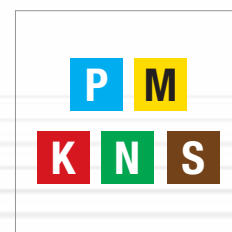
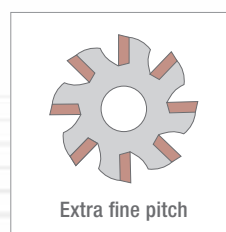
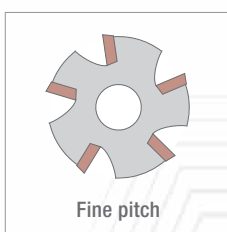
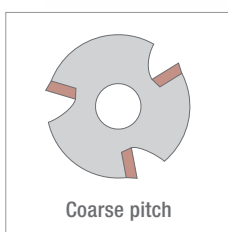




DOUBLE4FACE ACTION

Il meglio per la fresatura a spianare a 45°



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

Inserti: SNEX12, SNMX12

Corpi fresa: NT-SX12H

nixkoTOOLS

uemme
TOOLS and EQUIPMENT

VALIDITA': 31/12/2023

DOUBLE4FACE

First choice for high productivity face milling

APPLICATION

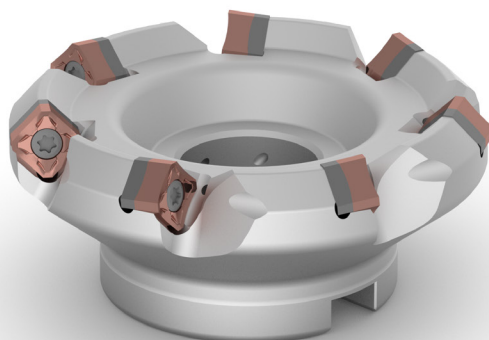
- Finishing / semi-finishing / rough face milling
- Removal of the crusted surfaces
- General milling of interrupted surfaces

ISO APPLICATION FIELDS

P M K N S

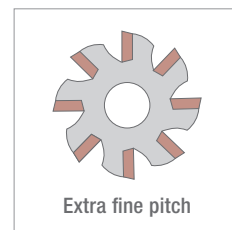
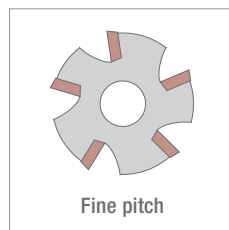
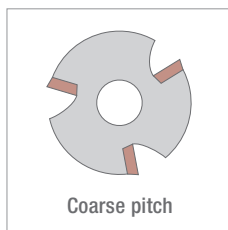
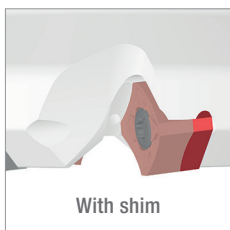
ADVANTAGES AND CHARACTERISTICS

- Curved geometry generates low cutting force and smooth cutting process.
- Shim style cutter in the entire range guarantees high stability and operational.
- Complete grades covering ISO P, M, K, N, S materials (with both PVD and CVD coating).
- Accurate inserts in tolerance E or pressed inserts in tolerance M - available both high precision and high economical solutions.



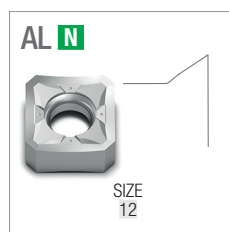
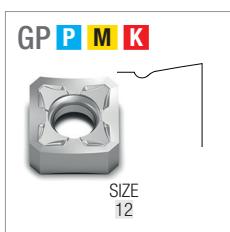
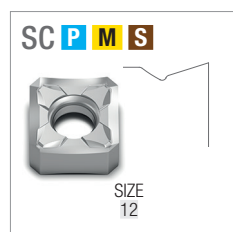
• Cutter bodies

- Arbor type with shim
- From D50 to D160



• Inserts

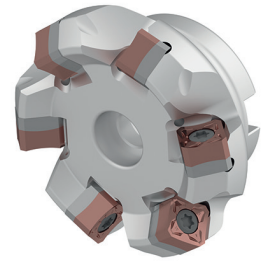
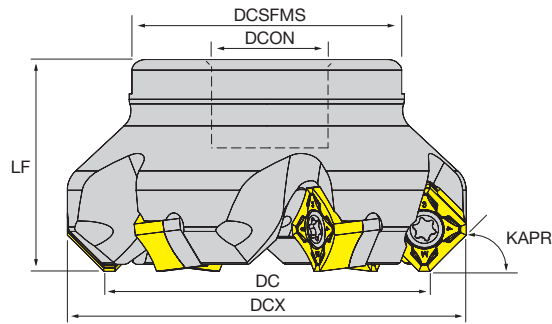
- 8 cutting edges
- Edge length 12 with APMX = 3 mm
- Cemented carbide grades with CVD and PVD coatings
- Geometries: SC, GP, TE, AL, WU wiper



NT-SX

Double4Face

- Double-sided face milling cutters, Kapr 45°
- With shims to protect the insert seats
- For double-sided square inserts with 8 cutting edges
- With coolant through



Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	DCX	WT	MIID
NT-SX12H D050-F22-Z04	●	50	4	22	40	-	48	-	64	0.48 Kg	SNoX1205
NT-SX12H D050-F22-Z05	●	50	5	22	40	-	48	-	64	0.46 Kg	SNoX1205
NT-SX12H D063-F22-Z05	●	63	5	22	50	-	52	-	77	0.69 Kg	SNoX1205
NT-SX12H D063-F22-Z06	●	63	6	22	50	-	52	-	77	0.67 Kg	SNoX1205
NT-SX12H D080-F27-Z06	●	80	6	27	50	-	60	-	94	1.29 Kg	SNoX1205
NT-SX12H D080-F27-Z07	●	80	7	27	50	-	60	-	94	1.27 Kg	SNoX1205
NT-SX12H D080-F27-Z08	●	80	8	27	50	-	60	-	94	1.25 Kg	SNoX1205
NT-SX12H D100-F32-Z07	●	100	7	32	50	-	70	-	114	1.64 Kg	SNoX1205
NT-SX12H D100-F32-Z08	●	100	8	32	50	-	70	-	114	1.62 Kg	SNoX1205
NT-SX12H D100-F32-Z09	●	100	9	32	50	-	70	-	114	1.59 Kg	SNoX1205
NT-SX12H D125-F40-Z10	●	125	10	40	63	-	80	-	139	2.92 Kg	SNoX1205
NT-SX12H D160-F40-Z12	●	160	12	40	63	-	85	-	174	4.36 Kg	SNoX1205

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

Spare parts	Insert screws	Flag wrenches	Shim	Shim screws	L wrench
NT-SX12H D 000 -F 00 -Z 00					
NT-SX12H D 000 -F 00 -Z 00	NT-ST40136T15	NT-FTB15	NT-SH009	NT-SR009	NT-WR040

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

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			JP5530			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%	90	130	170	60	100	140	80	120	160
			30%	110	160	210	80	130	180	100	150	200
			10%	130	190	250	100	160	220	120	180	240
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	100%	70	100	130				60	90	120
			30%	80	110	140				70	100	130
			10%	90	120	150				80	110	140
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	100%	90	120	150	60	90	120	80	110	140
			30%	110	150	190	80	120	160	100	140	180
			10%	130	170	210	100	140	180	120	160	200
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		100%	80	110	140				70	100	130
			30%	90	120	150				80	110	140
			10%	100	130	160				90	120	150
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC7515			JC8520			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	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	JU6520								
				min	start	max						
N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGAL)		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						
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC9540			JP9535					
				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			
			30%	40	50	60	30	40	50			
			10%	50	60	70	40	50	60			
S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		100%				40	50	60			
			30%				50	60	70			
			10%				60	70	80			

ae: radial depth of cut; DC: milling cutter diameter

Complete workpiece materials p. H1.

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

A - TURNING	DESIGNATION	ae/DC	DEPTH OF CUT			FEED RATE		
			ap (mm)			fz (mm)		
			min	start	max	min	start	max
B - THREADING	SNxX1205ANEN-GP	100%	1.00	2.00	3.00	0.13	0.21	0.29
		30%	1.00	2.00	3.00	0.16	0.26	0.36
		10%	1.00	2.00	3.00	0.20	0.31	0.42
	SNEX1205ANEN-SC	100%	0.50	1.50	2.50	0.06	0.12	0.18
		30%	0.50	1.50	2.50	0.08	0.15	0.22
		10%	0.50	1.50	2.50	0.10	0.18	0.26
	SNxX1205ANSN-TE	100%	1.00	2.00	3.00	0.16	0.25	0.34
		30%	1.00	2.00	3.00	0.20	0.32	0.44
		10%	1.00	2.00	3.00	0.24	0.38	0.52
C - GROOVING	SNEX1205ANFN-AL	100%	0.50	1.50	2.50	0.10	0.20	0.30
		30%	0.50	1.50	2.50	0.12	0.25	0.38
		10%	0.50	1.50	2.50	0.14	0.28	0.42
	SNEX1205-WU	100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
D - MILLING		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
E - DRILLING		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
F - ACCESSORIES		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
G - SPARE PARTS		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28
		100%	0.50	1.00	1.50	0.06	0.13	0.20
		30%	0.50	1.00	1.50	0.08	0.16	0.24
		10%	0.50	1.00	1.50	0.10	0.19	0.28