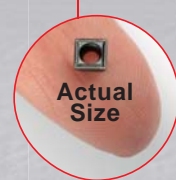
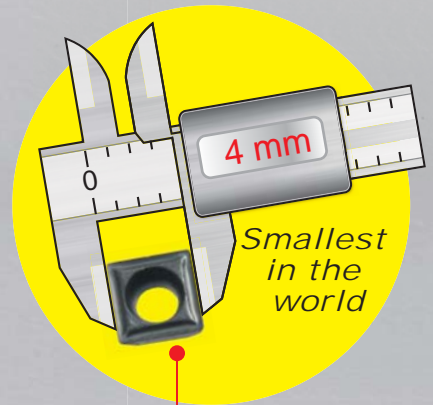
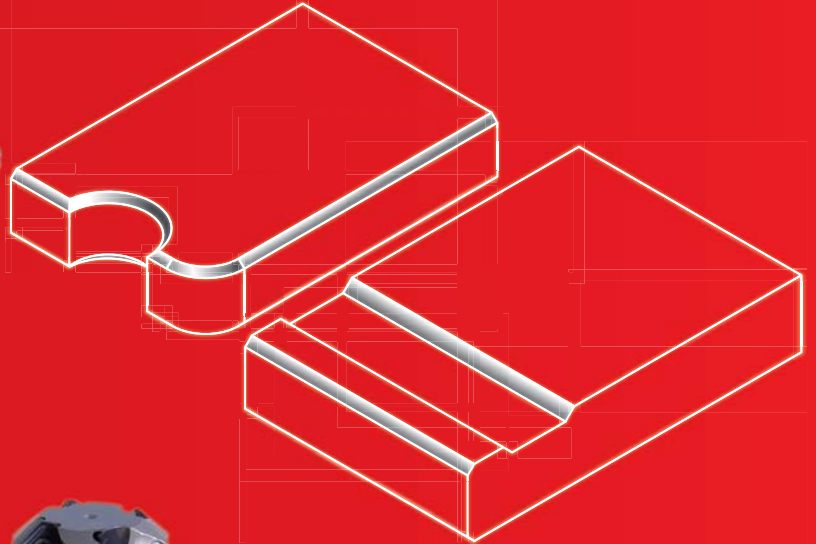
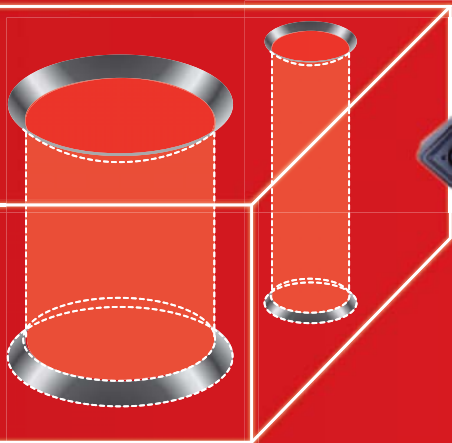


45° indexable chamfer mill



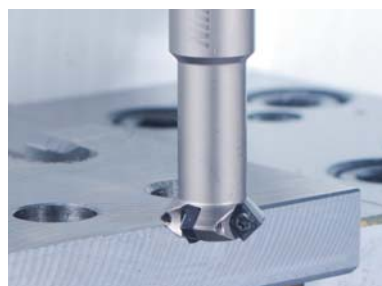
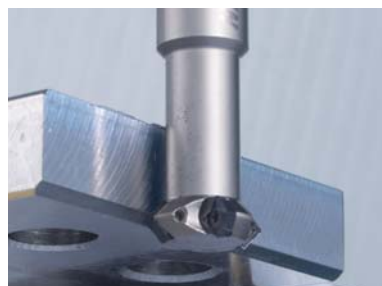
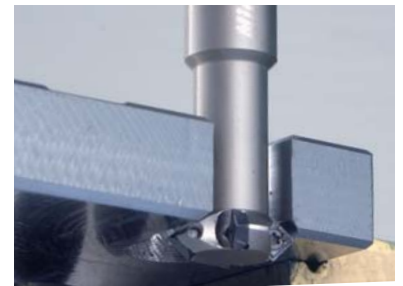
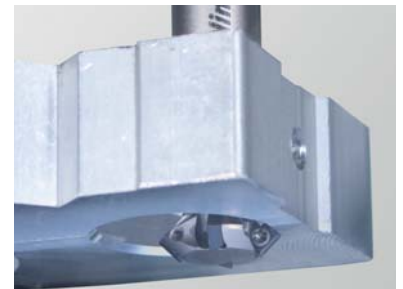
<http://www.jic-tools.com.tw>



