smart-lock at the back of the insert and on the seat, offering better reliability and surface finishing
- Tolerance of tool diameter (with Nikko inserts installed) 0/-0.2

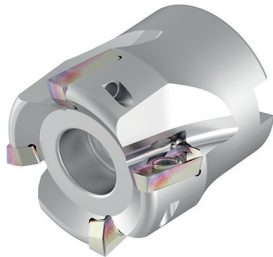
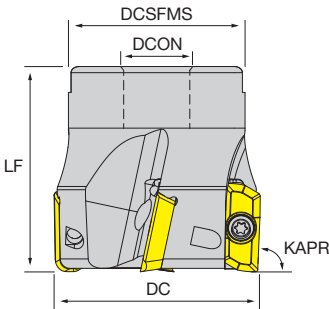
Screw-in



Cylindrical



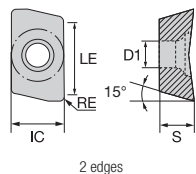
Arbor



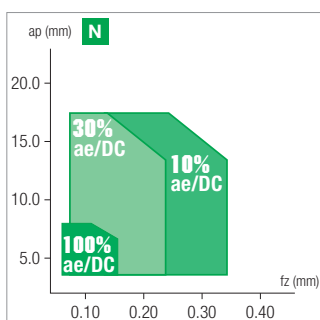
Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	KAPR		MIID
SCREW-IN											
NT-ALU9019 D025-M12-Z02	●	25	2	12.5	50	-	-	M12	90°		NT-ALU9019
NT-ALU9019 D032-M16-Z03	●	32	3	17	60	-	-	M16	90°		NT-ALU9019
CYLINDRICAL											
NT-ALU9019 D025-S25-Z02	●	25	2	25	120	50	-	-	90°		NT-ALU9019
NT-ALU9019 D032-S32-Z03	●	32	3	32	130	60	-	-	90°		NT-ALU9019
ARBOR											
NT-ALU9019 D040-F16-Z03	●	40	3	16	50	-	33	-	90°		NT-ALU9019
NT-ALU9019 D050-F22-Z03	●	50	3	22	50	-	43	-	90°		NT-ALU9019
NT-ALU9019 D050-F22-Z04	●	50	4	22	50	-	43	-	90°		NT-ALU9019

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

Spare parts	Insert screws	Flag wrenches
NT-ALU9019 D000-000-Z00	NT-ST40090T15	NT-FTB15

NT-ALU90		HF: Micrograin carbide PVD: Physical vapour deposition		HF PVD				
				JP6525				
AluRek								
• PVD coated micro-grain grade, optimal cost effective solution between uncoated carbide inserts and PCD • With Nikko smart lock at the back, provides better surface finishing • Sharp but reliable geometry, polished surface, precision periphery ground high performance solution • Multiple radii available, R0.2 / 0.8 / 3.2		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)						
 2 edges		P						
		M						
		K						
		N	400 1400					
		S						
		H						
Designation		RE	IC	S	D1	LE	Stock	
AL N  polished surface periphery ground	NT-ALU9019R02H-AL	0.2	9.5	4.76	4.6	19	●	
	NT-ALU9019R08H-AL	0.8	9.5	4.76	4.6	19	●	
	NT-ALU9019R32H-AL	3.2	9.5	4.76	4.6	19	●	

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



A - TURNING	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP6525				
					min	start	max		
	N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGAL)		100%	400	500	600		
				30%	600	800	1000		
				10%	800	1100	1400		
	N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		100%	200	350	500		
				30%	300	450	600		
				10%	400	550	700		

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

B - THREADING

C - GROOVING

D - MILLING

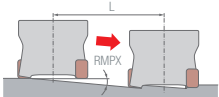
E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

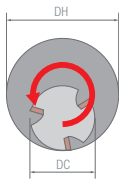
DESIGNATION	ae/DC	DEPTH OF CUT			FEED RATE		
		ap (mm)			fn (mm/rev)		
		min	start	max	min	start	max
NT-ALU9019R00H-AL	100%	1.00	4.00	7.00	0.06	0.10	0.14
	30%	1.00	9.00	17.00	0.08	0.15	0.22
	10%	1.00	9.00	17.00	0.10	0.20	0.30

Parameters for ramping

	ALU9019					
	DC	RMPX	L			
	25	3.4°	3.0			
	32	2.5°	2.9			
	40	1.4°	2.1			
	50	0.7°	1.4			

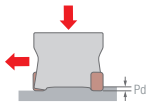
RMPX: max. ramping angle; L: max. ramping path

Parameters for helical milling

	ALU9019 R0.2			ALU9019 R0.8			ALU9019 R3.2			
	DC	DH min.	DH max.	DC	DH min.	DH max.	DC	DH min.	DH max.	
	25	32	49	25	33	48	25	37	47	
	32	46	63	32	47	62	32	51	61	
	40	62	79	40	63	78	40	67	77	
	50	82	99	50	83	98	50	87	97	

DH min.: min. cutting dia.; DH max.: max. cutting dia.

Peck milling

	Pd maximum pecking depth			
	Pd = 1 mm			