NTK **HFC** - High Feed Cutter-

for Aluminum Milling

ver.2











HFC-High Feed Cutter-



Item number						Max	Stock	
item number	Inch	mm		lbs	kg	RPM	JUGER	
JHF050C2200R07	1.969	φ50	7	0.5	0.23	20,000	•	
JHF063C2200R10	2.480	φ63	10	0.8	0.38	20,000	•	
JHF080A2540R12	3.150	φ80	12	1.1	0.48	18,000	•	
JHF100A2540R16	3.937	φ100	16	1.6	0.74	18,000	•	
JHF125A2540R22	4.921	φ125	22	2.4	1.10	15,000	•	

More teeth=More productivity



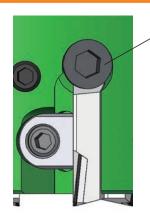
Easy to cut cycle time

Light weight aluminum body



 \bullet A 25 HP machine can mount a ϕ 125 mm cutter

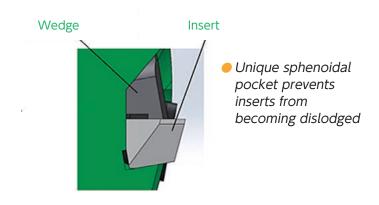
Adjustable edge height



Axial set screw

 Easy adjustment system for axial direction

Safety clamp mechanism



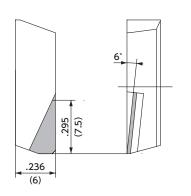
Internal coolant supply

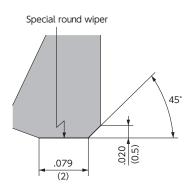
Coolant through mounting bolt for better chip evacuation

High speed capability

Up to 20,000 rpm capability







HFT802006C05 shown.

Produces outstanding surface finishes

Unique cutting edge wiper produces excellent surface finishes

Reduced cutting forces

Sharp multi-faceted cutting edges reduce tool pressure

Less burrs

A 45 degree chamfer on the insert reduces edge burrs

Inserts can be reground up to 4 times

Refer to back cover page for details

Cutter

A.R. 0°			EDP			Weight	Dimensions									Manu	A ulb a u	Aulaau	Recommended tightening		
		Item Number		Stock			φD		h		\$ d		b		а		Max RPM	Arbor style	Arbor bolt	torque	
φ _d R	R.R. +5°					lbs*	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm				N∙m	lb∙ft
		JHF050C2200R07	5929278		7	0.5	1.969	50	1.772	45	.866	22.0	.409	10.4	.409	6.3	20,000	FMC22	CS1040A	20	6.3
		JHF063C2200R10	5929260		10	0.8	2.480	63	1.772	45	.866	22.0	.409	10.4	.409	6.3	20,000	FMC22	CS1040A	20	6.3
	EI +	JHF080A2540R12	5929252	•	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	6.0
φD	-	JHF100A2540R16	5929245	•	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	6.0
		JHF125A2540R22	5929237	•	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	6.0
																		de Inco	ludos ins	orte on	d parts

* Includes inserts and parts

Insert

	IIISCIA										
Г	.236″ (6)	Item Number	EDP	PCD	Corner	Max	DOC	A.R.	rε	Wiper	
		item Number	EDP	PD1	angle	inch	mm	A.K.	inch	mm	vvipei
	.787" (20) (20) (95" (50) (50) (50) (50) (50) (50) (50) (50)	HFT802006C05	5947692	•	90°	.295	7.5	6°	.02 chamfer	C0.5	Yes
	.079" (2)	HFT802006R04	5986138	•	90°	.295	7.5	6°	R .016	RO.4	Yes

• : Stock

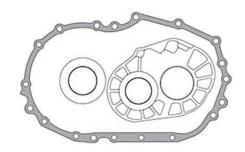
Recommend Cutting Conditions

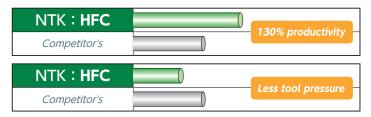
• 1100011111101		- 0																		
Work Material	Grade	Dry	Wet				Cu	tting Sp	eed (S	(SFM)					Feed (IPT)					Depth of Cut
VVOIR Material	Grade	Diy	WEL	1000	3000	5000	7000	9000	11000	13000	15000	17000	19000	.002	.004	.006	.008	.010	.012	(inch)
N	PD1																			250
Aluminum Alloy (Si≦13)																				.230
Aluminum Alloy (Si≧13)	PD1	0	•																	250

Field Result

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

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



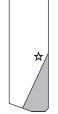


NTK Regrind Program

- 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.





After 1st

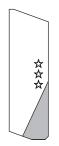




After 2nd

regrinding

TECHNICAL CERAMICS







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.



Delivery will be 6-8 weeks upon receiving your inserts



The insert number will be changed to the following HFT802006C05 RPD1



When installing NTK inserts into a cutter, please make sure that all the inserts have the same number of regrind stars



SPARK PLUGS

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