

# ROUNDPLUS

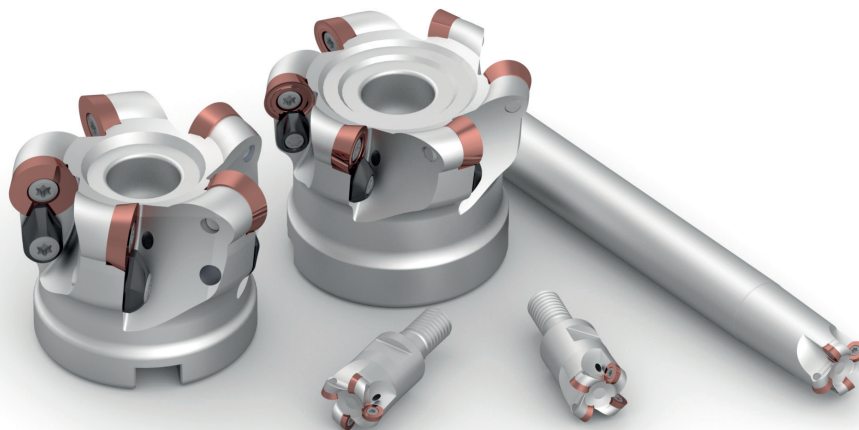
Profiling and face milling system

## Application

- Versatile milling system for profiling and facing applications
  - Suitable for ramping and helical interpolation of pockets
  - Finishing/Semifinishing and Rough face milling
- Schlichtprofilierung oder-fräsen/Schruppschlichtprofilierung oder -fräsen/Schruppprofilierung oder -fräsen
  - Schlichtfräsen/Schruppschlichtfräsen/Schrupppräsen
  - Die Bearbeitung von Rampen und die Ausführung von Taschen ist möglich
- Sistema di fresatura versatile per profilatura e spianatura
  - Adatto alla lavorazione in rampa e all'esecuzione elicodiale di tasche
  - Finitura, semi finitura e sgrossatura
- Système de fraisage polyvalent pour les applications de copiage et surfacage
  - Convient également pour le ramping et l'interpolation hélicoidale
  - Finition, semi-finition et ebauche

## Application range - ISO 513

**P M K S**



## Advantages and features

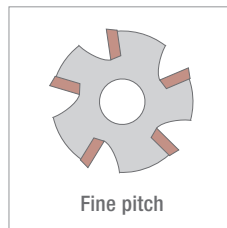
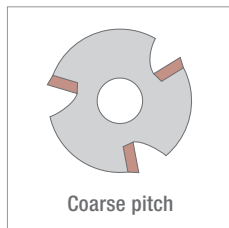
- Comprehensive range of insert geometries for finishing, semi finishing and roughing.
  - Wide range of milling holders from D9 to D160
  - Strong and low cutting force system for stable working and long overhanging application (up to 10xD)
  - Multi-functional tool featuring exceptional machining versatility.
- Wendeplatten mit Geometrien zum Schlichten/Schruppschlichten/Schruppen verfügbar.
  - Verschiedene Fräskörper von D9 bis D160 erhältlich.
  - Niedrige Schnittkräfte bei guter Robustheit, überhängende Bearbeitung möglich (bis zu 10xD).
  - Multifunktionswerkzeug mit guter Flexibilität bei verschiedenen Bearbeitungen.
- Gamma completa di inserti per finitura, semi finitura e sgrossatura.
  - Gamma di corpi fresa disponibili da D9 a D160.
  - Sistema robusto con bassi sforzi di taglio che consente lavorazioni stabili e con grandi sporgenze (fino a 10xD).
  - Utensile multifunzione con buona flessibilità nelle diverse lavorazioni.
- Gamme complète de géométries pour la finition, semi-finition et ébauche
  - Gamme de corps de fraise disponibles du D9 au D160.
  - Faibles efforts de coupe, permet un usinage avec longs porte à faux (jusqu'à 10xD).
  - Outil polyvalent offrant une large gamme d'usinabilité

