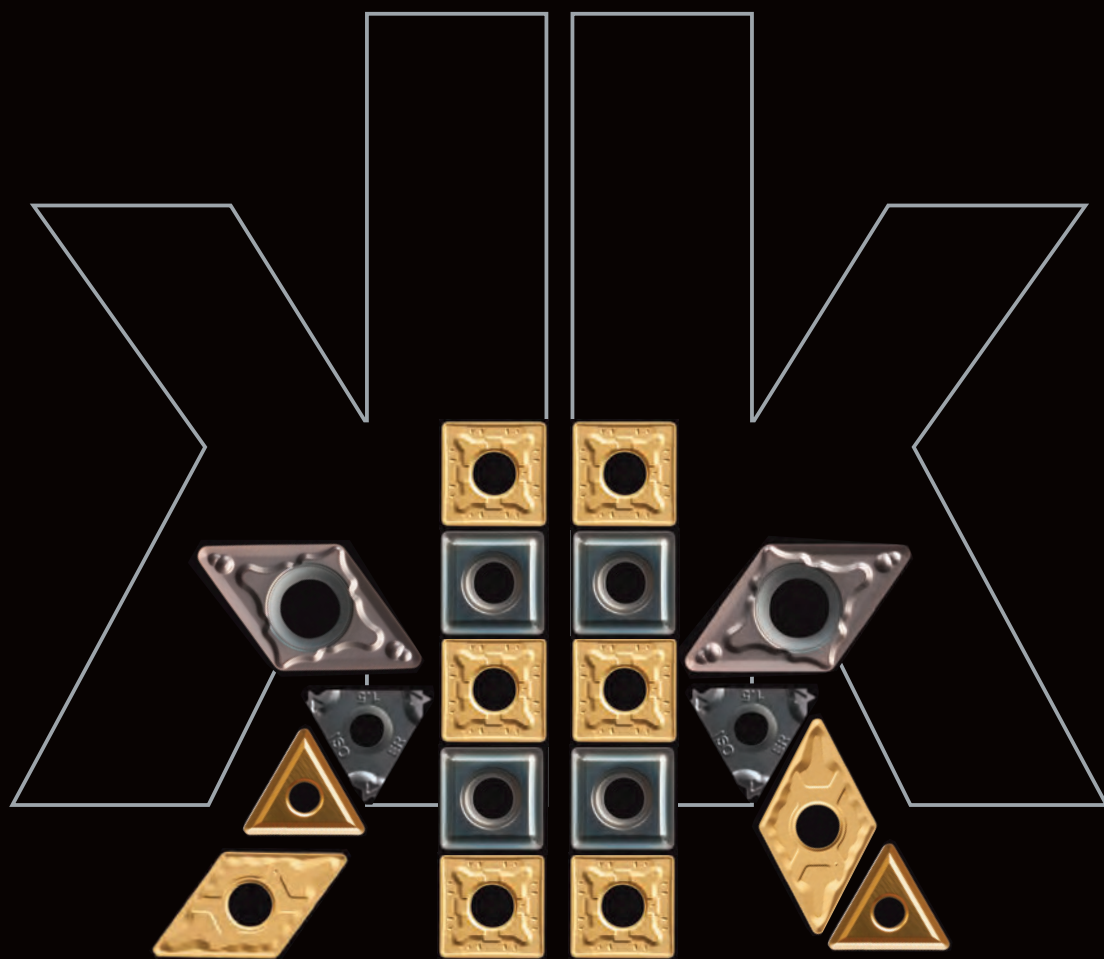
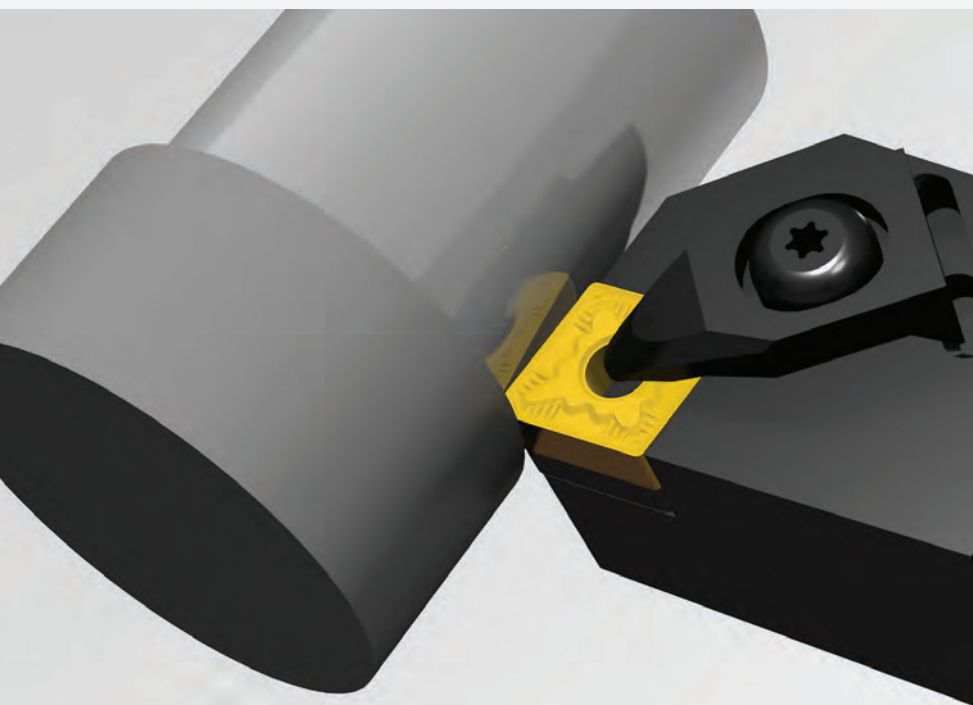


