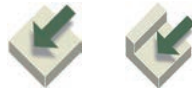


# NTK Milling Cutter Selection

## Machining Gray / Ductile Cast Iron

**XFM** series  
*xtreme feed mill*



88°  
Lead angle

**A.R.-4° R.R.0°**

**Features**

- Large DOC is possible because of the fine pitch of inserts which results in higher productivity
- LNX insert comes with a special chipbreaker to reduce tool pressure
- Newly added Left-hand cutters
- Up to .300" depth of cut

**HVM** series  
*high velocity mill*



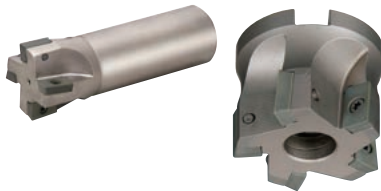
45° 75° 88°  
Lead angles

**A.R.-6° R.R.-10°**

**Features**

- Extremely economical 8-corner inserts (SNG43...)
- Covers various applications with 45, 75, and 88 degree angle milling cutters
- Ceramic inserts with chipbreaker and wiper are available
- Up to .220" depth of cut

**JQ** series



90°

Lead angle

**Features**

- Capable of 90-degree shoulder milling
- A variety of cutter diameters as small as .787 (φ20mm)
- APCW inserts standard edge prep also available with wiper
- Up to .320" depth of cut

**TRI** series



88°

Lead angle

**A.R.5° R.R.4°,7°,10°**

**Features**

- Stable gray cast iron milling with lower cutting forces
- Maximizes ceramic insert potential and can mill faster than 3,200 SFM
- WNX inserts with radius or chamfer
- Up to .220" depth of cut

**HSM** series  
*high speed hear mill*



45° 75° 88°  
Lead angles

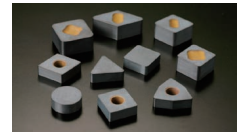
**A.R.+12° R.R.0°**

**Features**

- Positive inserts (SDCW) reduce tool pressure and produce excellent surface finish in addition to long tool life
- Best for milling thin parts thanks to reduced tool pressure
- Up to .200" depth of cut

## SX6 Ceramic

Premium Silicon Nitride



### Features

- **Excellent wear resistance in applications where notch wear appears**
- **Stable tool life in the applications where thermal shock resistance is required : such as WET machining or milling**

Work material	Application	Purpose	Cutting speed (SFM)	Feed (IPR / IPT)	Depth of cut (inch)	DRY	WET
Cast iron	Milling	Rough	1500-4200	.003-.010	.020-.140	●	●

## SP9 Ceramic + Coating

High Speed machining with low cutting forces



### Features

- **Excellent wear- resistance and chipping resistance with CVD coated high-strength silicon nitride-based ceramic**
- **Achieves lower tool pressure with minimal edge preparation**
- **Also usable for finishing**

Work material	Application	Purpose	Cutting speed (SFM)	Feed (IPR / IPT)	Depth of cut (inch)	DRY	WET
Gray cast iron	Milling	Rough-Semi finish	1200-2500	.003-.010	-.240	●	○
Ductile cast iron	Milling	Rough-Semi finish	2100-3000	.003-.010	-.240	●	○

## B30 CBN

### Features

- **Excellent wear resistance thanks to high CBN content**
- **Designed for finishing cast iron**

- **CBN Wiper Insert: Can install 1 or 2 CBN Wiper Inserts with ceramic insert.**
- **Available for: JQ Series - APCW inserts  
HVM Series - FDX inserts  
HSM Series - SDW inserts**

## B52 CBN

### Features

- **Excellent wear resistance due to optimum CBN content with special TiC binders**
- **Ideal for finishing ductile cast iron and continuous cuts for finishing hardened materials**



NGK SPARKPLUGS(USA),INC.

### NTK Cutting Tools USA

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