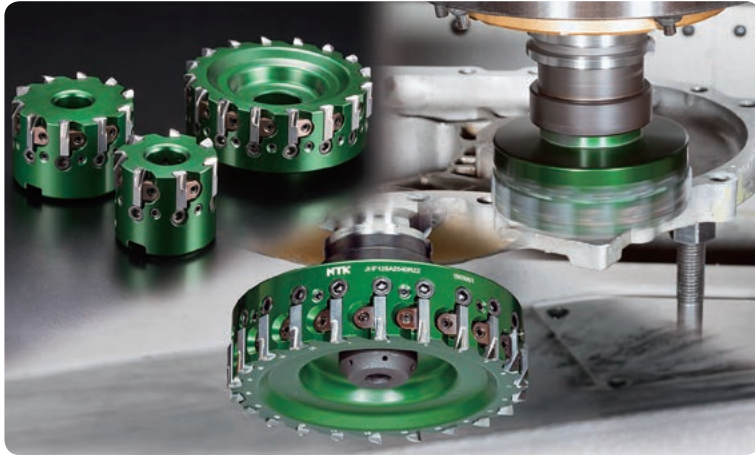


## HFC series Adjustable type



### 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 set up service is available**

### ● Cutter




Item Number	Stock	✳	Weight (kg)	Dimensions (mm)					Max RPM	Arbor style	Arbor bolt	Recommended tightening torque
				$\phi D$	$h$	$\phi d$	$b$	$a$				N · m
JHF050C2200R07	●	7	0.23	50	45	22.0	10.4	6.3	20,000	FMC22	CS1040A	20
JHF063C2200R10	●	10	0.38	63	45	22.0	10.4	6.3	20,000	FMC22	CS1040A	20
JHF080A2540R12	●	12	0.48	80	45	25.4	9.5	6.0	18,000	FMA25.4	MBC-M12	40
JHF100A2540R16	●	16	0.74	100	45	25.4	9.5	6.0	18,000	FMA25.4	MBC-M12	40
JHF125A2540R22	●	22	1.10	125	45	25.4	9.5	6.0	15,000	FMA25.4	MBC-M12	40

\* Includes inserts and parts

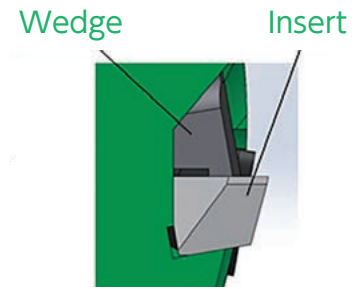
### ● Insert

Wiper	Shape	Item Number	Corner angle	Max DOC (mm)	A.R.	$r_e$ (mm)	PCD
							PD1
Yes (Rounded)	For Standard use 	HFT 802006 C05	90°	7.5	6°	C0.5	●
Yes (Rounded)		HFT 802006 R04	90°	7.5	6°	R0.4	●
Yes (Straight)	For less tool pressure 	HFT 702010 W05	90°	6.5	10°	Double chamfer	●

## ● 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



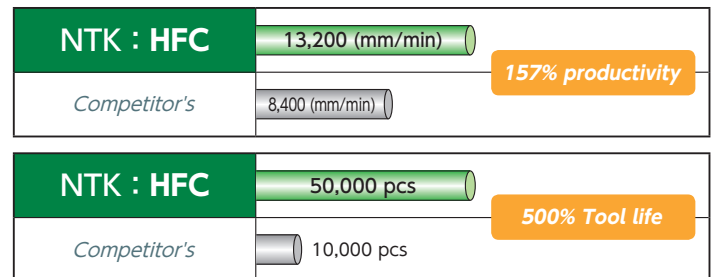
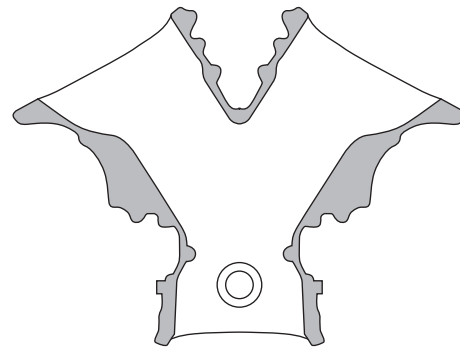
● Unique sphenoidal pocket prevents inserts from becoming dislodged

## ● Field Result

Part : Chain Cover  
Material : ADC12

Cutter : JHF125A2540R22  
Insert : HFT802006C05 PD1

	NTK	Competitor's
Number of edges	22	14
n (min-1)	10,000	←
Vc (m/min)	3,925	←
Vf (mm/min)	13,200	8,400
f (mm/t)	0.06	←
DOC (mm)	2.8 (1 Pass)	2.0 + 0.8 (2 Passes)
Tool life	50,000pcs	10,000pcs



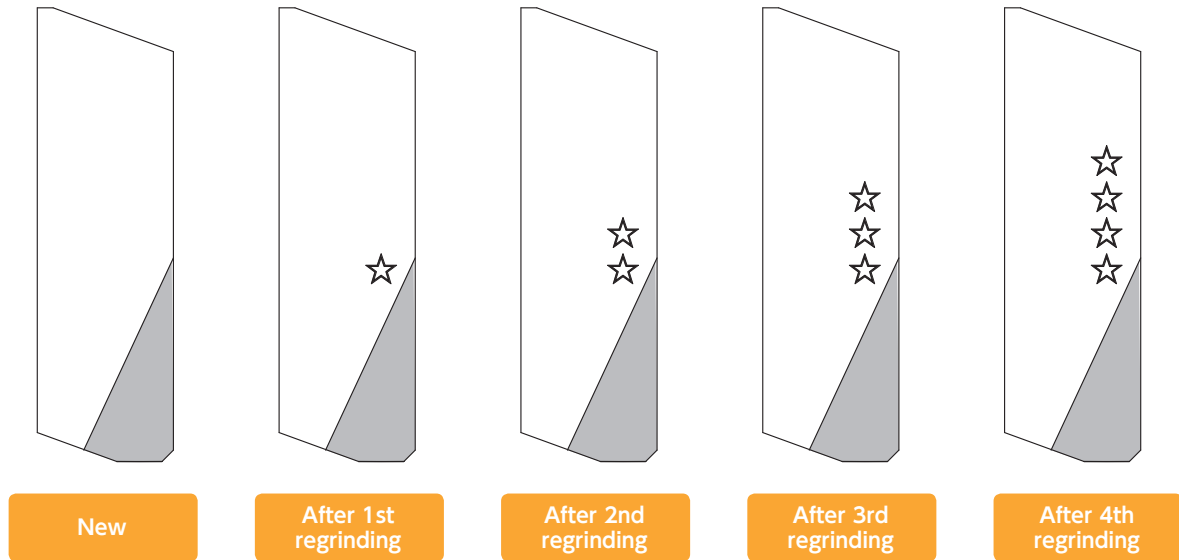
## ● Recommend Cutting Conditions

Work Material	Grade	Dry	Wet	Cutting Speed (m/min)										Feed (mm/t)					Depth of Cut (mm)									
				300	900	1500	2100	2700	3300	3900	4500	5100	5700	0.05	0.1	0.15	0.2	0.25		0.3								
N	PD1	○	●																									~ 6.35
Aluminum Alloy (Si ≤ 13)																												
Aluminum Alloy (Si ≥ 13)	PD1	○	●																									~ 6.35

## NTK Regrind Program

- Inserts can be reground up to (4\*) times
  - The cutter's diameter and height of the insert will change by 0.1mm 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.



## 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**

### Re-balancing



**Balance grade: G 2.5**