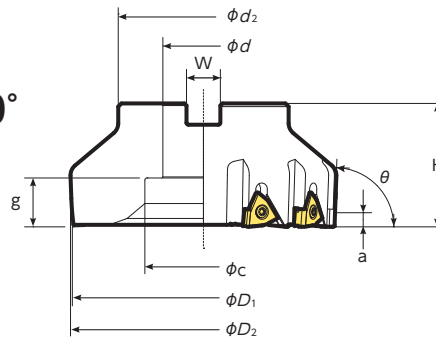
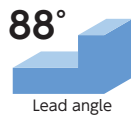


A. R. +5°
R. R. +4°, +7°, +10°



JWNXM type milling body

θ	Code No.	Part number	Stock	No of inserts	Dimensions (mm)										Weight (kg)	Rake angle (°)		Centering location type	
					φD ₁	φD ₂	H	a※1	a※2	φd ₁	W	φd ₂	φc	g		A.R.	R.R.		
88°	QUE002327	JWNXM063-88-06R-GM	●	6	63	63	50	5.5	4.5	22	10.4	60	18	15.5	0.9	+5	+4	FMC	
	QUE002823	JWNXM080-88-08R-GM	●	8	80	80				27	12.4		36	15			1.1		+7
	QUE002749	JWNXM100-88-10R-GM	●	10	100	100				32	14.4	80	50	18	1.8		+10		FMA
		JWNXM125-88-12R-GM	●	12	125	125				40	16.4		55	23	3				
		JWNXM160-88-16R-GM	●	16	160	160				60	40	16.4	100	72	22				

※1 Dimension when set the insert [WNX44-C10T01020]
※2 Dimension when set the insert [WNX44-R12T01020]

Parts	
Clamping Screw FSI 26-4.0×12-LH 5861935 Sales quantity 10pcs/case	Wrench LLR-T15 5701909 Sales quantity 5pcs/case

Insert

Shape	Dimensions (mm)	Part number	C or r _ε	Grade	
		WNX44-C10T01020	C1.0	SX6	●
				SP9	●
		WNX44-R12T01020	R1.2	SX6	●
				SP9	●

● : New standard stock items

Recommended cutting conditions

Grade	Work material	Cutting speed (m/min)												Feed (mm/t)					Depth of cut (mm)
		400	500	600	700	800	900	1000	1100	1200	1300	1400	0.05	0.1	0.15	0.2	0.25	0.3	
SX6	Gray cast iron	[Red bar with vertical lines]												[Red bar with vertical lines]					~ 6 (mm)
		[Blue bar with vertical lines]												[Blue bar with vertical lines]					
SP9	Ductile cast iron	[Red bar with vertical lines]												[Red bar with vertical lines]					

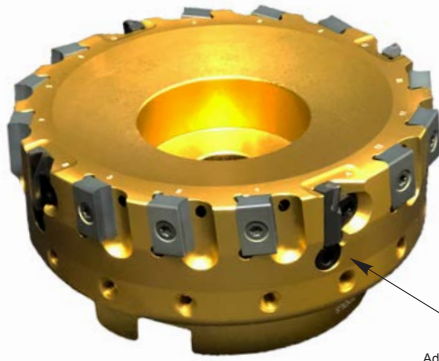
Case study

Transmission case			● Work material : FC23		
	current tool		NTK		
Holder	Competitor		JWNXM125A3810R12		
Insert	Ceramic insert		SX6 WNX44-R12T01020		
Cutting speed	(m/min)	500	←		
Feed per tooth	(mm/t)	0.13	←		
Depth of cut	(mm)	1	←		
Coolant		DRY	←		
Tool life	(pcs/coner)	60	120		

As for competitor's milling cutter, we needed to change inserts to new ones due to the wearprogress and lower clamping force of work material after machining 60 pcs. This was caused by increasing Cutting force. NTK NEW Milling cutter "FU-HA MILL" achieved 2 times longer competitor's. Low cutting force avoided the problem occurred by competitor's milling cutter.

