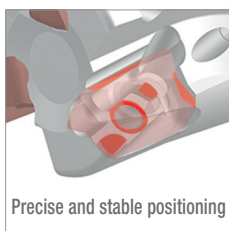


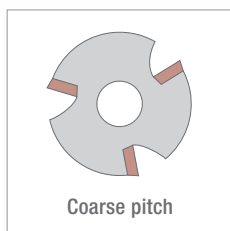


DOUBLEREK ACTION

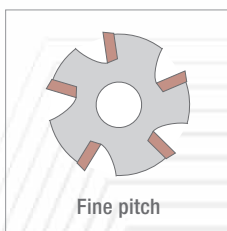
Per spallamenti di elevata precisione con accuratezza superiore



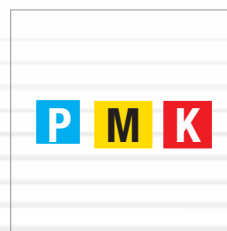
Precise and stable positioning



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

nikkoTOOLS

scadenza: 31/12/2025

uerme
TOOLS and EQUIPMENT

DOUBLEREK

High productivity high precision double sided shoulder milling system

APPLICATION

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

ISO APPLICATION FIELDS

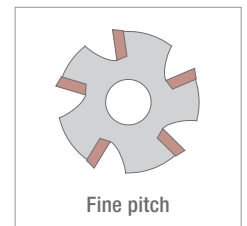
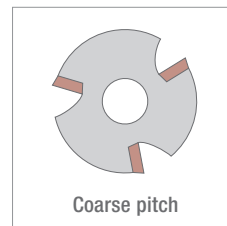
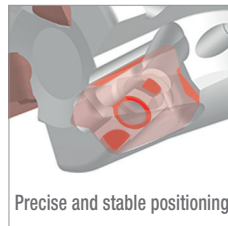
P M K

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

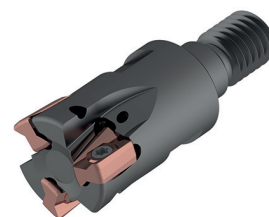
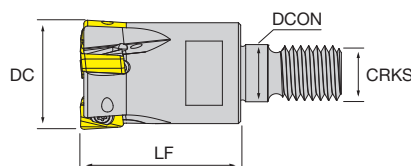
G - SPARE PARTS

NT-DRK

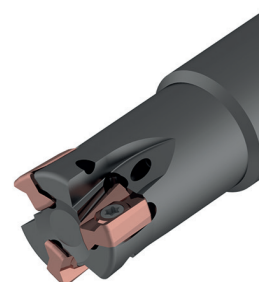
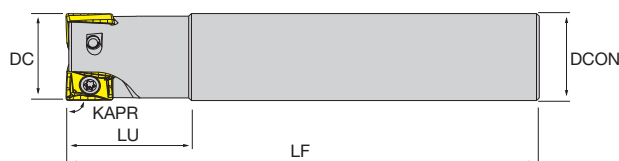
DoubleRek

- 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

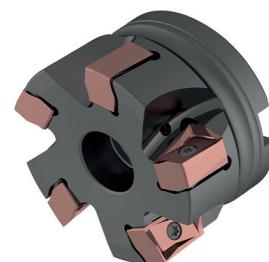
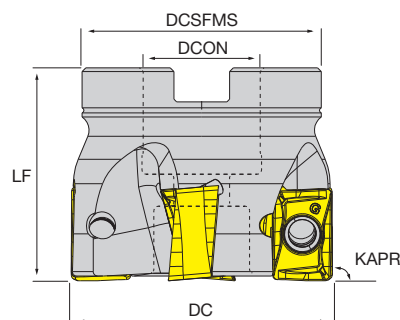
Screw-in



Cylindrical



Arbor



Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	KAPR	WT	MIID
SCREW-IN											
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
CYLINDRICAL											
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
ARBOR											
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

A - TURNING

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E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

NT-DRK

DoubleRek

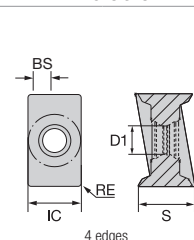
- GP and TE are both helical geometries with reduced cutting resistance
- Precise and enhanced positioning guarantees more reliability in machining
- Available in diverse grades covering wide application range

HC: Coated carbide
 HF: Micrograin carbide
 CVD: Chemical vapour deposition
 PVD: Physical vapour deposition

HC	HC	HC	HF	HF	HF	HF	HF
CVD	CVD	CVD	PVD	PVD	PVD	PVD	PVD
JC7515	JC8520	JC9540	JP5530	JP7525	JP8725	JP9535	JP9545

Stable machining, light cut ● 1st choice ○ suitable
 General machining, medium cut ● 1st choice ○ suitable
 Unstable machining, heavy cut ▲ 1st choice ▲ suitable

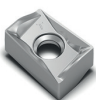
Dimensions



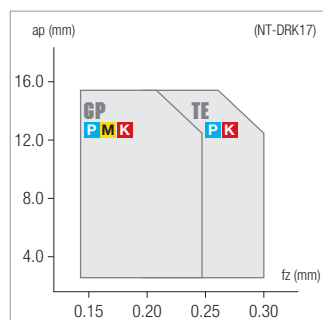
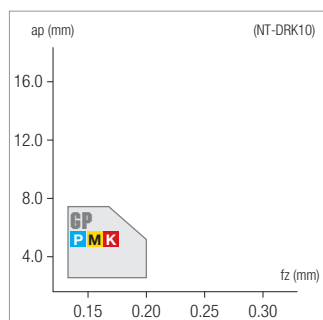
ISO

Vc(m/min) - suggested cutting speed range (bold: 1st choice)

P	130 300	100 260	100 280		
M		90 210	60 180	80 200	60 180
K	180 360	160 320	140 300		
N					
S		30 70		20 60	20 50
H					

Designation		RE	IC	S	D1	BS	Stock							
GENERAL	GP P M K													
	 NT-DRK10R08K-GP	0.8	5.82	5.45	2.9	0.9	●	●	●	●	●	●	●	
REINFORCED	GP P M K													
	 NT-DRK17R08K-GP	0.8	11.2	10.94	5.2	3.2	●	●	●	●	●	●	●	
REINFORCED	TE P K													
	 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
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
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
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.

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

A - TURNING
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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	2.50	4.00	0.08	0.10	0.12
	30%	1.00	4.00	7.00	0.10	0.13	0.16
	10%	1.00	4.00	7.00	0.12	0.16	0.20
NT-DRK17R08K-GP	100%	1.00	4.00	7.00	0.11	0.18	0.21
	30%	1.00	8.00	15.00	0.14	0.20	0.26
	10%	1.00	8.00	15.00	0.16	0.23	0.30
NT-DRK17R12K-TE	100%	1.00	4.00	7.00	0.13	0.19	0.25
	30%	1.00	8.00	15.00	0.16	0.23	0.30
	10%	1.00	8.00	15.00	0.20	0.27	0.34



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