

#### Features

- **More teeth = More productivity**
- **Light weight aluminum body**
- **Adjustable edge height**
- **Produces outstanding surface finishes**
- **Internal coolant supply**
- **Inserts can be reground up to 4 times**
- **Guaranteed setup service is available**

#### Cutter

Technical drawing of a cutter showing dimensions: A.R. 0° R.R. +5°, ϕd, b, h, ϕD.




Item Number	Stock		Weight	Dimensions										Max RPM	Arbor style	Arbor bolt	Recommended tightening torque	
				ϕD		h		ϕ d		b		a					N • m	lb • ft
				inch	mm	inch	mm	inch	mm	inch	mm	inch	mm					
JHF050C2200R07	●	7	0.5	1.969	50	1.772	45	.866	22.0	.409	10.4	.409	6.3	20,000	FMC22	CS1040A	20	14.8
JHF063C2200R10	●	10	0.8	2.480	63	1.772	45	.866	22.0	.409	10.4	.409	6.3	20,000	FMC22	CS1040A	20	14.8
JHF080A2540R12	●	12	1.1	3.150	80	1.772	45	1.000	25.4	.374	9.5	.374	6.0	18,000	FMA25.4	MBC-M12	40	29.5
JHF100A2540R16	●	16	1.6	3.937	100	1.772	45	1.000	25.4	.374	9.5	.374	6.0	18,000	FMA25.4	MBC-M12	40	29.5
JHF125A2540R22	●	22	2.4	4.921	125	1.772	45	1.000	25.4	.374	9.5	.374	6.0	15,000	FMA25.4	MBC-M12	40	29.5

\* Includes inserts and parts

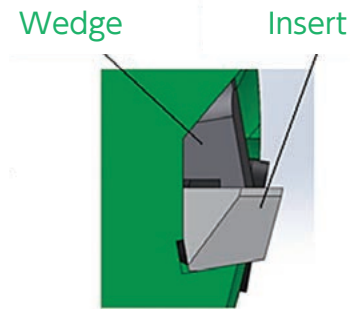
#### Insert

	Item Number	PCD	Corner angle	Max DOC		A.R.	r <sub>e</sub>		Wiper
		PD1		inch	mm		inch	mm	
For Standard use 	HFT802006C05	●	90°	.295	7.5	6°	.02 chamfer	C0.5	Yes (Rounded)
	HFT802006R04	●	90°	.295	7.5	6°	R .016	R0.4	Yes (Rounded)
For less tool pressure 	HFT70201W05	●	90°	.256	6.5	10°	Double chamfer		Yes (Straight)

## ● Spare Parts

Item number	Arbor bolt	Wedge	Axial set screw		Wedge set screw	
			Screw	Screwdriver	Screw	Screwdriver
JHF050C2200R07	CS1040A	HLW179	CS0510A	LW-4	WS0512	LW-2.5
JHF063C2200R10						
JHF080A2540R12	MBC-M12			LW-4		LW-2.5
JHF100A2540R16						
JHF125A2540R22						

## ● Safety clamp mechanism



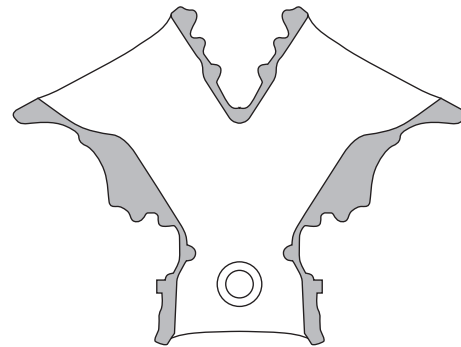
● Unique sphenoidal pocket prevents inserts from becoming dislodged

## ● Field Result

Part : Chain Cover  
Material : ADC12

Cutter : JHF125A2540R22  
Insert : HFT802006C05 PD1

	NTK	Competitor's
Number of edges	22	14
RPM	10,000	10,000
SFM	12,877	←
IPM	520	330
IPT	.0024	←
DOC	.111 (1 Pass)	.080+.031 (2 Passes)
Tool life	50,000pcs	10,000pcs



NTK : HFC	520 IPM	157% productivity
Competitor's	330 IPM	
NTK : HFC	50,000 pcs	500% Tool life
Competitor's	10,000 pcs	

## ● Recommend Cutting Conditions

Work Material	Grade	Dry	Wet	Cutting Speed (SFM)												Feed (IPT)						Depth of Cut (inch)	
				1000	3000	5000	7000	9000	11000	13000	15000	17000	19000	.002	.004	.006	.008	.010	.012				
N	PD1	○	●																				
Aluminum Alloy (Si ≤ 13)																							
Aluminum Alloy (Si ≥ 13)	PD1	○	●																				