# ROUNDPLUS

Profiling and face milling system

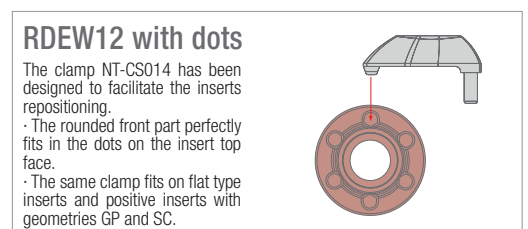
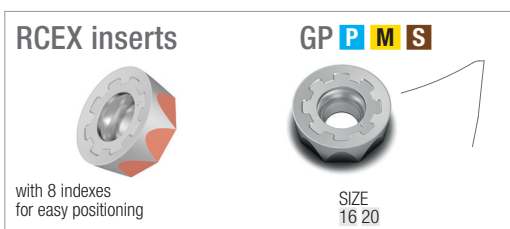
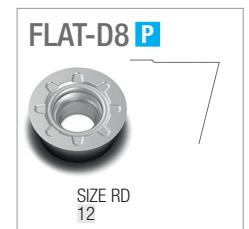
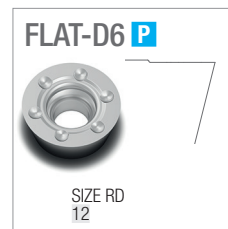
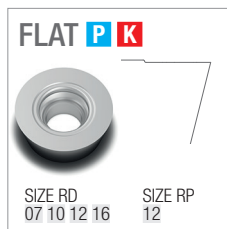
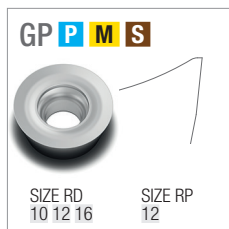
## Cutter bodies

- Shell mill type
  - Cylindrical shank type (up to 10xD)
  - Screw-in type
  - Extension arbors (steel/carbide 10xD)
  - From D9 to D160
- Attacco a manicotto
  - Attacco cilindrico (fino a 10xD)
  - Attacco filettato
  - Prolunghe (acciaio/metallo duro 10xD)
  - Da D9 a D160
- Hülsenaufnahme
  - Aufnahme zylindrisch (bis 10xD)
  - Aufschraubsystem
  - Erweiterungshülsen (Stahl/Hartmetall 10xD)
  - D9 bis D160
- Type mandrin
  - Queue cylindrique (jusqu'à 10xD)
  - Embout vissé
  - Rallonge (acier/carbure 10xD)
  - Du D9 à D160



## Inserts

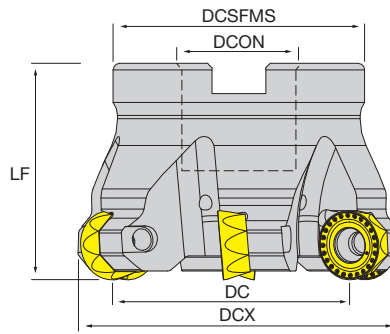
- Multi-edges
  - IC 05 / 07 / 10 / 12 / 16 / 20
  - CVD and PVD coated carbide grades
  - Geometries: SC, GP, Flat
- Multitagliente
  - IC 05 / 07 / 10 / 12 / 16 / 20
  - Gradi in metallo duro rivestito CVD e PVD
  - Geometrie: SC, GP, Flat
- Mehrzahn
  - IC 05 / 07 / 10 / 12 / 16 / 20
  - PVD- und CVD-beschichtete Hartmetallqualitäten
  - Geometrien: SC, GP, Flat
- Arêtes de coupe multiples
  - IC 05 / 07 / 10 / 12 / 16 / 20
  - Nuances carbure revêtues PVD et CVD
  - Géométries : SC, GP, Flat



## NT-RC

### RoundPlus RC index

- Positive general face milling cutters for RC inserts
- All with coolant through
- Very robust milling solution for massive chip removal application



Designation	DCX	CIC2	DC	DCON	LF	DCSFMS	WT	MID			Stock
<b>ARBOR MOUNTING</b>											
NT-RC16H D063-F22-Z05	63	5	47	22	50	45	0.46	RCEX1606			●
NT-RC16H D080-F27-Z06	80	6	54	27	50	58	0.78	RCEX1606			●
NT-RC16H D100-F32-Z06	100	6	84	32	50	70	1.26	RCEX1606			●
NT-RC20H D100-F32-Z06	100	6	80	32	50	70	1.19	RCEX2006			●
NT-RC20H D125-F40-Z07	125	7	105	40	63	90	2.71	RCEX2006			●
NT-RC20H D160-F40-Z08	160	8	140	40	63	100	3.98	RCEX2006			●

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

Spare parts	Insert screw	Flag wrench	T wrench
NT-RC16H D100-000-Z00	NT-ST50110T20	-	NT-TT20
NT-RC16H D000-000-Z00	NT-ST50110T20	NT-FTB20	-
NT-RC20H D000-000-Z00	NT-ST60160T25	-	NT-TT25

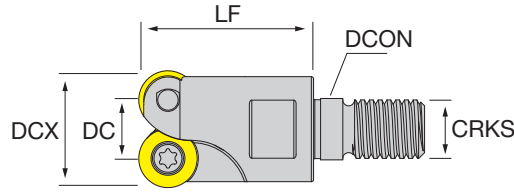


## NT-RD

### RoundPlus RD

- Positive general face milling cutters for RD inserts, with or without coolant through, various options available
- Very convenient multipurpose tool, at small depth of cut could be used as highfeed, at bigger depth of cut is robust with big radii, can also do profiling and copy milling
- Tolerance of tool diameter (with Nikko inserts installed) 0/-0.2
- Steel and carbide arbors available for screw in type holders

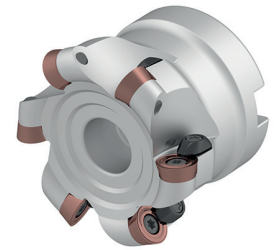
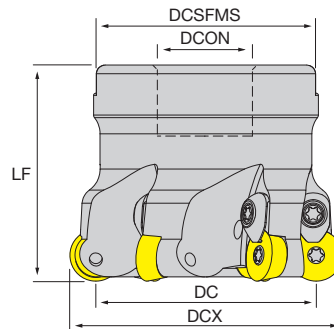
Screw-in



Cylindrical



Arbor



Designation	DCX	CICT	DC	DCON	LF	LU	DCSFMS	CRKS	WT	MIID	Stock
<b>SCREW-IN</b>											
NT-RD05 D012-M06-Z2	12	2	7	6.5	18	-	-	M6	0.01	RDEW0501	▽
NT-RD05 D012-M06-Z3	12	3	7	6.5	18	-	-	M6	0.01	RDEW0501	▽
NT-RD05 D013-M06-Z2	13	2	8	6.5	18	-	-	M6	0.01	RDEW0501	▽
NT-RD05 D013-M06-Z3	13	3	8	6.5	18	-	-	M6	0.01	RDEW0501	▽
NT-RD05 D016-M08-Z4	16	4	11	8.5	23	-	-	M8	0.03	RDEW0501	▽
NT-RD05 D017-M08-Z4	17	4	12	8.5	23	-	-	M8	0.03	RDEW0501	▽
NT-RD07 D016-M08-Z2	16	2	9	8.5	23	-	-	M8	0.03	RDEW0702	▽
NT-RD07H D016-M08-Z03	16	3	9	8.5	23	-	-	M8	0.02	RDEW0702	●
NT-RD07 D017-M08-Z2	17	2	10	8.5	23	-	-	M8	0.03	RDEW0702	▽
NT-RD07 D017-M08-Z3	17	3	10	8.5	23	-	-	M8	0.03	RDEW0702	▽
NT-RD07H D020-M10-Z03	20	3	13	10.5	30	-	-	M10	0.06	RDEW0702	●
NT-RD07 D021-M10-Z2	21	2	14	10.5	30	-	-	M10	0.06	RDEW0702	▽
NT-RD07 D021-M10-Z3	21	3	14	10.5	30	-	-	M10	0.05	RDEW0702	▽
NT-RD07H D025-M12-Z04	25	4	18	12.5	35	-	-	M12	0.09	RDEW0702	●
NT-RD07 D025-M12-Z5	25	5	18	12.5	35	-	-	M12	0.11	RDEW0702	▽
NT-RD07 D026-M12-Z4	26	4	19	12.5	35	-	-	M12	0.1	RDEW0702	▽
NT-RD07 D026-M12-Z5	26	5	19	12.5	35	-	-	M12	0.11	RDEW0702	▽
NT-RD07 D035-M16-Z5	35	5	28	17	43	-	-	M16	0.24	RDEW0702	▽
NT-RD07H D035-M16-Z06	35	6	28	17	43	-	-	M16	0.22	RDEW0702	◎
NT-RD10H D020-M10-Z02	20	2	10	10.5	20	-	-	M10	0.05	RD∞1003	●
NT-RD10H D025-M12-Z03	25	3	15	12.5	35	-	-	M12	0.09	RD∞1003	●
NT-RD10H D026-M12-Z03	26	3	16	12.5	35	-	-	M12	0.09	RD∞1003	●

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

Designation	DCX	CICT	DC	DCON	LF	LU	DCSFMS	CRKS	WT	MHD	Stock
NT-RD10H D030-M12-Z03	30	3	20	12.5	35	-	-	M12	0.11	RD∞1003	●
NT-RD10H D032-M16-Z03	32	3	22	17	43	-	-	M16	0.2	RD∞1003	●
NT-RD10H D032-M16-Z04	32	4	22	17	43	-	-	M16	0.18	RD∞1003	●
NT-RD10H D035-M16-Z03	35	3	25	17	43	-	-	M16	0.22	RD∞1003	○
NT-RD10H D035-M16-Z04	35	4	25	17	43	-	-	M16	0.2	RD∞1003	●
NT-RD10H D040-M16-Z04	40	4	30	17	43	-	-	M16	0.24	RD∞1003	●
NT-RD10H D042-M16-Z05	42	5	32	17	43	-	-	M16	0.21	RD∞1003	◎
<b>CYLINDRICAL SHANK</b>											
NT-RD05 D009-S08-Z2-L100	9	2	4	8	100	12	-	-	0.04	RDEW0501	▽
NT-RD05H D010-S10-Z02	10	2	5	10	100	18	-	-	0.05	RDEW0501	●
NT-RD05 D011-S10-Z2-L100	11	2	6	10	100	15	-	-	0.06	RDEW0501	▽
NT-RD05H D012-S12-Z03	12	3	7	12	100	22	-	-	0.07	RDEW0501	●
NT-RD05 D013-S12-Z3-L100	13	3	8	12	100	18	-	-	0.08	RDEW0501	▽
NT-RD05H D016-S16-Z04	16	4	11	16	150	30	-	-	0.21	RDEW0501	●
NT-RD07H D016-S16-Z02	16	2	9	16	150	25	-	-	0.21	RDEW0702	●
NT-RD07H D017-S16-Z02	17	2	10	16	150	20	-	-	0.2	RDEW0702	●
NT-RD07H D020-S20-Z03	20	3	13	20	150	35	-	-	0.33	RDEW0702	●
NT-RD07 D021-S20-Z3-L150	21	3	14	20	150	25	-	-	0.35	RDEW0702	▽
NT-RD07H D025-S25-Z05	25	5	18	25	150	40	-	-	0.51	RDEW0702	●
NT-RD07 D026-S25-Z5-L150	26	5	19	25	150	25	-	-	0.55	RDEW0702	▽
NT-RD07 D035-S32-Z6-L150	35	6	28	32	150	30	-	-	0.92	RDEW0702	▽
NT-RD10H D020-S20-Z02	20	2	10	20	150	40	-	-	0.32	RD∞1003	●
NT-RD10H D021-S20-Z02	21	2	11	20	150	25	-	-	0.34	RD∞1003	○
NT-RD10H D025-S25-Z03	25	3	15	25	150	40	-	-	0.5	RD∞1003	●
NT-RD10H D026-S25-Z03	26	3	16	25	150	25	-	-	0.52	RD∞1003	●
NT-RD10H D030-S25-Z03	30	3	20	25	150	25	-	-	0.53	RD∞1003	●
NT-RD10H D032-S32-Z03	32	3	22	32	150	40	-	-	0.82	RD∞1003	●
NT-RD10H D035-S32-Z04	35	4	25	32	150	35	-	-	0.85	RD∞1003	◎
<b>ARBOR MOUNTING</b>											
NT-RD10H D042-F16-Z05	42	5	32	16	40	-	35	-	0.2	RD∞1003	●
