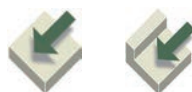


NTK Milling Cutter Selection

Machining Gray / Ductile Cast Iron



XFM series



88°
Lead angle

A.R.-4° R.R.0°

Features

- Large DOC is possible because of the fine pitch of inserts which results in higher productivity
- LNX insert comes with a special chipbreaker to reduce tool pressure
- Newly added Left-hand cutters
- Up to .300" depth of cut

HVM series



45° 75° 88°
Lead angles

A.R.-6° R.R.-10°

Features

- Extremely economical 8-corner inserts (SNG43...)
- Covers various applications with 45, 75, and 88 degree angle milling cutters
- Ceramic inserts with chipbreaker and wiper are available
- Up to .220" depth of cut

JQ series



90°
Lead angle

Features

- Capable of 90-degree shoulder milling
- A variety of cutter diameters as small as .787 (φ20mm)
- APCW inserts standard edge prep also available with wiper
- Up to .320" depth of cut

TRI series



88°
Lead angle

A.R.5° R.R.4°,7°,10°

Features

- Stable gray cast iron milling with lower cutting forces
- Maximizes ceramic insert potential and can mill faster than 3,200 SFM
- WNX inserts with radius or chamfer
- Up to .220" depth of cut

HSM series



45° 75° 88°
Lead angles

A.R.+12° R.R.0°

Features

- Positive inserts (SDCW) reduce tool pressure and produce excellent surface finish in addition to long tool life
- Best for milling thin parts thanks to reduced tool pressure
- Up to .200" depth of cut

COMING SOON: New Cutter | Large DOC | 90 Degree Shoulder Milling

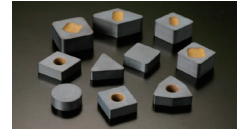
SX6 Ceramic

Premium Silicon Nitride

Features

- *Excellent wear resistance in applications where notch wear appears*
- *Stable tool life in the applications where thermal shock resistance is required : such as WET machining or milling*

Work material	Application	Purpose	Cutting speed (SFM)	Feed (IPR / IPT)	Depth of cut (inch)	DRY	WET
Cast iron	Milling	Rough	1500-4200	.003-.010	.020-.140	●	●



SP9 Ceramic + Coating

High Speed machining with low cutting forces

Features

- *Excellent wear- resistance and chipping resistance with CVD coated high-strength silicon nitride-based ceramic*
- *Achieves lower tool pressure with minimal edge preparation*
- *Also usable for finishing*

Work material	Application	Purpose	Cutting speed (SFM)	Feed (IPR / IPT)	Depth of cut (inch)	DRY	WET
Gray cast iron	Milling	Rough-Semi finish	1200-2500	.003-.010	-.240	●	○
Ductile cast iron	Milling	Rough-Semi finish	2100-3000	.003-.010	-.240	●	○



B30 CBN

Features

- *Excellent wear resistance thanks to high CBN content*
- *Designed for finishing cast iron*

- CBN Wiper Insert: Can install 1 or 2 CBN Wiper Inserts with ceramic insert.
- Available for: JQ Series - APCW inserts
HVM Series - FDX inserts
HSM Series - SDW inserts

B52 CBN

Features

- *Excellent wear resistance due to optimum CBN content with special TiC binders*
- *Ideal for finishing ductile cast iron and continuous cuts for finishing hardened materials*



Tungaloy-NTK USA

3726 N. Ventura Dr., Arlington Heights, IL 60004

www.ntkcuttingtools.com/us

youtube.com/NTKCUTTINGTOOLS

DISTRIBUTED BY