nixkoTOOLS



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www.jcmesa-representaciones.es

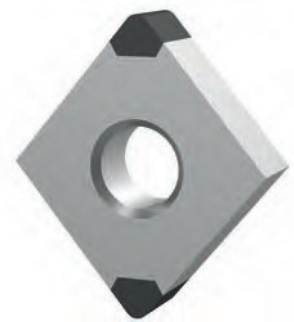


TURNING

Carbide .7
PCBN .37
Ceramic .55
Diamond .69
Holders .85



TURNING Carbide



TURNING PCBN

		MATERIAL	OPERATION	CONDITION	EDGE PREP.	GRADE	Vc (m/min)	fn (mm/rev)	COOLANT
TURNING	H	Hardened steel	finishing ap < 0.5 mm		SE	NBL050C	140 190 240	0.06 0.14 0.22	
					UE	NBL150C tool life	120 170 220	0.06 0.15 0.24	
						NBL250C reliability	100 150 200		
		RE	NBL350C	80 120 160	0.06 0.16 0.26				
THREADING		Bearing steel	finishing ap < 0.5 mm		SE	NBL050C	120 170 220	0.05 0.10 0.15	
					UE	NBL150C tool life	100 150 200	0.06 0.13 0.20	
						NBL250C reliability	80 130 180		
				RE	NBL350C	60 110 160	0.06 0.14 0.22		
			roughing ap > 0.5 mm SOLID PCBN		UE	NBH900U	100 140 180	0.15 0.30 0.45	
		UE		NBH950U	80 120 160	0.10 0.25 0.40			
GROOVING		Tool steel	finishing ap < 0.5 mm		SE	NBL150C	100 140 180	0.04 0.09 0.14	
					UE	NBL250C	80 120 160	0.05 0.12 0.19	
						RE	NBL350C	60 100 140	0.06 0.13 0.20
	roughing ap > 0.5 mm SOLID PCBN			UE	NBH900U	60 100 140	0.10 0.30 0.50		
				UE	NBH950U	40 80 120	0.10 0.25 0.40		
MILLING	High speed steel	finishing ap < 0.5 mm		UE	NBL150C	100 120 140	0.05 0.08 0.11		
	White cast iron	finishing ap < 0.5 mm		UE	NBH500C	60 120 180	0.10 0.30 0.50		
				UE	NBH900U	40 80 120	0.10 0.25 0.40		
		roughing ap > 0.5 mm SOLID PCBN		UE	NBH500C	60 90 120	0.20 0.40 0.60		
			UE	NBH950U	40 60 80	0.20 0.35 0.50			
DRILLING	Gray cast iron	finishing ap < 0.5 mm		UE	NBH450C	400 800 1200	0.10 0.25 0.40		
				UE	NBH500C	600 1000 1400	0.10 0.20 0.30		
		roughing ap > 0.5 mm SOLID PCBN		UE	NBH500C	600 1000 1400	0.20 0.40 0.60		
				UE	NBH900U tool life NBH950U reliability	400 800 1200 400 700 1000	0.20 0.35 0.50		
	ADI cast iron	finishing ap < 0.5 mm		UE	NBL150C	500 600 700	0.05 0.15 0.25		
			UE	NBL250C	400 500 600	0.05 0.15 0.25			
roughing ap > 0.5 mm SOLID PCBN			UE	NBH500C	300 400 500	0.10 0.25 0.40			
			UE	NBH900U tool life NBH950U reliability	200 250 300 180 230 280	0.10 0.25 0.40			
ACCESSORIES	P	Sintered powder metal, high alloyed	finishing ap < 0.5 mm		UE	NBL150C	80 160 240	0.05 0.10 0.15	
		Sintered powder metal, low alloyed	finishing ap < 0.5 mm		UE	NBH450C	140 220 300	0.10 0.20 0.30	

 Stable machining, continuous cut
  General machining, light interruption
  Unstable machining, interrupted cut



TURNING Ceramic



TURNING Diamond

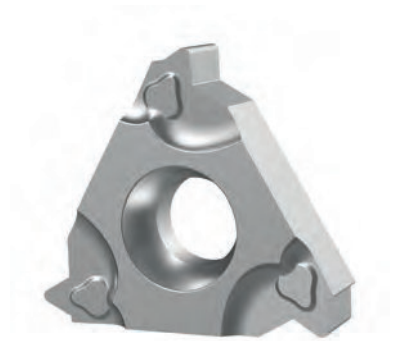


TURNING Holders

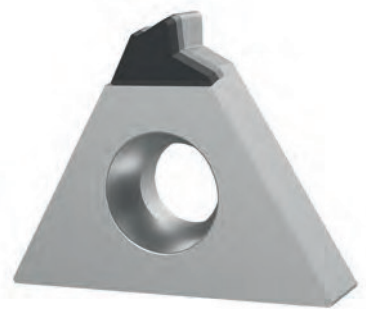


THREADING

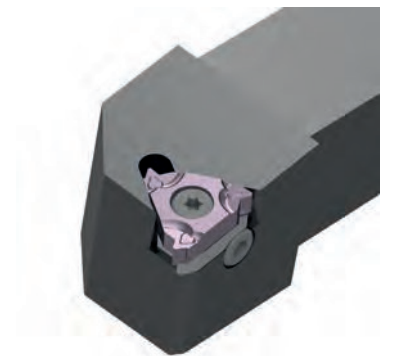
Carbide .175
Advanced .181
Holders .185



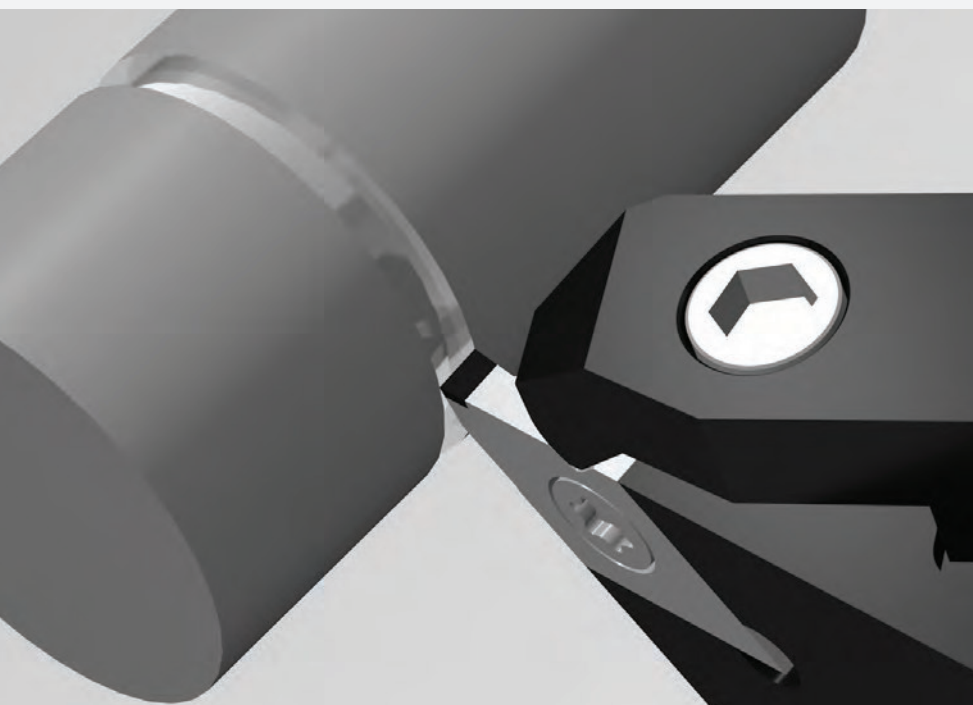
THREADING Carbide



THREADING Advanced



THREADING Holders



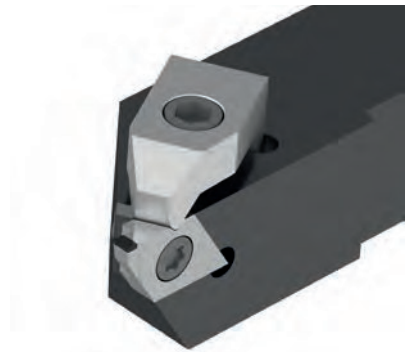
GROOVING

Advanced .193

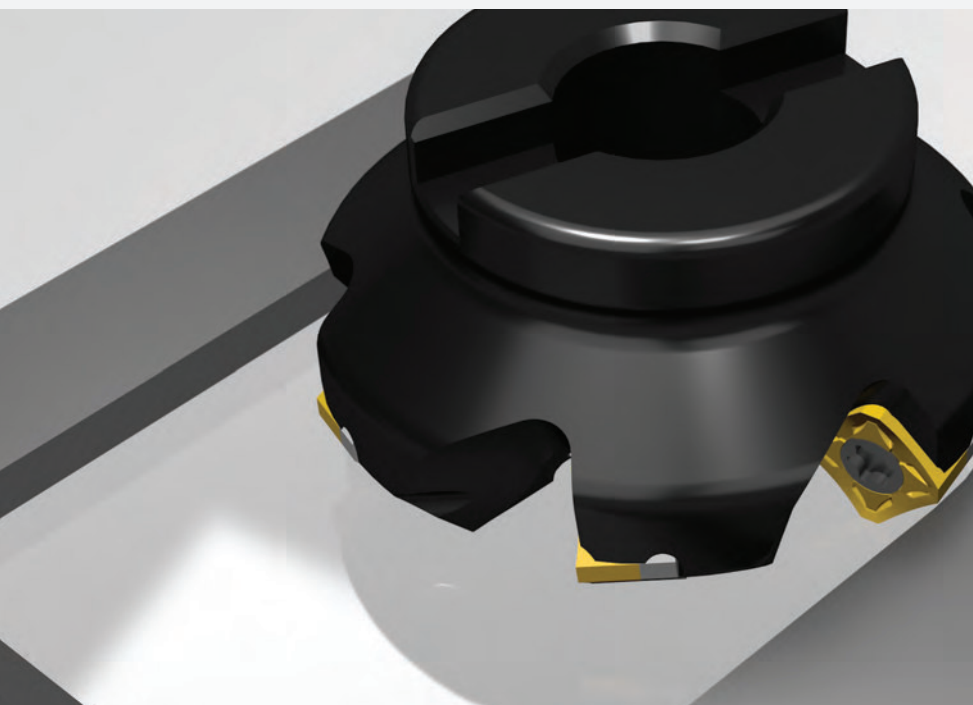
Holders .195



GROOVING Advanced



GROOVING Holders



MILLING

Shouldering .199

Facing .209

High Feed .223

Copying .229

Chamfering .237

Advanced .241



MILLING Shouldering

DOUBLE3CON .200

REKPLUS .202

APKT ISO .206



MILLING Facing

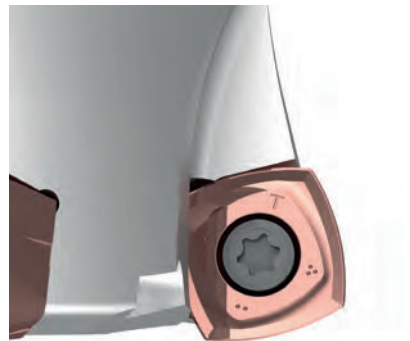
DOUBLE4FACE .210

DOUBLEHEX .212

4FACEPLUS .214

OKTOPLUS .218

SEHX12 ISO .222



MILLING High Feed

HF4PLUS .224



MILLING Copying

ROUNDPLUS .230



MILLING Chamfering

CHAMFERSQUARE .238



MILLING Advanced



DRILLING

DEXdrill .253

DRSdrill .261

DRSpilot .271

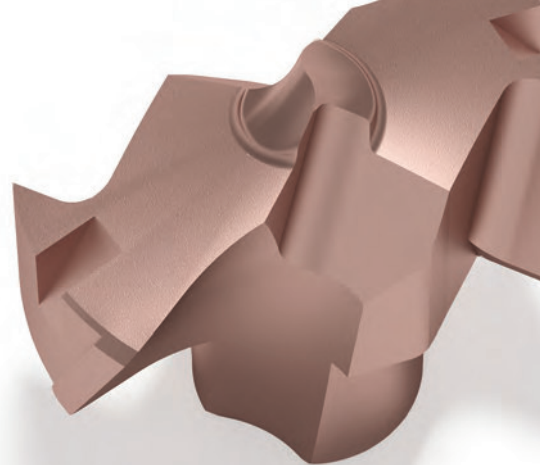
SPOTdrill .277



DRILLING DEXdrill

DEXDRILL

3XD
5XD

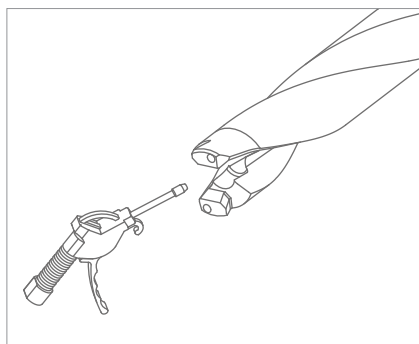


High performance drilling system with interchangeable heads

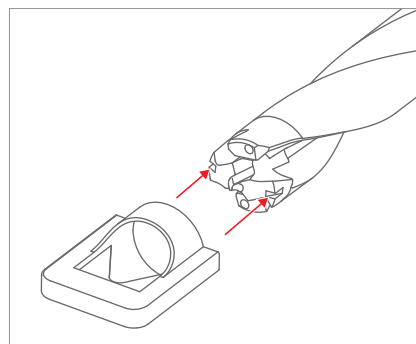
1. Where is DEXdrill applicable?