Cat. No. 01



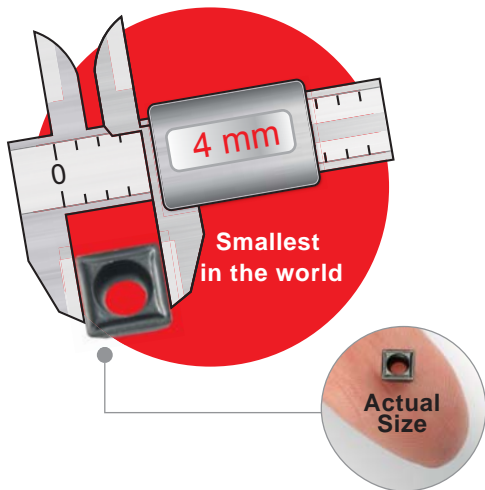
New Nine9 chamfer mill is designed for chamfering and countersinking with an indexable insert. The insert is a dedicated design for use in high speed machining ; the multiple cutting edges increase feed rate, optimizing performance and reducing cutting time.



Features

- Smallest insert in the world for chamfering mill.
- Smallest Indexable counter sink, diameter ø7 mm.
- The insert is dual-relief angle, specially honed and optimized coated for high cutting speed.
- Optimized the number of teeth on the holder to achieve higher feed rate.
- For front and back chamfering.

Eliminates 2nd operation or de-burring time.

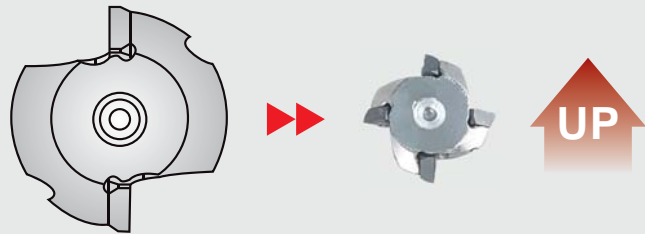


Applications

- 90° counter sink and 45° chamfering.
- For counter sink, circular chamfering, contour chamfering and face milling.

- Comparison with other manufacturers chamfer tool with larger insert(Sxxx1204) and Nine9 N9GX04 insert.

	Other makers with Large insert	Nine 9 Chamfer mills
Chamfering	1 mm	1 mm
Feed rate mm/rev.	0.1	0.1
Dia. of cutter	32 mm	11 mm
Teeth of cutter	2	4
Vc m/min.	200	300
R.P.M	1990	8685
F mm/min	398	3474



Feed Rate = Feed per Tooth x Spindle Speed x **No. of Flute** mm/min.

$$\text{UP Spindle Speed} = \frac{\text{Cutting Speed} \times 1000}{\pi \times \text{Cmin.}}$$