NT-RD10H D052-F22-Z06	52	6	42	22	40	-	46	-	0.33	RD∞1003	●
NT-RD12H D040-F16-Z04	40	4	28	16	50	-	38	-	0.22	RD∞1204	○
NT-RD12H D042-F16-Z04	42	4	30	16	50	-	38	-	0.25	RD∞1204	●
NT-RD12H D050-F22-Z04	50	4	38	22	50	-	46	-	0.35	RD∞1204	●
NT-RD12H D050-F22-Z05	50	5	38	22	50	-	46	-	0.37	RD∞1204	●
NT-RD12H D052-F22-Z04	52	4	40	22	50	-	46	-	0.4	RD∞1204	◎
NT-RD12H D052-F22-Z05	52	5	40	22	50	-	46	-	0.42	RD∞1204	●
NT-RD12H D063-F22-Z05	63	5	51	22	50	-	52	-	0.56	RD∞1204	●
NT-RD12H D063-F22-Z06	63	6	51	22	50	-	52	-	0.58	RD∞1204	●
NT-RD12H D066-F22-Z06	66	6	54	22	50	-	56	-	0.71	RD∞1204	●
NT-RD12H D080-F27-Z07	80	7	68	27	50	-	60	-	0.93	RD∞1204	●
NT-RD16H D063-F22-Z05	63	5	47	22	50	-	52	-	0.5	RD∞1604	◎
NT-RD16 D066-F22-Z5	66	5	50	22	50	-	56	-	0.62	RD∞1604	●
NT-RD16H D066-F27-Z05	66	5	50	27	50	-	56	-	0.56	RD∞1604	▲
NT-RD16H D080-F27-Z05	80	5	64	27	50	-	60	-	0.85	RD∞1604	●
NT-RD16H D080-F27-Z06	80	6	64	27	50	-	60	-	0.87	RD∞1604	●
NT-RD16H D100-F32-Z07	100	7	84	32	50	-	70	-	1.22	RD∞1604	●
NT-RD16H D125-F40-Z08	125	8	109	40	63	-	90	-	2.5	RD∞1604	●

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

INDEXABLE

A - TURNING

B - THREADING




C - GROOVING

D - MILLING

E - DRILLING

F - ACCESSORIES

G - SPARE PARTS

Spare parts	Insert screw 	Flag wrench 	Clamping set 
<b>NT-RD05<sub>0</sub> DCX ≤ 10</b>	NT-ST20033T06	NT-FTB06	-
<b>NT-RD05<sub>0</sub> DCX ≥ 11</b>	NT-ST20040T06	NT-FTB06	-
<b>NT-RD07<sub>0</sub> D<sub>000-000</sub>-Z<sub>00</sub></b>	NT-ST25056T08HQ	NT-FTB08	-
<b>NT-RD10<sub>0</sub> DCX = 30</b>	NT-ST35095T15HQ	NT-FTB15	-
<b>NT-RD10<sub>0</sub> DCX ≤ 26</b>	NT-ST35070T15	NT-FTB15	-
<b>NT-RD10<sub>0</sub> DCX ≥ 32</b>	NT-ST35095T15HQ	NT-FTB15	NT-CS013
<b>NT-RD12H D<sub>000-000</sub>-Z<sub>00</sub></b>	NT-ST40110T15HQ	NT-FTB15	NT-CS014
<b>NT-RD16 D<sub>000-000</sub>-Z<sub>00</sub></b>	NT-ST45110T20	-	NT-CS021
<b>NT-RD16H D<sub>000-000</sub>-Z<sub>00</sub></b>	NT-ST45110T20	-	NT-CS021

