

DOUBLEHEX

Double sided face milling system for cast iron

Application

- Face milling system for cast iron with double sided 12-cutting-edge inserts.
 - Adapted for interrupted surfaces
 - Effective for casted hard skin removal
- Sistema per spianatura di ghisa con inserti bilaterali a 12 taglienti.
 - Efficace anche nella rimozione della crosta superficiale
 - Spianatura anche di superfici irregolari.
- Schruppfräsen oder Schruppschlichtfräsen von Grauguss
 - Geeignet für unterbrochene Oberflächen
 - Zum Entfernen von Schmelzkrusten geeignet
- Surfaçage
 - Fiable même en conditions d'usinage instables
 - Applications générales, même en coupes interrompues

Application range - ISO 513

K



Advantages and features

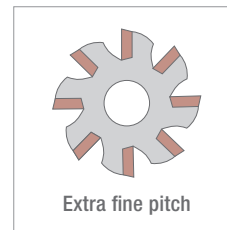
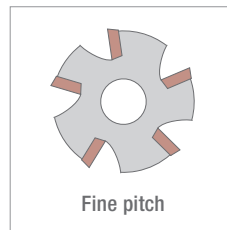
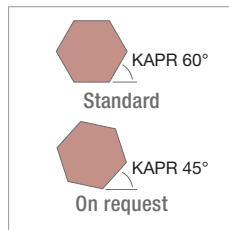
- Milling holders available in fine and extra-fine pitch style. The large number of teeth allows very high table feed and extraordinary productivity.
 - wide range of inserts available in E tolerance for high precision machining and M tolerance for general machining
 - 3 types of chipbreakers in CVD and PVD coated carbide grades.
 - Wide range including carbide, full solid PCBN and silicon nitride inserts.
 - Very competitive cost/edge
- Fräser mit feiner und extrafeiner Teilung erhältlich. Die Dichte der Zähne im Fräskörper ermöglicht einen hohen Vorschub bei außergewöhnlicher Produktivität.
 - Präzise Wendeschneidplatten in E- oder M-Toleranz, hochpräzise oder sehr kostengünstige Lösungen erhältlich.
 - 3 verschiedene Spanbrecher, beide kombiniert mit PVD- und CVD-beschichteten Qualitäten.
 - Die Wendeschneidplatten sind auch aus integrealem PCBN und Siliziumnitrid erhältlich.
 - Extrem attraktive Kosten pro Schneidkante.
- Frese disponibili con passo fine ed extra fine. La densità dei denti nel corpo fresa consente elevati avanzamenti con eccezionale produttività.
 - Inserti precisi in tolleranza E o in tolleranza M, disponibili soluzione a elevata precisione o soluzioni altamente economiche.
 - 3 diversi rompitruciolo entrambi combinati con gradi rivestiti PVD e CVD.
 - Inserti disponibili anche in PCBN integrale e nitruro di silicio.
 - Costo per tagliente estremamente competitivo.
- Fraises disponibles en pas fin et extra fin. Le nombre élevé de dents sur le corps de fraise permet des avances élevées avec un rendement exceptionnel.
 - Plaquettes disponibles en tolérance E pour un usinage de haute précision et en tolérance M pour les applications générales
 - 3 brise-copeaux différents combinés à des nuances revêtues PVD et CVD.
 - Plaquettes également disponibles en PCBN intégral et en nitruro de silicium.
 - Coût par arêtes extrêmement compétitif.

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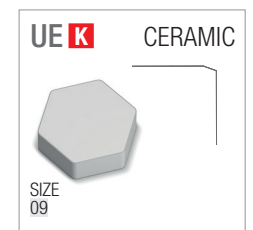
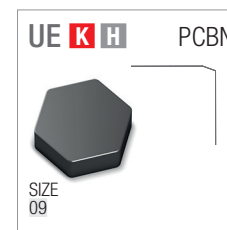
Milling holders

- Shell mill type with shim
 - From D80 to D160
- Attacco a manicotto con sottopiacchetta
 - Da D80 a D160
- Hülsenaufnahme
 - D80 bis D160
- Type mandrin
 - Du D80 à D160



Inserts

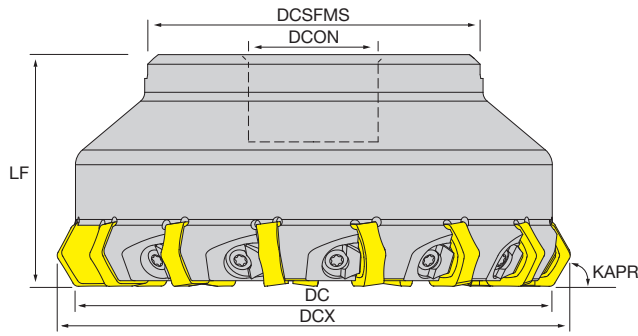
- 12 cutting edges
 - Edge length 09 with APMX = 6 mm
 - CVD and PVD coated carbide grades, full solid PCBN and ceramic
 - Geometries: GL, GG, GH, Advanced
- 12 taglianti
 - Lunghezza del tagliente 09 con APMX = 6 mm
 - Gradi in metallo duro rivestito CVD e PVD, PCBN integrale e ceramica
 - Geometrie: GL, GG, GH, Advanced
- 12 Schneidkanten
 - Länge der Schneidkante 09 mit APMX = 6 mm
 - Hartmetallqualitäten mit PVD- und CVD-Beschichtung, integrales PCBN und Keramik
 - Geometrien: GL, GG, GH, Advanced
- 12 arêtes de coupe
 - Taille de plaquette 09 avec APMX = 6 mm
 - Nuances en carbure revêtues PVD et CVD, PCBN intégral et céramique
 - Géométries : GL, GG, GH, avancées



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	DC	CIC2	DCON	LF	DCSFMS	DCX	WT				Stock
ARBOR MOUNTING											
NT-HN09 D080-F27-Z08	80	8	27	50	60	90	1.28				⊙
NT-HN09 D080-F27-Z10	80	10	27	50	60	90	1.23				●
NT-HN0945 D080-F27-Z10	80	10	27	50	60	92.4	1.3				⊙
NT-HN09 D100-F32-Z10	100	10	32	50	80	110	1.87				●
NT-HN09 D100-F32-Z14	100	14	32	50	80	110	1.8				⊙
NT-HN09 D125-F40-Z12	125	12	40	63	88	135	3.55				●
NT-HN09 D125-F40-Z15	125	15	40	63	88	135	3.33				⊙
NT-HN09 D160-F40-Z15	160	15	40	63	120	170	5.1				⊙
NT-HN09 D160-F40-Z20	160	20	40	63	120	170	4.98				⊙

★ 1st choice, ☆ suitable, ● stock standard, ⊙ non-stock standard (no MOQ), ○ non-stock standard (MOQ), ▲ upcoming product, ▽ stock exhaustion

Spare parts	Wedge	Wedge screw	L wrench
NT-HN09 D○○○-F○○-Z○○	NT-WD090	NT-SC090	NT-WR030

INDEXABLE

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INDEXABLE

A - TURNING

ISO 513	MATERIAL	HARDNESS HB	ae/DC	JG7515			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	

B - THREADING

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%	800	1000	1200	400	600	800	
			30%	1000	1300	1600	550	750	950	
			10%	1200	1600	2000	800	900	1000	

ae: radial depth of cut; DC: milling cutter diameter
Complete workpiece materials p. H1.

C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

DESIGNATION	ae/DC	DEPTH OF CUT			FEED RATE		
		ap (mm)			fz (mm)		
		min	start	max	min	start	max
HN ₀ X090520-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
HN ₀ X090500-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