

# NTK

## HFC - High Feed Cutter - for Aluminum Milling

ver.2



App for iOS



App for ANDROID



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# HFC -High Feed Cutter-



Item number	Cutter diameter			Weight includes inserts/parts		Max RPM	Stock
	Inch	mm		lbs	kg		
<b>JHF050C2200R07</b>	1.969	φ50	7	0.5	0.23	20,000	●
<b>JHF063C2200R10</b>	2.480	φ63	10	0.8	0.38	20,000	●
<b>JHF080A2540R12</b>	3.150	φ80	12	1.1	0.48	18,000	●
<b>JHF100A2540R16</b>	3.937	φ100	16	1.6	0.74	18,000	●
<b>JHF125A2540R22</b>	4.921	φ125	22	2.4	1.10	15,000	●

## More teeth=More productivity



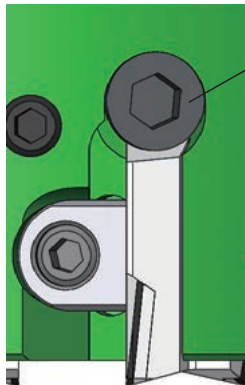
- Easy to cut cycle time

## Light weight aluminum body



- A 25 HP machine can mount a φ 125 mm cutter

## Adjustable edge height



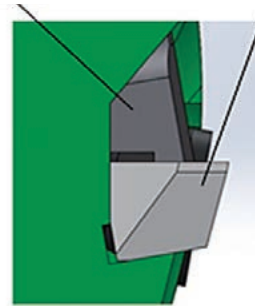
Axial set screw

- Easy adjustment system for axial direction

## Safety clamp mechanism

Wedge

Insert



- Unique sphenoidal pocket prevents inserts from becoming dislodged

## Internal coolant supply

- Coolant through mounting bolt for better chip evacuation

## High speed capability

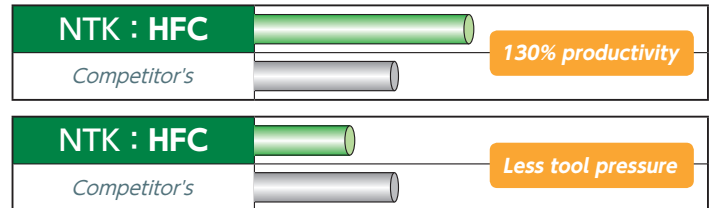
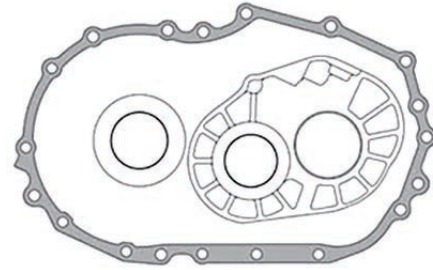
- Up to 20,000 rpm capability



## Field Result

Part : Transmission Case      Cutter : JHF063C220R10  
 Material : ADC12              Insert : HFT802005C05 PD1

	NTK	Competitor's
Number of edges	<b>10</b>	6
Insert grade	PD1	PCD
RPM	10,000	12,000
SFM	6490	7790
IPM	<b>400</b>	312
IPT	0.004	0.004
DOC	.02"	.02"
Spindle load	<b>23%</b>	34%
Flatness	<b>6 μm</b>	20 μm

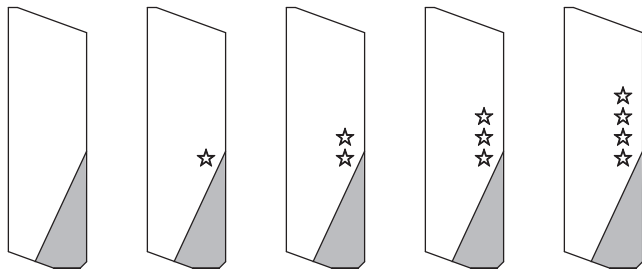


## NTK Regrind Program

- Inserts can be reground up to (4\*) times
- The 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

**NGK** | **NTK**  
 SPARK PLUGS | TECHNICAL CERAMICS  
 NGK SPARK PLUGS (USA), INC.

### NTK Cutting Tools USA

a division of NGK SPARK PLUGS (U.S.A.), INC.  
 46929 Magellan Drive, Wixom, MI 48393, U.S.A.  
 Toll Free: 866-900-9800  
 ctinfo@ntktech.com

[www.ntkcuttingtools.com](http://www.ntkcuttingtools.com)



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