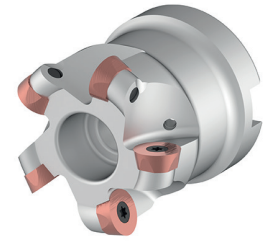
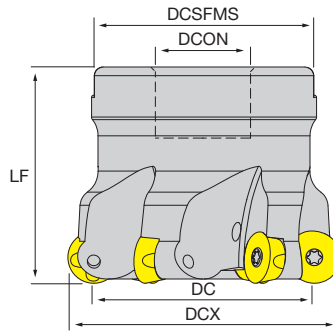




## NT-RPX

### RoundPlus RP index

- Positive general face milling cutters for RP inserts
- All with coolant through
- High clearance angle useful for M and S material roughing



Designation	DCX	CICT	DC	DCON	LF	DCSFMS	WT	MIID			Stock
<b>ARBOR MOUNTING</b>											
NT-RPX12H D042-F16-Z04	42	4	30	16	50	38	0.26	RP∞1204			●
NT-RPX12H D050-F22-Z05	50	5	38	22	50	46	0.4	RP∞1204			●
NT-RPX12H D052-F22-Z05	52	5	40	22	50	46	0.4	RP∞1204			●
NT-RPX12H D063-F22-Z06	63	6	51	22	50	52	0.59	RP∞1204			●
NT-RPX12H D066-F22-Z06	66	6	54	22	50	56	0.73	RP∞1204			●
NT-RPX12H D080-F27-Z07	80	7	68	27	50	60	0.94	RP∞1204			●

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

Spare parts	Insert screw	Flag wrench
NT-RPX12H D∞∞-F∞∞-Z∞∞	NT-ST40110T15HQ	NT-FTB15

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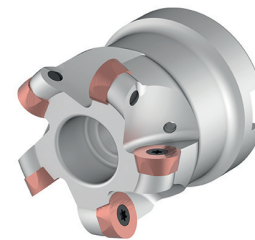
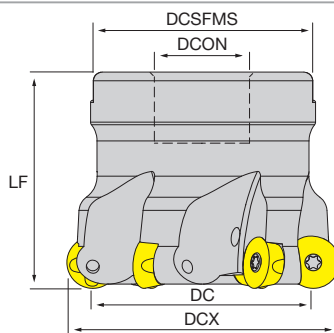
G - SPARE PARTS



## NT-RP

### RoundPlus RP

- Positive general face milling cutters for RP inserts
- All with coolant through
- High clearance angle useful for M and S material roughing



Designation	DCX	CICT	DC	DCON	LF	DCSFMS	WT	MID			Stock
<b>ARBOR MOUNTING</b>											
NT-RP12H D042-F16-Z04	42	4	30	16	50	38	0.26	RP∞1204			○
NT-RP12H D050-F22-Z05	50	5	38	22	50	46	0.4	RP∞1204			●
NT-RP12H D052-F22-Z05	52	5	40	22	50	46	0.4	RP∞1204			●
NT-RP12H D063-F22-Z06	63	6	51	22	50	52	0.59	RP∞1204			●
NT-RP12H D066-F22-Z06	66	6	54	22	50	56	0.73	RP∞1204			⊙
NT-RP12H D080-F27-Z07	80	7	68	27	50	60	0.94	RP∞1204			⊙