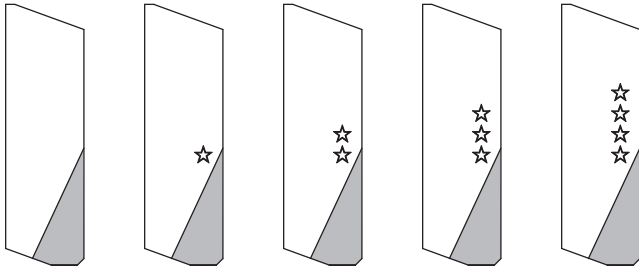
# Rotating Tools

## NTK Regrind Program

- Inserts can be reground up to (4\*) times
- The cutter's diameter and height of the insert will change by .004" after each regrind
- The set of inserts placed back into the cutter must have the same amount of stars indicating number of regrinds

\*The number of regrinds per insert may vary depending upon cutting conditions

Each insert will be marked with a star to indicate how many times it has been reground.



New

After 1st  
regrinding

After 2nd  
regrinding

After 3rd  
regrinding

After 4th  
regrinding

- 1 Send the inserts back to our NTK Wixom office with the appropriate paperwork. Minimum order is 30 pcs.  
(Note: Send in inserts with the same amount of regrind stars.)  
For orders greater than 50 pcs, NTK will manage the inserts in lots for regrind process.



- 2 Delivery will be 6-8 weeks upon receiving your inserts



- 3 The insert number will be changed to the following  
HFT802006C05 RPD1



- 4 When installing NTK inserts into a cutter, please make sure that all the inserts have the same number of regrind stars

## NTK's Worry free guaranteed setting

- NTK offers cleaning, resetting and rebalancing service to customer for new and reground inserts.
- NTK's guaranteed setting provides stable and worry free operation.

### Re-setting



$\pm .002\text{mm}$  height run out  
( $\pm .00008''$ )

### Re-balancing



Balance grade: G 2.5

## Adjusting and handling instructions for High Feed Cutter

### Operational procedure

1. Loosen the axial adjustment screw
2. Install the inserts (initially tighten)
3. Clean the inserts
4. Adjust height of inserts (initial)
5. Tighten the wedge set screw
6. Adjust height of inserts (final)

#### Tools for setup

- Tool presetter
- Air blower
- Clay
- 4.0mm Hex wrench
- 2.5mm Hex torque-wrench

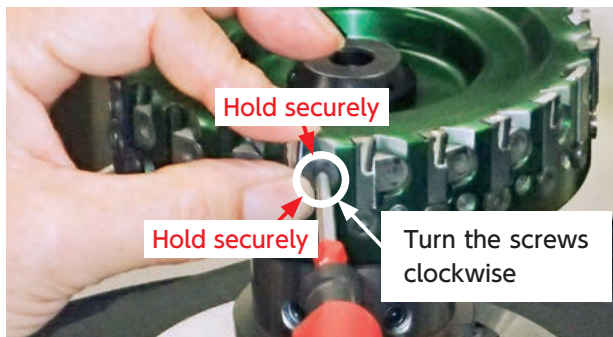


### 1. Loosen the axial adjustment screw



Loosen axial set screw until the screw head is 1 to 2 mm from cutter body.  
Clean up insert pocket using air.

### 2. Install the inserts (initially tighten)



Install the insert to cutter pocket. Tighten wedge set screw with 1Nm torque while pushing insert to cutter center using two fingers. (do not overtighten)

### 3. Clean the inserts



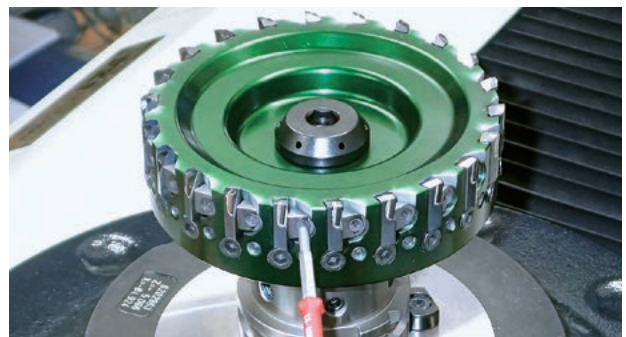
Clean up insert edges using clay.

### 4. Adjust height of inserts (initial)



Tighten axial set screw of each insert until you reach around 44.980 mm height dimension.  
Adjust other inserts within 0.01mm range.

### 5. Tighten the wedge set screw



Tighten wedge set screws with 4Nm torque.

### 6. Adjust height of inserts (final)



Tighten axial set screws to get 45.000 mm height dimension.  
Adjust other inserts within +/- 0.002 mm range.