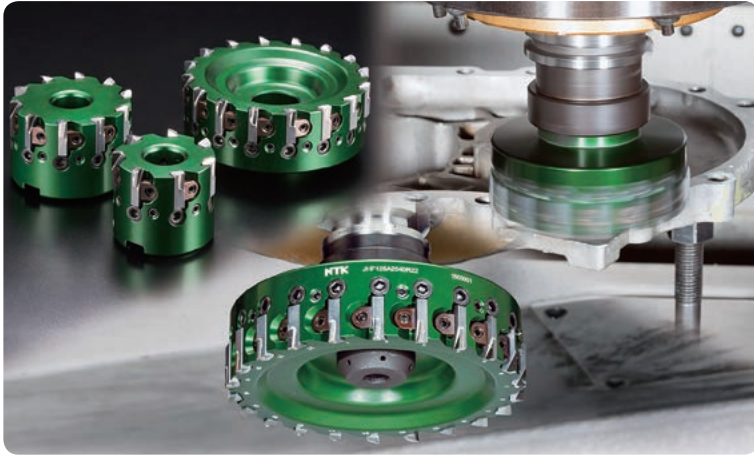


HFC series Adjustable type



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




	Item Number	Stock		Weight	Dimensions								Max RPM	Arbor style	Arbor bolt	Recommended tightening torque			
					ϕD		h		ϕd		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

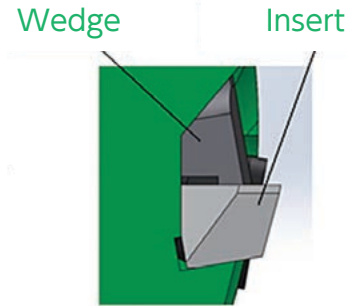
Insert

	Item Number	PCD	Corner angle	Max DOC		A.R.	r_ϵ		Wiper
				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



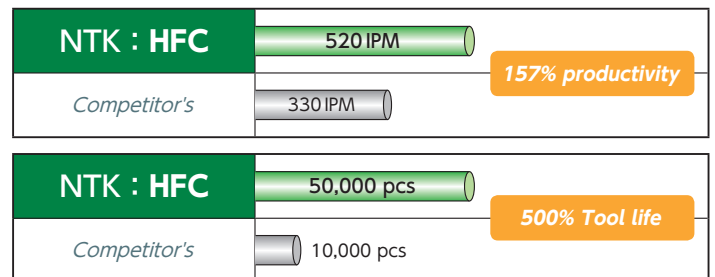
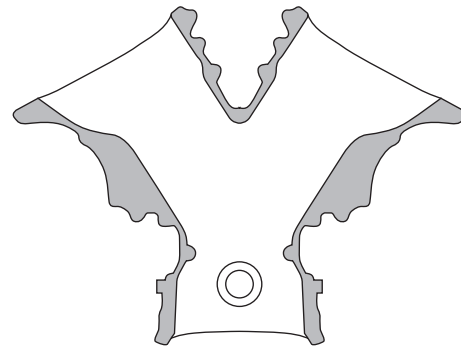
● Unique sphenoidal pocket prevents inserts from becoming dislodged

● 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



● 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	○	●																		

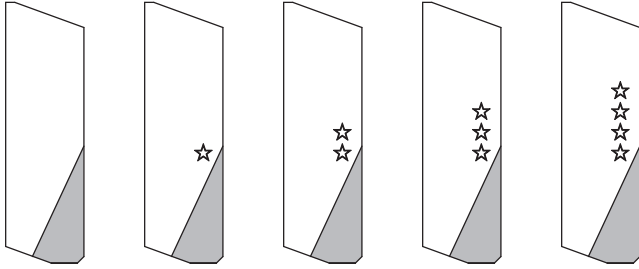
Rotating Tools

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



±.002mm height run out
(±.00008")

Re-balancing



Balance grade: G 2.5