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

Spare parts	Insert screw	Flag wrench	Clamping set
NT-RP12H D <del>000</del> -F <del>00</del> -Z <del>00</del>	NT-ST40110T15HQ	NT-FTB15	NT-CS013

INDEXABLE

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ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP5530			JP8725			JU4225		
				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%	100	140	180	100	150	200	130	180	230
			30%	160	200	240	160	210	260	200	240	280
			10%	220	240	260	220	250	280	260	280	300
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	100%	80	120	160	90	130	170	120	150	180
			30%	120	160	200	130	170	210	180	210	240
			10%	180	200	220	190	210	230	230	250	270
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	100%	60	90	120	80	110	140	90	120	150
			30%	100	130	160	120	150	180	150	180	210
			10%	140	170	200	160	190	220	190	220	250
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC9540			JP5530			JP9535		
min	start	max	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	60	100	140	80	120	160
			30%	110	160	210	80	130	180	100	150	200
			10%	130	190	250	100	160	220	120	180	240
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	100%	70	100	130				60	90	120
			30%	80	110	140				70	100	130
			10%	90	120	150				80	110	140
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	100%	90	120	150	60	90	120	80	110	140
			30%	110	150	190	80	120	160	100	140	180
			10%	130	170	210	100	140	180	120	160	200
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		100%	80	110	140				70	100	130
			30%	90	120	150				80	110	140
			10%	100	130	160				90	120	150
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP7525								
min	start	max										
K1	Grey cast iron (ex. 0.6025/GG 25/EN-GJL-250)	150 ÷ 250	100%	140	180	220						
			30%	160	210	260						
			10%	180	240	300						
K2	Nodular cast iron (ex. 0.7050/GGG 50/EN-GJS-500-7)	150 ÷ 350	100%	100	140	180						
			30%	120	170	220						
			10%	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%	90	120	150						
			30%	120	150	180						
			10%	150	180	210						
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JC9540			JP9535					
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			
			30%	40	50	60	30	40	50			
			10%	50	60	70	40	50	60			
S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		100%				40	50	60			
			30%				50	60	70			
			10%				60	70	80			

ae: radial depth of cut; DC: milling cutter diameter  
Complete workpiece materials p. M1.

INDEXABLE

A - TURNING

B - THREADING

C - GROOVING

D - MILLING

E - DRILLING

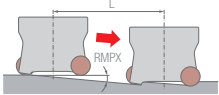
F - ACCESSORIES

G - SPARE PARTS

DESIGNATION	ae/DCX	DEPTH OF CUT			FEED RATE		
		ap (mm)			fz (mm)		
		min	start	max	min	start	max
IC=10 GP chipbreaker	100%	0.50	<b>1.50</b>	2.50	0.10	<b>0.18</b>	0.26
	30%	1.00	<b>3.00</b>	5.00	0.12	<b>0.21</b>	0.30
	10%	1.00	<b>3.00</b>	5.00	0.16	<b>0.28</b>	0.40
IC=12 GP and TB chipbreaker	100%	1.00	<b>2.00</b>	3.00	0.12	<b>0.23</b>	0.34
	30%	1.00	<b>3.50</b>	6.00	0.16	<b>0.28</b>	0.40
	10%	1.00	<b>3.50</b>	6.00	0.20	<b>0.35</b>	0.50
IC=16 GP chipbreaker	100%	1.00	<b>2.50</b>	4.00	0.16	<b>0.28</b>	0.40
	30%	1.00	<b>4.50</b>	8.00	0.20	<b>0.33</b>	0.46
	10%	1.00	<b>4.50</b>	8.00	0.24	<b>0.42</b>	0.60
IC=20 GP chipbreaker	100%	1.00	<b>3.00</b>	5.00	0.18	<b>0.33</b>	0.48
	30%	1.00	<b>5.50</b>	10.00	0.22	<b>0.40</b>	0.58
	10%	1.00	<b>5.50</b>	10.00	0.30	<b>0.50</b>	0.70
IC=12 SC chipbreaker	100%	1.00	<b>2.00</b>	3.00	0.12	<b>0.20</b>	0.28
	30%	1.00	<b>3.50</b>	6.00	0.14	<b>0.24</b>	0.34
	10%	1.00	<b>3.50</b>	6.00	0.16	<b>0.28</b>	0.40
IC=16 SC chipbreaker	100%	1.00	<b>2.50</b>	4.00	0.14	<b>0.25</b>	0.36
	30%	1.00	<b>4.50</b>	8.00	0.18	<b>0.30</b>	0.42
	10%	1.00	<b>4.50</b>	8.00	0.22	<b>0.35</b>	0.48

