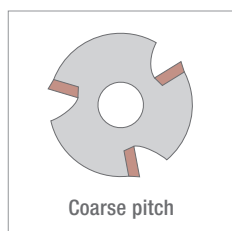




OKTOPLUS ACTION

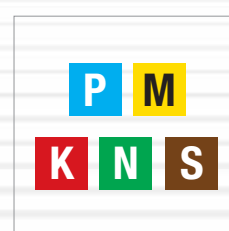
per spianatura economica con inserto ottagonale



Coarse pitch



Fine pitch



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

nixkoTOOLS

uemme
TOOLS and EQUIPMENT

VALIDITA': 31/12/2023

OKTOPLUS

Multi-edge face mill to optimize production economy

APPLICATION

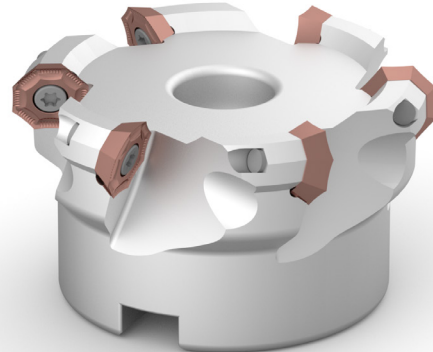
- Finishing / semi-finishing / rough face milling
- Removal of the crusted surfaces
- General milling of interrupted surfaces

ISO APPLICATION FIELDS

P M K N S

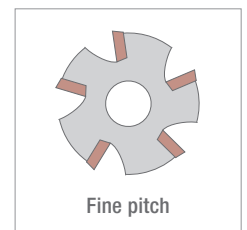
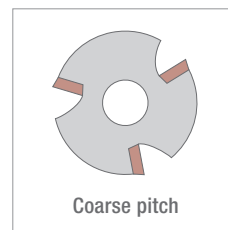
ADVANTAGES AND CHARACTERISTICS

- 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

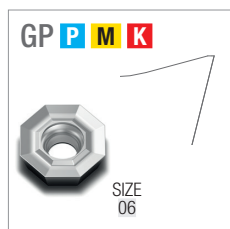
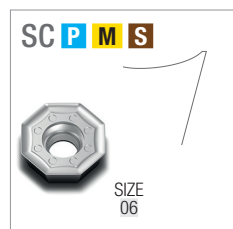
- Arbor type with coolant
- From D50 to D160



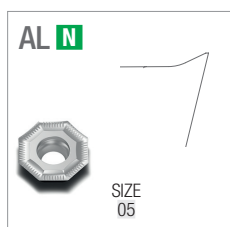
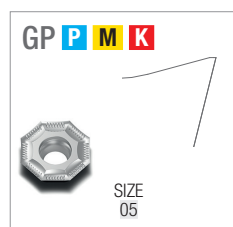
• Inserts

- 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

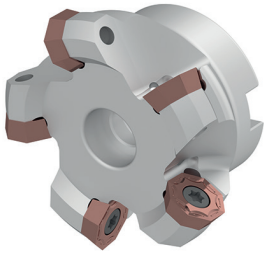
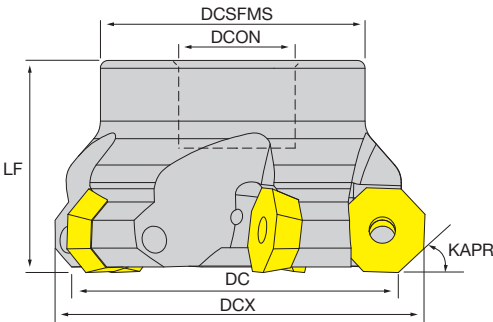
F - ACCESSORIES

G - SPARE PARTS

NT-OD

OktoPlus OD

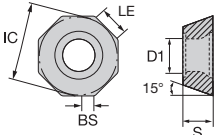
- Positive general face milling cutters
- For octagonal inserts with 8 cutting edges
- K_{apr} 43°
- With coolant through



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	0Doo0605
NT-OD06H D063-F22-Z05	●	63	5	22	40	-	50	-	73	0.52 Kg	0Doo0605
NT-OD06H D080-F27-Z06	●	80	6	27	50	-	60	-	90	1.05 Kg	0Doo0605
NT-OD06H D100-F32-Z07	●	100	7	32	50	-	70	-	110	1.48 Kg	0Doo0605
NT-OD06H D125-F40-Z08	●	125	8	40	63	-	80	-	135	2.60 Kg	0Doo0605
NT-OD06H D160-F40-Z10	●	160	10	40	63	-	85	-	170	3.96 Kg	0Doo0605

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

Spare parts	Insert screws	Flag wrenches
NT-OD06H Dooo-Foo-Zoo	NT-ST50110T20	NT-FTB20

OD		HC: Coated carbide HF: Micrograin carbide CVD: Chemical vapour deposition PVD: Physical vapour deposition						HC CVD	HF PVD	HF PVD	HF PVD	HF PVD	HF		
OktoPlus OD								JP7515	JP5520	JP5530	JP7525	JP9535	JUG520		
- Positive general face milling inserts 8 cutting edges - Kapr 43° - Diverse carbide grades with PVD and CVD coating grades available, covering a wide range of applications - Sharp/universal/robust/wiper geometries available		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: 1 st choice)									
		 8 edges		P		100 260		100 260							
M				60 180		60 180				80 200					
K				180 360				140 300							
N										300 1100					
S										20 60					
H															

