

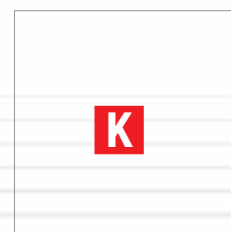
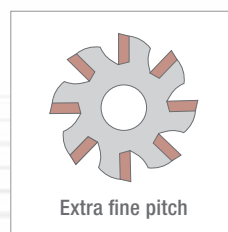
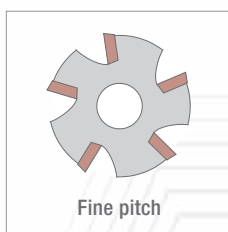
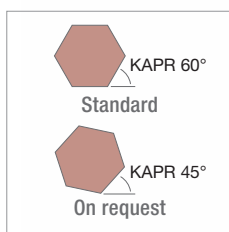


DOUBLEHEX ACTION

Sistema di fresatura sicuro ed economico per ghisa



Wedge clamping



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

Inserti: HN..09

Corpi fresa: NT-HN09

nixkoTOOLS

uemme
TOOLS and EQUIPMENT

VALIDITA': 31/12/2023

DOUBLEHEX

Safe and high economical milling system for cast iron

APPLICATION

- Roughing or semi-finishing face milling of cast iron
- Adapted for interrupted surfaces
- Adapted for remove the casted hard skins

ISO APPLICATION FIELDS

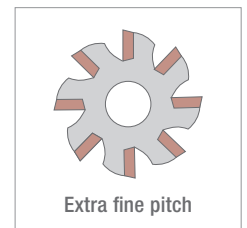
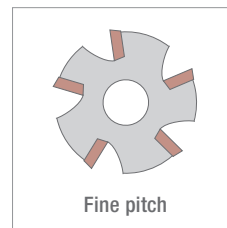
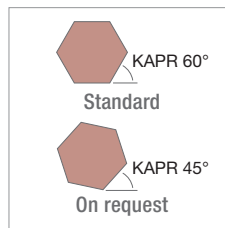
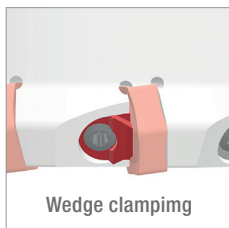
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ADVANTAGES AND CHARACTERISTICS

- Fine pitch and extra-fine pitch type cutters available. Dense teeth in the cutter body allows higher table feeds with exceptional productivity.
- Precise inserts in tol.E or in tol.M, high precision or high economical solutions available.
- 3 different chipbreakers combined with both PVD and CVD grades.
- Inserts also available in solid PCBN and Silicon Nitride.
- Extremely competitive cost per cutting edge.

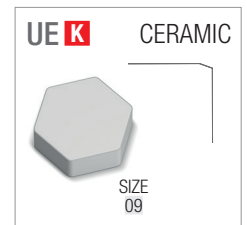
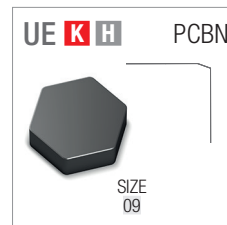
• Cutter bodies

- Arbor type
- From D80 to D160



• Inserts

- 12 edges
- Edge length 09 with APMX = 6 mm
- Carbide grades with PVD and CVD coatings, solid PCBN and ceramic
- Geometries: GL, GG, GH, Advanced



A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

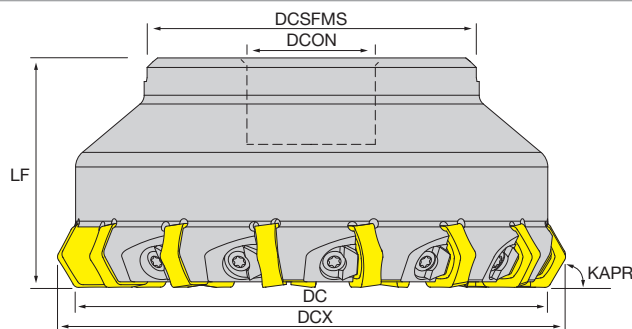
F - ACCESSORIES

G - SPARE PARTS

NT-HN

DoubleHex

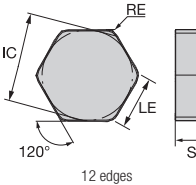
- Double-sided face milling cutters specially for cast iron
- For hexagonal inserts with 12 cutting edges
- Kapr 60° and 45° upon request
- Extra fine pitch available



Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	DCX	WT	MIID
KAPR 60°											
NT-HN09 D080-F27-Z08	●	80	8	27	50	-	60	-	90	1.28 Kg	HNoX0905
NT-HN09 D080-F27-Z10	●	80	10	27	50	-	60	-	90	1.23 Kg	HNoX0905
NT-HN09 D100-F32-Z10	●	100	10	32	50	-	80	-	110	1.87 Kg	HNoX0905
NT-HN09 D100-F32-Z14	●	100	14	32	50	-	80	-	110	1.80 Kg	HNoX0905
NT-HN09 D125-F40-Z12	●	125	12	40	63	-	88	-	135	3.55 Kg	HNoX0905
NT-HN09 D125-F40-Z15	●	125	15	40	63	-	88	-	135	3.33 Kg	HNoX0905
NT-HN09 D160-F40-Z15	●	160	15	40	63	-	120	-	170	5.10 Kg	HNoX0905
NT-HN09 D160-F40-Z20	●	160	20	40	63	-	120	-	170	4.98 Kg	HNoX0905
KAPR 45°											
NT-HN0945 D080-F27-Z10	●	80	10	27	50	-	60	-	92.4	1.30 Kg	HNoX0905

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

Spare parts	Wedge	Wedge screws	L wrench
NT-HN09 D000-F00-Z00	NT-WD090	NT-SC090	NT-WR030

HN		HC: Coated carbide HF: Micrograin carbide BH: High volume CBN CN: Silicon nitride ceramic Si3N4 CVD: Chemical vapour deposition PVD: Physical vapour deposition						HC	HF	BH	CN
DoubleHex								JC7515	JP7525	NBH550U	NSN400
- Double-sided face milling inserts specially for cast iron - Hexagonal inserts with 12 cutting edges - Coated carbide, CBN and ceramic grades available, covering a wide range of applications - Geometries featuring different applications on cast iron, from light to heavy cutting	Stable machining, light cut						●			●	
	General machining, medium cut						●	●	●	●	
	Unstable machining, heavy cut						⚙	⚙	⚙		
	1 st choice										
	suitable										
Dimensions		ISO						Vc(m/min) - suggested cutting speed range (bold: 1 st choice)			
		P									
		M									
		K		180 360	140 300	800 2000	600 1200				
		N									
		S									
		H									
Designation		RE	IC	S	LE	AN	Stock				
GENERAL	GG K 	HNEX090520-GG	2	16.2	5.56	9.35	0°	●	●		
		HNMX090520-GG	2	16.2	5.56	9.35	0°	●	●		
LOW FORCE	GL K 	HNEX090510-GL	1	16.2	5.56	9.35	0°	●	●		
		HNEX090520-GL	2	16.2	5.56	9.35	0°	●	●		
REINFORCED	GH K 	HNEX090516-GH	1.6	16.2	5.56	9.35	0°	●	●		
		HNEX090530-GH	3	16.2	5.56	9.35	0°	●	●		
		HNMX090516-GH	1.6	16.2	5.56	9.35	0°	●	●		
ADVANCED	UE K  PCBN full solid	HNEN090520S-UE	2	16.2	5.56	9.35	0°			●	
ADVANCED	UE K  CERAMIC silicon nitride	HNEN090520T-UE	2	16.2	5.56	9.35	0°			●	
		HNEN090530T-UE	3	16.2	5.56	9.35	0°			●	

A - TURNING	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC7515			JP7525			
					min	start	max	min	start	max	
	K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	100% 30% 10%	180 200 220	230 260 290	280 320 360	140 160 180	180 210 240	220 260 300	
B - THREADING	K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	100% 30% 10%	120 160 200	180 220 260	240 280 320	100 120 140	140 170 200	180 220 260	
	K3 - K4	Austenitic and ADI cast iron (ex. 0.6660/GGL-NiCr 20 2/Ni-Resist 2, GJS-1000-5/ ADI1000)	250 ÷ 500	100% 30% 10%	100 140 180	140 180 220	180 220 260	90 120 150	120 150 180	150 180 210	

ISO 513	MATERIAL	HARDNESS HB	ae/DC	NBH550U			NSN400			
				min	start	max	min	start	max	
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	100% 30% 10%	800 1000 1200	1000 1300 1600	1200 1600 2000	400 550 800	600 750 900	800 950 1000	

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
HNx090520-GG	100%	1.00	3.00	5.00	0.10	0.25	0.40
	30%	1.00	3.00	5.00	0.13	0.32	0.51
	10%	1.00	3.00	5.00	0.16	0.38	0.60
HNEX090500-GL	100%	0.50	2.50	4.50	0.08	0.22	0.36
	30%	0.50	2.50	4.50	0.10	0.27	0.44
	10%	0.50	2.50	4.50	0.12	0.32	0.52
HNx090500-GH	100%	1.00	3.50	6.00	0.13	0.31	0.50
	30%	1.00	3.50	6.00	0.16	0.39	0.62
	10%	1.00	3.50	6.00	0.19	0.46	0.73
HNEN090500-UE	100%	1.00	2.00	3.00	0.13	0.28	0.43
	30%	1.00	2.00	3.00	0.16	0.35	0.54
	10%	1.00	2.00	3.00	0.20	0.41	0.62

A - TURNING

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F - ACCESSORIES

G - SPARE PARTS