DESIGNATION	ae/DCX	DEPTH OF CUT			FEED RATE		
		ap (mm)			fz (mm)		
		min	start	max	min	start	max
IC=05 Flat (MOE)	100%	0.25	<b>0.75</b>	1.25	0.04	<b>0.06</b>	0.08
	30%	0.50	<b>1.50</b>	2.50	0.06	<b>0.08</b>	0.10
	10%	0.50	<b>1.50</b>	2.50	0.08	<b>0.10</b>	0.12
IC=07 Flat (MOE, MOT)	100%	0.25	<b>1.00</b>	1.75	0.08	<b>0.12</b>	0.16
	30%	0.50	<b>2.00</b>	3.50	0.10	<b>0.15</b>	0.20
	10%	0.50	<b>2.00</b>	3.50	0.12	<b>0.18</b>	0.24
IC=10 Flat (MOT)	100%	0.50	<b>1.50</b>	2.50	0.12	<b>0.20</b>	0.28
	30%	1.00	<b>3.00</b>	5.00	0.15	<b>0.25</b>	0.35
	10%	1.00	<b>3.00</b>	5.00	0.18	<b>0.30</b>	0.42
IC=12 Flat (MOT)	100%	1.00	<b>2.00</b>	3.00	0.16	<b>0.27</b>	0.38
	30%	1.00	<b>3.50</b>	6.00	0.20	<b>0.34</b>	0.48
	10%	1.00	<b>3.50</b>	6.00	0.24	<b>0.40</b>	0.56
IC=16 Flat (MOT)	100%	1.00	<b>2.50</b>	4.00	0.19	<b>0.32</b>	0.45
	30%	1.00	<b>4.50</b>	8.00	0.24	<b>0.40</b>	0.56
	10%	1.00	<b>4.50</b>	8.00	0.28	<b>0.47</b>	0.66

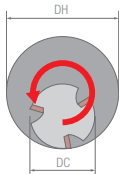
## Parameters for ramping



	NT-RD05H			NT-RD07H			NT-RD10H		
	DCX	RMPX	L	DCX	RMPX	L	DCX	RMPX	L
	10	6.2°	2.1	16	4.7°	2.6	20	9.4°	6.6
	12	4.4°	1.8	17	4.1°	2.4	21	6.6°	4.8
	13	3.6°	1.6	20	3.3°	2.2	25	4.4°	3.9
	16	2.0°	1.0	25	2.3°	2.0	26	4.3°	3.9
	17	2.0°	1.0	35	2.0°	1.0	30	3.2°	3.4
							32	1.2°	1.5
							35	1.0°	1.4
							40	0.9°	1.4
							42	0.8°	1.3
							52	0.6°	0.9

RMPX: max. ramping angle; L: max. ramping path

## Parameters for helical milling



	NT-RD05H			NT-RD07H			NT-RD10H		
	DCX	DH min.	DH max.	DCX	DH min.	DH max.	DCX	DH min.	DH max.
	10	12	18	16	24	30	20	22	38
	12	16	22	17	26	32	21	24	40
	13	18	24	20	32	38	25	32	48
	16	24	30	25	42	48	26	34	50
	17	26	32	35	62	68	30	42	58
							32	46	62
							35	52	68
							40	62	78
							42	66	82
							52	86	102

DH min.: min. cutting dia.; DH max.: max. cutting dia.