



DOUBLEREK SYSTEM

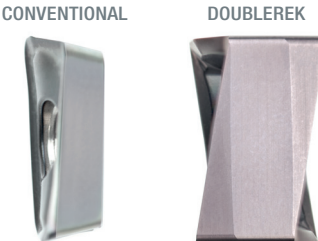
Reliable shouldering applications with superior accuracy



<h1>DRK</h1> <h2>DOUBLEREK</h2> <ul style="list-style-type: none"> Shoulder milling 90° Double-sided insert Rectangular shape with hole 4 cutting edges Two insert sizes for APMX until 15 mm High rake angle allows soft cutting action Precision ground with large wiper facet for perfect finishing 	HC: coated carbide HF: micrograin carbide CVD: chemical vapour deposition PVD: physical vapour deposition	HF PVD	HC CVD	HF PVD	HC CVD	HF PVD	HC CVD	HF PVD	HF PVD
	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ❄ 1 st choice ❄ suitable	JPS530	JC7515	JP7525	JG8520	JP8725	JG9540	JP9535	JP9545
	Dimensions 	Vc(m/min) - suggested cutting speed range (bold: 1st choice) ISO P M K N S H 60 230 150 80 140 60 50 140 60 150 350 280 260 200 140 100 120 100 130 200 350 240 250 40 40 40 100 80 60							

Designation	RE	IC	S	D1	BS	Stock															
GP general purpose	NT-DRK10R08K-GP	0.8	5.82	5.45	2.90	0.90	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
GP general purpose	NT-DRK17R08K-GP	0.8	11.20	10.94	5.20	3.20	●	●	●	●	●	●	●	●	●						
TE reinforced edge	NT-DRK17R12K-TE	1.2	11.20	10.94	5.20	2.90	●	●	●	●	●										

● stock standard



much thicker than conventional solutions

DRK10-GP		
a_e	a_p	1.00 2.50 4.00
40÷100% DC	f_z	0.08 0.10 0.12
a_e	a_p	1.00 4.00 7.00
10÷30% DC	f_z	0.10 0.13 0.16
a_e	a_p	1.00 4.00 7.00
<10% DC	f_z	0.12 0.16 0.20

DRK17-GP		
a_e	a_p	1.00 4.00 7.00
40÷100% DC	f_z	0.10 0.13 0.16
a_e	a_p	1.00 8.00 15.0
10÷30% DC	f_z	0.12 0.16 0.20
a_e	a_p	1.00 8.00 15.0
<10% DC	f_z	0.16 0.20 0.24

DRK17-TE		
a_e	a_p	1.00 4.00 7.00
40÷100% DC	f_z	0.14 0.17 0.20
a_e	a_p	1.00 8.00 15.0
10÷30% DC	f_z	0.16 0.20 0.24
a_e	a_p	1.00 8.00 15.0
<10% DC	f_z	0.20 0.25 0.30

a_e : radial depth of cut (mm)
 a_p : axial depth of cut (mm)
 f_z : feed per tooth (mm)
 DC: milling cutter diameter (mm)



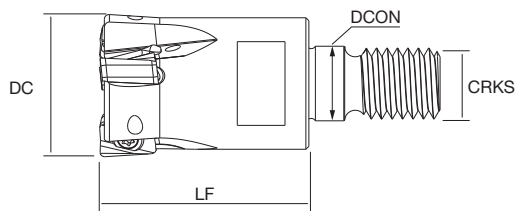
large contact surfaces for stable and reliable operation

Spare Parts	INSERT SCREW	INSERT WRENCH
NT-DRK10 D ^{ooo-ooo-Z^{oo}}	NT-ST048	NT-FTB08
NT-DRK17 D ^{ooo-ooo-Z^{oo}}	NT-ST037	NT-FTB15

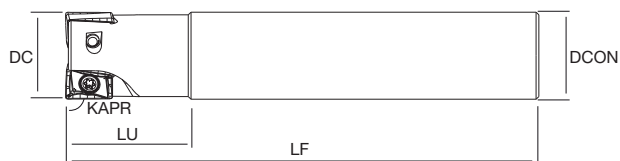
DOUBLEREK

P	M	K	N	S	H
★	☆	★		☆	

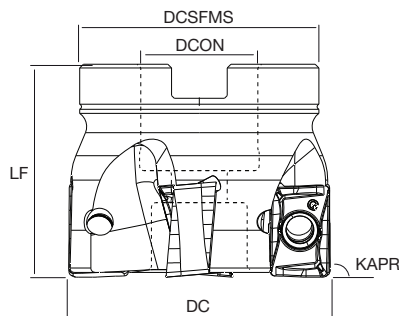
- Shoulder milling
- KAPR = 90°
- Internal coolant
- Economical double-sided system
- Reliable and versatile system
- Stable and easy insert positioning



SCREW-IN



CYLINDRICAL



ARBOR



	Designation	Stock	DC	ZEFP	DCON	DCSFMS	LF	LU	CRKS	WT	MIID
SCREW-IN	NT-DRK10 D016-M08-Z02	●	16	2	8.5		25		M8	0.05	NT-DRK10
	NT-DRK10 D020-M10-Z03	●	20	3	10.5		30		M10	0.10	NT-DRK10
	NT-DRK10 D025-M12-Z03	●	25	3	12.5		35		M12	0.15	NT-DRK10
	NT-DRK10 D032-M16-Z04	●	32	4	16.0		43		M16	0.25	NT-DRK10
CYLINDRICAL	NT-DRK10 D016-S16-Z02	●	16	2	16		100	25		0.15	NT-DRK10
	NT-DRK10 D020-S20-Z03	●	20	3	20		110	30		0.25	NT-DRK10
	NT-DRK10 D025-S25-Z03	●	25	3	25		120	35		0.45	NT-DRK10
	NT-DRK10 D032-S32-Z04	●	32	4	32		130	45		0.75	NT-DRK10
	NT-DRK17 D032-S32-Z02	●	32	2	32		130	45		0.70	NT-DRK17
	NT-DRK17 D040-S32-Z03	●	40	3	32		150	40		1.90	NT-DRK17
ARBOR	NT-DRK10 D032-F16-Z04	●	32	4	16	30	40			0.15	NT-DRK10
	NT-DRK10 D040-F16-Z05	●	40	5	16	30	40			0.20	NT-DRK10
	NT-DRK10 D050-F22-Z05	●	50	5	22	40	40			0.35	NT-DRK10
	NT-DRK10 D050-F22-Z07	●	50	7	22	40	40			0.30	NT-DRK10
	NT-DRK10 D063-F22-Z06	●	63	6	22	55	40			0.65	NT-DRK10
	NT-DRK10 D063-F22-Z08	●	63	8	22	55	40			0.60	NT-DRK10
	NT-DRK10 D080-F27-Z07	●	80	7	27	60	50			1.30	NT-DRK10
	NT-DRK10 D080-F27-Z10	●	80	10	27	60	50			1.25	NT-DRK10
	NT-DRK17 D050-F22-Z04	●	50	4	22	45	40			0.30	NT-DRK17
	NT-DRK17 D063-F22-Z05	●	63	5	22	55	40			0.55	NT-DRK17
	NT-DRK17 D063-F22-Z06	●	63	6	22	55	40			0.55	NT-DRK17
	NT-DRK17 D080-F27-Z06	●	80	6	27	60	50			1.15	NT-DRK17
	NT-DRK17 D080-F27-Z07	●	80	7	27	60	50			1.10	NT-DRK17
	NT-DRK17 D100-F32-Z07	●	100	7	32	78	50			1.75	NT-DRK17
	NT-DRK17 D100-F32-Z09	●	100	9	32	78	50			1.75	NT-DRK17
	NT-DRK17 D125-F40-Z08	●	125	8	40	80	63			3.20	NT-DRK17
	NT-DRK17 D125-F40-Z10	●	125	10	40	80	63			3.15	NT-DRK17

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