PLAIN SURFACE	CONCAVE SURFACE	STACKED PLATES	PIPES	SLANT SURFACE	HALF HOLE	HOLE EXPANSION

2. Drilling heads installation

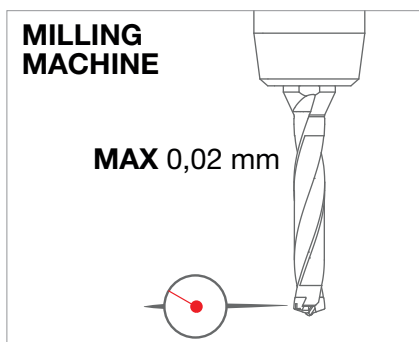


*Clean pocket
with air blast.
Put insert into
drill holder.*



*Set wrench into
slots on insert
flanks.
Slowly turn
the wrench
clockwise until
stop.*

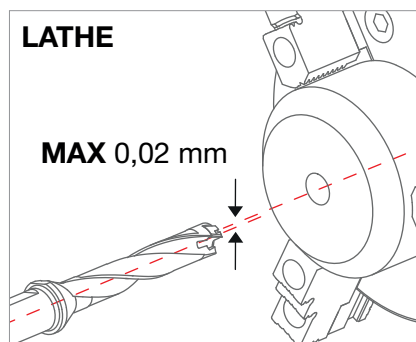
3. Operation recommendations



**MILLING
MACHINE**

MAX 0,02 mm

*Center of
arbor deviation
must be under
0.02mm*



LATHE

MAX 0,02 mm

*Keep under
0.02mm
the maximum
deviation
between drill
and workpiece*



DRILLING DRSdrill

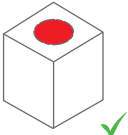
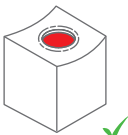
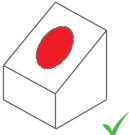
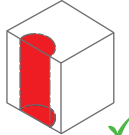
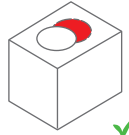
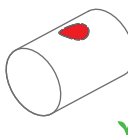
DRSDRILL

High performance drills for universal use

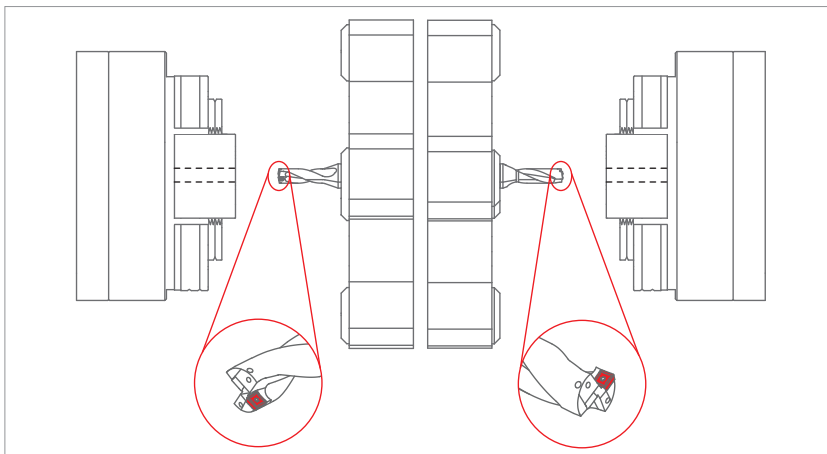
2XD
3XD
4XD
5XD



1. Where is DRSDrill applicable?

PLAIN SURFACE	CONCAVE SURFACE	SLANT SURFACE	HALF HOLE	HOLE EXPANSION	PIPES	STACKED PLATES
						

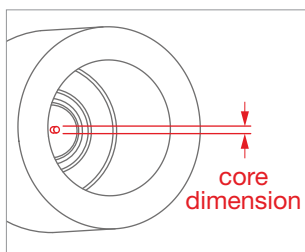
2. Lathe installation



It's recommended to set the outer insert facing the operator as shown in the drawing, both for main and sub-spindle to gain the best results.