Designation		BS	IC	S	D1	LE	Stock							
GENERAL	GP P M K 	ODKT060508-GP	1.8	15.875	3.56	5.5	5					▽	●	
	ODMT060508-GP	1.8	15.875	3.56	5.5	5	●	▽	●	●	●			
LOW FORCE	SC P M S 	ODKT060508-SC	1.8	15.875	3.56	5.5	5		▽	▽		●		
REINFORCED	TE P K 	ODKT060508-TE	1.8	15.875	3.56	5.5	5		▽					
	ODMT060508-TE	1.8	15.875	3.56	5.5	5	○	▽	●	●				
ALUMINIUM	AL N  polished surface periphery ground	ODKT060508-AL	1.8	15.875	3.56	5.5	5						●	
WIPER	WU P K  2 edges	ODKW060508-WU	6.4	15.875	3.56	5.5	5		▽	●	●			

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

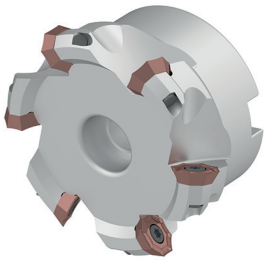
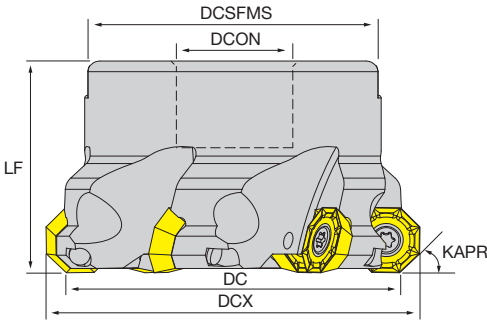
F - ACCESSORIES

G - SPARE PARTS

NT-OF

OktoPlus OF

- Positive general face milling cutters
- For octagonal inserts with 8 cutting edges
- K_{apr} 43°
- With coolant through



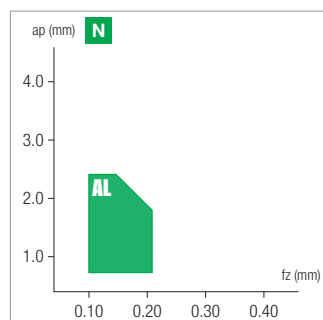
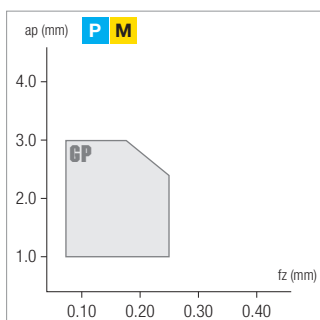
Designation	Stock	DC	CICT	DCON	LF	LU	DCSFMS	CRKS	DCX	WT	MIID
NT-OF05H D050-F22-Z05	●	50	5	22	40	-	46.8	-	58	0.34 Kg	0F0005T3
NT-OF05H D063-F22-Z06	●	63	6	22	40	-	56	-	71	0.58 Kg	0F0005T3
NT-OF05H D080-F27-Z07	●	80	7	27	50	-	60	-	88	0.91 Kg	0F0005T3
NT-OF05H D100-F32-Z08	▲	100	8	32	50	-	70	-	108	1.40 Kg	0F0005T3

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

Spare parts	Insert screws	Flag wrenches
NT-OF05H D000-F00-Z00	NT-ST40110T15HQ	NT-FTB15

OFKT		HC: Coated carbide HF: Micrograin carbide CVD: Chemical vapour deposition PVD: Physical vapour deposition		HC CVD	HF PVD	HF					
OktoPlus OF				JC7530	JP5540	JU6520					
Positive general face milling inserts 8 cutting edges Kapr 43° Diverse carbide grades with PVD and CVD coating grades available, covering a wide range of applications Sharp/universal/robust/wiper geometries available		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: 1 st choice)					
		IC LE D1 BS S 26° 8 edges		P	80 220						
				M	60 180						
				K	160 320						
N	300 1100										
S	20 50										
H											
Designation		BS	IC	S	D1	LE	Stock				
GENERAL	GP P M K										
	 OFKT05T305-GP	1.1	12.7	3.97	4.4	4	▽	●			
ALUMINIUM	AL N										
	 polished surface periphery ground OFKT05T305-AL	1.1	12.7	3.97	4.4	4		●			

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



A - TURNING	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP5530			JP5540					
					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%	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			
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						
B - THREADING	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
				30%	80	130	180	80	130	180	100	150	200
				10%	100	160	220	100	160	220	120	180	240
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
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
								80	110	140	90	120	150
D - MILLING	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%	180	230	280	140	180	220			
				30%	200	260	320	160	210	260			
				10%	220	290	360	180	240	300			
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						
N1		Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGA)		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						
G - SPARE PARTS	ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP5540			JP9535					
					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			
				30%	30	35	40	30	40	50			
				10%	40	45	50	40	50	60			
S4 - S5		Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		100%	30	40	50	40	50	60			
				30%	40	50	60	50	60	70			
				10%	50	60	70	60	70	80			

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

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS