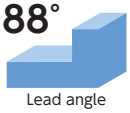
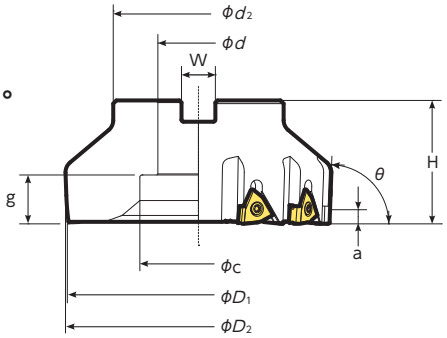
A. R. +5°
R. R. +4°, +7°, +10°

88°





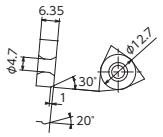
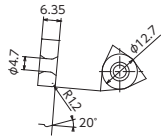
JWNXM type milling body

θ	Code No.	Part number	Stock	No. of inserts	Dimensions (mm)										Weight (kg)	Rake angle (°)		Centering location type
					ϕD1	ϕD2	H	a※1	a※2	ϕd1	W	ϕd2	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	FMA
	QUE002749	JWNXM100-88-10R-GM	●	10	100	100				32	14,4	80	50	18	1.8		+10	
		JWNXM125-88-12R-GM	●	12	125	125	58			40	16,4		55	23	3			
		JWNXM160-88-16R-GM	●	16	160	160	60			40	16,4	100	72	22	4.9			

※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

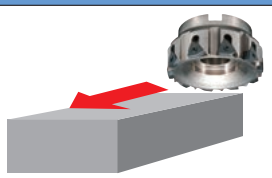
Shape	Dimensions (mm)	Part number	C or r_ε	Grade	
		WNX44-C10T01020	C1.0	SX6	●
				SP9	●
		WNX44-R12T01020	R1.2	SX6	●
				SP9	●

● : New standard stock items

Recommended cutting conditions

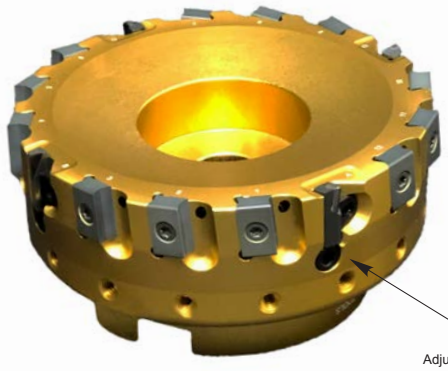
Grade	Work material	Cutting speed (m/min)	Feed (mm/t)	Depth of cut (mm)
	K	400 500 600 700 800 900 1000 1100 1200 1300 1400	0.05 0.1 0.15 0.2 0.25 0.3	
SX6	Gray cast iron			~6 (mm)
SP9	Ductile cast iron			

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 pertooth (mm/t)	0.13	←	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.
Depth of cut (mm)	1	←	
Coolant	DRY	←	
Tool life (pcs/coner)	60	120	

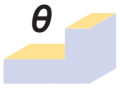
NEW

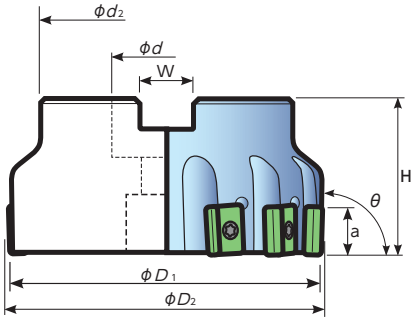
HMC Cutter



A.R.-4°
R.R.0°

θ : 88°





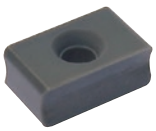
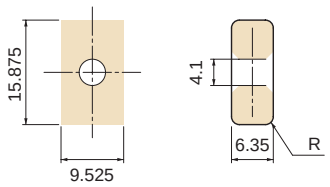
θ	Item No.	Reference	Standard		Dimensions(mm)									Weight (kg)
					ϕD1	ϕD2	H	a	ϕd	W	ϕd2	ϕc	g	
88°	QEU003684	HMC063-88-06/2-GM	●	6/2	63	66	50	14	22	10,4	58			0,76
	QEU003685	HMC080-88-08/2-GM	●	8/2	80	83	50	14	27	12,4	58			0,96
	QEU003686	HMC100-88-10/3-GM	●	10/3	100	103	50	14	32	14,7	77			1,47
	QEU003513	HMC125-88-12/4-GM	●	12/4	125	128	58	14	40	16,4	77			1,92

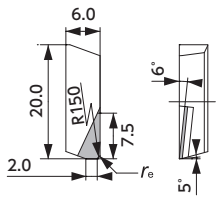
Spare parts

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** ●

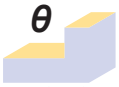
Wiper	Shape	Item Number	Corner angle	Max DOC (mm)		A.R.	r_ε (mm)	PCD / CBN	
				AL	GG			PD1	B30
Yes (Rounded)	For Standard use 	**HFT 802006 C05**	90°	7.5	0,5	6°	C0.5	●	●
Yes (Rounded)		**HFT 802006 R04**	90°	7.5	0,5	6°	R0.4	●	●

● : Standard
● : Coming Soon

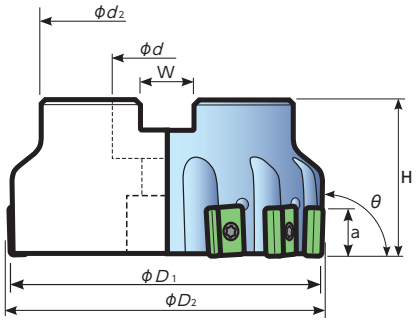
XTM Cutter

A.R.−4°
R.R.0°

θ : 88°



12.5

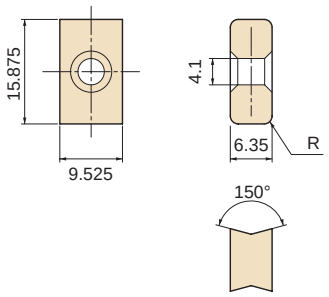


θ	Item No.	Reference	Standard		Dimensions(mm)									Weight (kg)
					ϕD1	ϕD2	H	a	ϕd	W	ϕd2	ϕc	g	
88°	QEU000471	**XTM080-88-10R-GM**	●	10	80	83	50	14	27	12,4	58			1.1
	QEU000473	**XTM100-88-13R-GM**	●	13	100	103	50	14	32	14,7	77			1.8
	QEU000475	**XTM125-88-16R-GM**	●	16	125	128	58	14	40	16,4	77			3.1

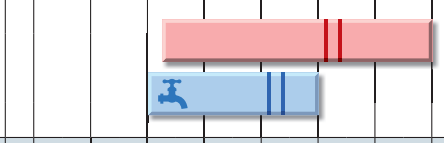
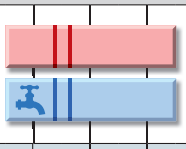
Parts	
Clamping screw	Wrench
	
LRIS-4＊12 **QEU000791** 10pcs/case	LLR-25S **5364930** 1pcs/case

Screwdrivers (Optional)		
		
HLR-25S **5485214** 1pc/case	XX2815-04 **5485172** 1pc/case	XX2815-04-25S **5485255** 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)
	K	400 500 600 700 800 900 1000 1100	0.05 0.1 0.15 0.2 0.25 0.3	
SX6	Normal cast iron			～8 (mm)
SX9	Ductile cast iron