Following this suggestion, generally, the inner insert will be set below the center which is the recommended situation for optimal operation.

3. Quick check of the center height



To check if the machine axis is correctly aligned, a test hole should be drilled checking the remaining core on the hole bottom.

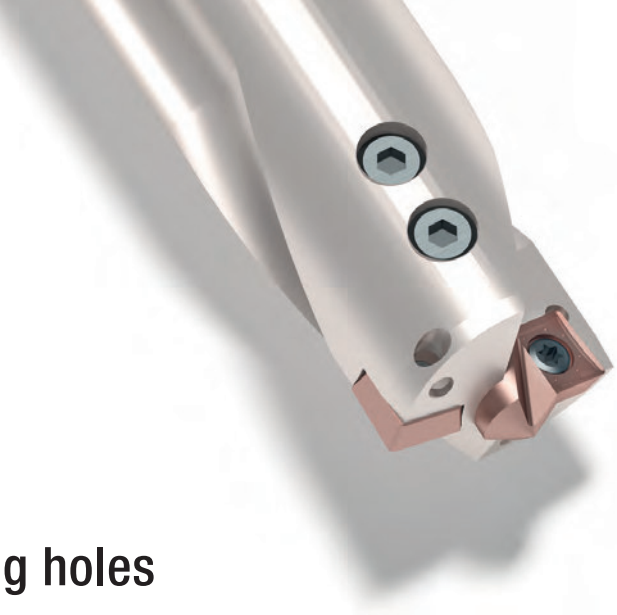
Center-height adjustment is necessary when **no core** remains or if the core diameter is **larger than 1mm**.



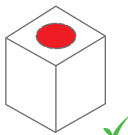
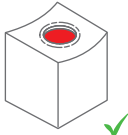
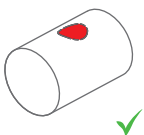
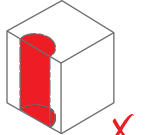
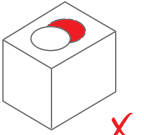
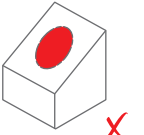
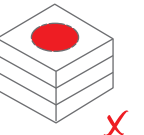
DRILLING DRSpilot

DRSPILOT^{6XD}_{9XD}

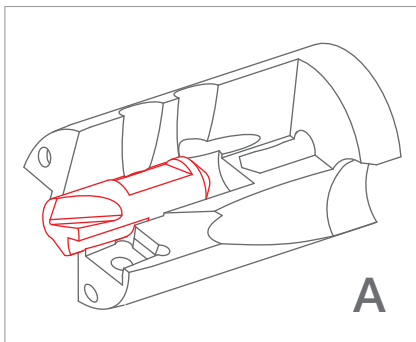
Perfect centering even on extra long holes



1. Where is DRSpilot applicable?

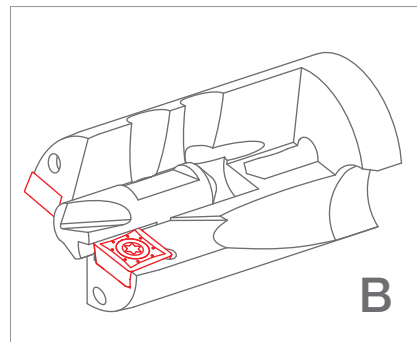
PLAIN SURFACE	CONCAVE SURFACE	PIPES	HALF HOLE	HOLE EXPANSION	SLANT SURFACE	STACKED PLATES
						