Cylindrical Shank Holders

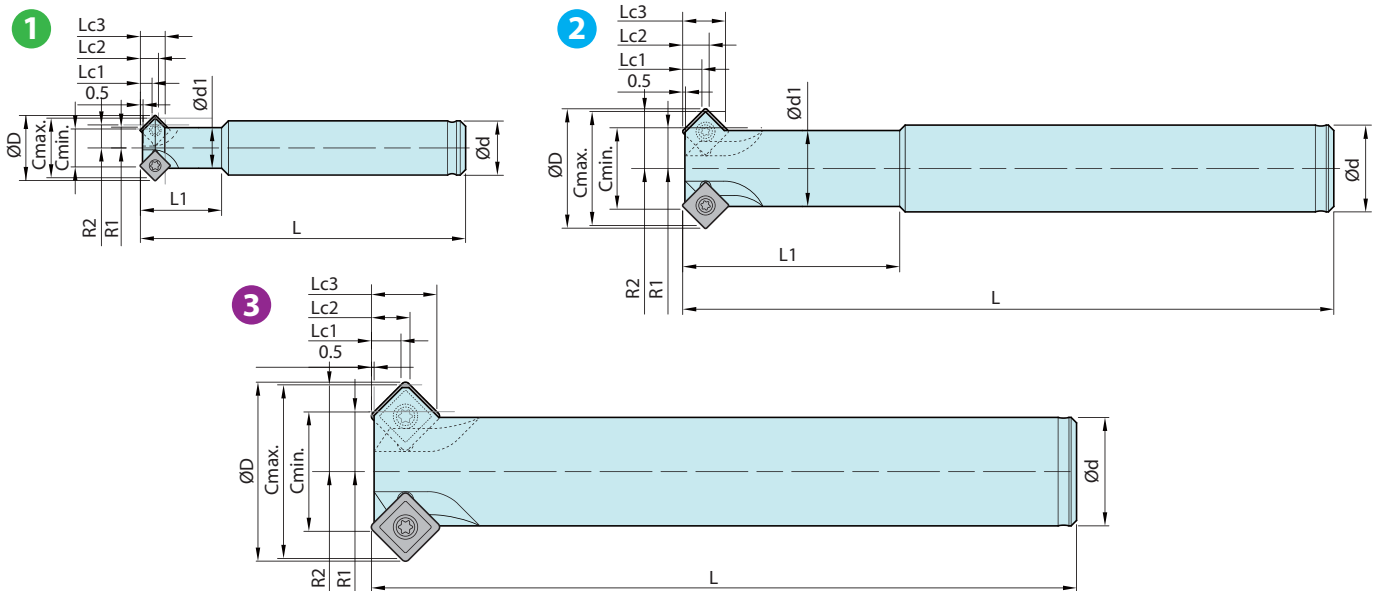


Fig.	Part No.	Type	Cmin. Ø	Cmax. Ø	Shank Ø	ød1	ØD	R1	R2	L	L1	Lc1	Lc2	Lc3	Z	Insert Screw / Key
1	00-99616-C10	BC10-C07-60	7 (.276")	11 (.433")	10 (.394")	7.5 (.295")	12 (.472")	3.8	4.3	60	15	2.2	3.3	4.6	2	N9GX04T002 NS-18037 / NK-T6
2	00-99616-C20	BC12-C11-100	11 (.433")	16 (.630")	12 (.472")	9.6 (.378")	16.2 (.638")	5.9	8	100	25	2.6	2.9	5.0	4	N9GX060204 NS-22055 / NK-T7
2	00-99616-C30	BC16-C15-120	15 (.590")	21 (.827")	16 (.630")	14 (.551")	22 (.866")	7.5	11.5	120	40	3.5	4.9	7.9	4	N9GX090308 NS-30072 / NK-T9
2	00-99616-C40	BC20-C19-130	19 (.748")	25 (.984")	20 (.787")	18 (.709")	26 (1.024")	9.5	12.5	130	50	3.5	4.9	7.9	4	N9GX090308 NS-30072 / NK-T9
3	00-99616-C50	BC20-C22-130	22 (.866")	32 (1.260")	20 (.787")	-	33 (1.299")	11	16	130	-	5.5	7.1	12.1	4	N9GX090308 NS-30072 / NK-T9
2	00-99616-C52	BC25-C22-180	22 (.866")	32 (1.260")	25 (.984")	20 (.787")	33 (1.299")	11	16	180	80	5.5	7.1	12.1	4	N9GX090308 NS-30072 / NK-T9

Kit

Fig.	Part No.	Insert included	Holder included	Content
1	00-99616-C1020-32	N9GX04T002-NC2032	00-99616-C10	2 x holders + 10 inserts + 1 key
	00-99616-C1020-71	N9GX04T002-NC9071	00-99616-C20	
2	00-99616-C3040-32	N9GX060204-NC2032	00-99616-C30	2 x holders + 10 inserts + 1 key
	00-99616-C3040-71	N9GX060204-NC9071	00-99616-C40	
3	00-99616-C5052-32	N9GX090308-NC2032	00-99616-C50	2 x holders + 10 inserts + 1 key
	00-99616-C5052-71	N9GX090308-NC9071	00-99616-C52	

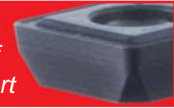


Insert

Features:

- Thanks to the patented specially ground dual-relief insert and optimized coating, higher feed rates and cutting speeds can be achieved on chamfering operations.
- Each insert has 4 cutting edges, reducing cost of inserts.
- Fine lapping on the cutting edge, good chip breaking condition and long tool life.

Patented
Dual-relief
angle insert



NC2032



NC9071

- **Grade NC2032** : K20F grade, AlTiN coated. The 1st choice for high carbon, high alloy and hardened steels as well as cast iron.

- **Grade NC9071**: K20F grade, TiN coated, high positive rake angle and honed sharp edge. The best choice for low carbon steel, low carbon alloy steel, stainless steel, Al, Al-alloy, Brass, Bronze and most of the non-ferrous metal.

Ordering Code			Dimensions			
Code of insert	Grade		L	S	re	Screw / Key
N9GX04T002	NC2032		4.0	1.8	0.2	NS-18037 / NK-T6
N9GX060204			6.35	2.38	0.4	NS-22055 / NK-T7
N9GX090308	NC9071		9.52	3.18	0.8	NS-30072 / NK-T9

Cutting Data

Work piece material		Grade of insert	Cutting Speed Vc m/min. (SFM feet / min.)	Feed rate mm/tooth (inch / tooth)		
				N9GX04T002	N9GX060204	N9GX090308
Material Group	Sample Code (JIS)			Max. Chamfering 1.5 mm	Max. Chamfering 2.5 mm	Max. Chamfering 4 mm
Carbon steel C<0.3%	SS400	NC9071	150-250-350 (500-820-1150)	0.06 ~ 0.12 (.002" ~ .005")	0.10 ~ 0.25 (.004" ~ .010")	0.10 ~ 0.25 (.004" ~ .010")
Carbon steel C>0.3%	S50C, P5	NC2032	200-300-400 (660-1050-1310)	0.06 ~ 0.10 (.002" ~ .004")	0.10 ~ 0.20 (.004" ~ .008")	0.10 ~ 0.25 (.004" ~ .010")
Low alloy steel C<0.3%	SCM420	NC9071	180-240-260 (590-790-860)	0.06 ~ 0.10 (.002" ~ .004")	0.10 ~ 0.20 (.004" ~ .008")	0.10 ~ 0.20 (.004" ~ .008")
High alloy steel C>0.3%	SKD11	NC2032	120-150-200 (390-500-660)	0.06 ~ 0.10 (.002" ~ .004")	0.10 ~ 0.15 (.004" ~ .006")	0.10 ~ 0.15 (.004" ~ .006")
Hardened steel <HRC50°	SKD61	NC2032	80-90-100 (265-300-330)	0.06 ~ 0.10 (.002" ~ .004")	0.06 ~ 0.12 (.002" ~ .005")	0.10 ~ 0.15 (.004" ~ .006")
Stainless steel	SUS304	NC9071	120-150-180 (390-500-590)	0.06 ~ 0.10 (.002" ~ .004")	0.06 ~ 0.15 (.002" ~ .006")	0.10 ~ 0.20 (.004" ~ .008")
Casting iron	FC25	NC2032	120-150-180 (390-500-590)	0.06 ~ 0.10 (.002" ~ .004")	0.10 ~ 0.15 (.004" ~ .006")	0.10 ~ 0.20 (.004" ~ .008")
Al, and non-ferrous metal	A6061	NC9071	200-400-600 (660-1310-1970)	0.06 ~ 0.15 (.002" ~ .006")	0.10 ~ 0.25 (.004" ~ .010")	0.10 ~ 0.25 (.004" ~ .010")

* Do not recommend to use on hand handling machine and hand holding power tool.

Distributor :