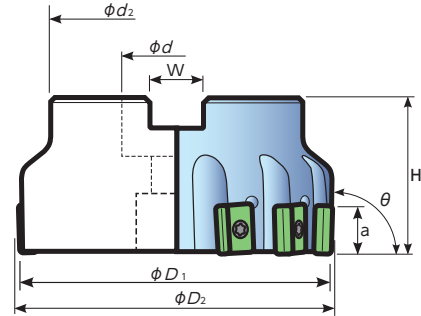
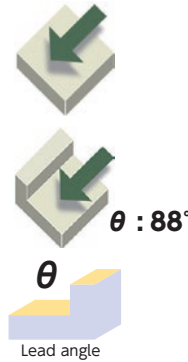
NEW

HMC Cutter





Adjustable HFT-Insert




A.R. -4°
R.R. 0°



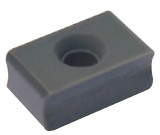
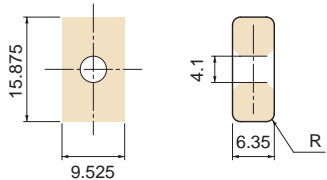
θ	Item No.	Reference	Standard	Standard	Dimensions(mm)								Weight (kg)	
					ϕD_1	ϕD_2	H	a	ϕd	W	ϕd_2	ϕc		g
88°	QEU003684	HMC063-88-06/2-GM	●	6/2	63	66	50	14	22	10,4	58			0,76
	QEU003685	HMC080-88-08/2-GM	●	8/2	80	83	50	14	27	12,4	58			0,96
	QEU003686	HMC100-88-10/3-GM	●	10/3	100	103	50	14	32	14,7	77			1,47
	QEU003513	HMC125-88-12/4-GM	●	12/4	125	128	58	14	40	16,4	77			1,92

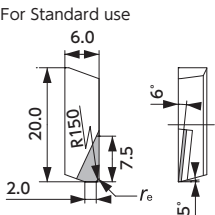
Spare parts

Parts LNX-Inserts	
Clamping screw 	Wrench 
LRIS-4 * 12 QEU000791 10pcs/case	LLR-25S 5364930 1pcs/case

Parts HFT-Inserts				
Wedge	Axial set screw		Wedge set screw	
	Screw	Screwdriver	Screw	Screwdriver
HLW179 	CS0510A 	LW-4	WS0512 	LW-2.5

Applicable inserts

Shape	Dimensions	Part No.	R	Grade
		LNX 324-08 FNX08 (For Aluminum) LNX 324-08 T00520 (For Cast Iron)	0.8	SX6 ●

Wiper	Shape	Item Number	Corner angle	Max DOC (mm)		A.R.	r_e (mm)	PCD / CBN	
				AL	GG			PD1	B30
Yes (Rounded)		HFT 802006 C05	90°	7.5	0.5	6°	C0.5	●	●
Yes (Rounded)		HFT 802006 R04	90°	7.5	0.5	6°	R0.4	●	●

● : Standard
● : Coming Soon

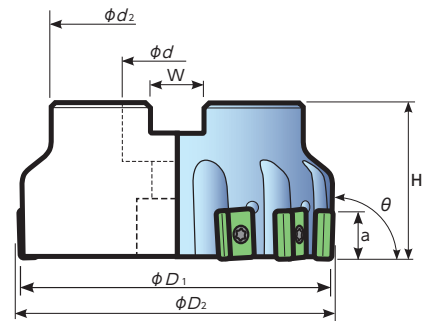
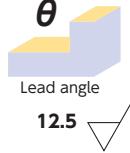
XTM Cutter



A.R.-4°
R.R.0°



$\theta : 88^\circ$



θ	Item No.	Reference	Standard		Dimensions(mm)								Weight (kg)	
					ϕD_1	ϕD_2	H	a	ϕd	W	ϕd_2	ϕc		g
88°	QEU000471	XTM080-88-10R-GM	●	10	80	83	50	14	27	12,4	58			1.1
	QEU000473	XTM100-88-13R-GM	●	13	100	103	50	14	32	14,7	77			1.8
	QEU000475	XTM125-88-16R-GM	●	16	125	128	58	14	40	16,4	77			3.1

Parts	
Clamping screw	Wrench
LRIS-4 * 12 QEU000791	LLR-25S 5364930
10pcs/case	1pcs/case

Screwdrivers (Optional)		
HLR-25S 5485214	XX2815-04 5485172	XX2815-04-25S 5485255
1pc/case	1pc/case	1pc/case

Applicable inserts

Shape	Dimensions	Part No.	R	Grade
		LNX 324-08T01020	0.8	SX6 ●
				SX9 ●
		LNX 324-12T01020	1.2	SX6 ●
				SX9 ●
		LNX 324-16T01020	1.6	SX6 ●
				SX9 ●

● : Standard

Recommended cutting conditions															
Grade	Work material	Cutting speed (m/min)								Feed rate (mm/tooth)					Depth of cut (mm)
		400	500	600	700	800	900	1000	1100	0.05	0.1	0.15	0.2	0.25	
SX6	Normal cast iron														~ 8 (mm)
SX9	Ductile cast iron														