2. Installation of inserts and pilot drill



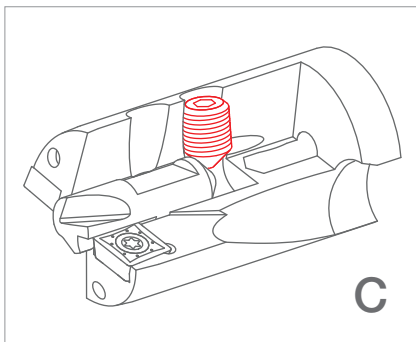
A

Insert DRSP pilot in the drilling body.



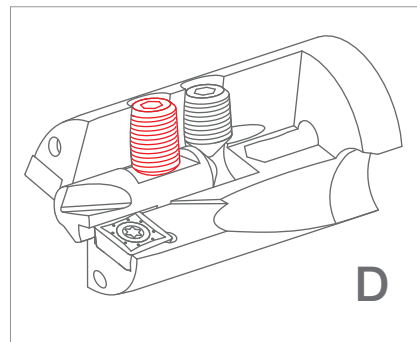
B

Install the SPMX/SPGX inserts.



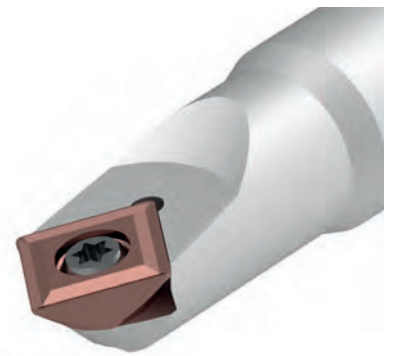
C

Adjust the DRSP pilot height using the setting grain as shown in the drawing, following the table at pag.273.



D

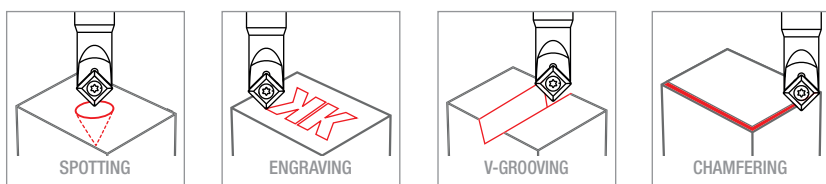
Screw tight the locking grain.



DRILLING SPOTdrill

SPOTDRILL

Multipurpose system



SPOT11		SPOTDRILL Multipurpose system				ISO513	COATED			UNCOATED									
							HC-150P	HC-150M	HC-150K	HW-150N									
 4 edges	Size	IC	S	D1		P	100 220												
	11	11	3.97	4.3		M		60 140											
						K			80 180										
						N				150 300									
						S													
						H													
GRADE APPLICATION AREA		Stable machining				+ Hardness - Toughness													
main application		General machining																	
applicable		Unstable machining																	
GENERAL	GP	SPOT 11R03-GP	RE 0.3	$f_n \blacktriangleright$ 0.04 $f_n \blacktriangleright$ 0.08	0.07 0.15	0.10 0.22	●	●	●										
		11R08-GP	RE 0.8	$f_n \blacktriangleright$ 0.04 $f_n \blacktriangleright$ 0.08	0.07 0.15	0.10 0.22	●	●	●										
ALUMINIUM	AL	11R04-AL	RE 0.4	$f_n \blacktriangleright$ 0.06 $f_n \blacktriangleright$ 0.14	0.09 0.22	0.12 0.30				●									
	polished surface	11R08-AL	RE 0.8	$f_n \blacktriangleright$ 0.06 $f_n \blacktriangleright$ 0.14	0.09 0.22	0.12 0.30				●									

● stock standard feed rate for chamfering