

MICROVORTEX 



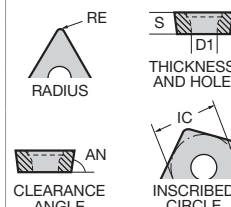
MICROVORTEX

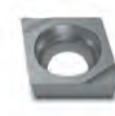



Turning and Threading of small bores

Choose your favorite set!

- Turning box € 199
- Threading box € 119

nikkoTOOLS

<h1>MICRO</h1> <h2>TURNING-THREADING</h2>	HF: micrograin carbide HT: cermet PVD: physical vapour deposition	HT	HF PVD	HF PVD																
		JU4015	JP5025	JP5125																
<ul style="list-style-type: none"> Small insert series for internal turning and threading applications. Available with PVD micrograin carbide that allows very good performance even at medium-low cutting speed, thanks to a great toughness substrate. Uncoated cermet is suggested for stable machining, higher cutting condition and better finishing surface. Turning inserts are combined with PPF ground chipbreaker, a very sharp solution recommended for super-finishing applications. Threading inserts are available with TPM chipbreaker that guarantees perfect chip control even in very small hole machining. 	Stable machining, light cut ● 1 st choice ○ suitable General machining, medium cut ● 1 st choice ○ suitable Unstable machining, heavy cut ⚙ 1 st choice ⚙ suitable	●	○	○																
	Dimensions	ISO	Vc(m/min) - suggested cutting speed range (bold: 1 st choice)																	
		P 200 60 60 380 180 180 M 160 60 60 280 120 120 K 200 80 80 400 150 150 N S 30 30 60 60 H																		

Designation		RE	IC	S	D1	AN	Stock																			
TURNING	PPF for precision finishing 	MCC.R02L-PPF	0.2	3.50	1.40	1.90	7°	●	●																	
		MCC.R04L-PPF	0.4	3.50	1.40	1.90	7°	●	●																	
	ground chipbreaker																									
	PPF for precision finishing 	TBET060102L-PPF	0.2	3.97	1.59	2.30	5°	●	●																	
		TBET060104L-PPF	0.4	3.97	1.59	2.30	5°	●	●																	
	ground chipbreaker																									
THREADING	PPF for precision finishing 	WBET060102L-PPF	0.2	3.97	1.59	2.30	5°	●	●																	
		WBET060104L-PPF	0.4	3.97	1.59	2.30	5°	●	●																	
	ground chipbreaker																									
	TPM partial profile design 	07IRA60-TPM	0.08	5.00	2.25	2.68			●																	
Metric and Unified threads																										

● stock standard

PPF

RE 0.2	a _p	0.05 0.30 0.55
	f _n	0.04 0.06 0.08
RE 0.4	a _p	0.05 0.30 0.55
	f _n	0.06 0.08 0.10

a_p: depth of cut (mm)
f_n: feed rate (mm/rev)

M THREADS

TP 0.50	No. of passes	8÷11
TP 0.75	No. of passes	8÷11
TP 1.00	No. of passes	10÷13
TP 1.25	No. of passes	12÷15
TP 1.50	No. of passes	12÷15

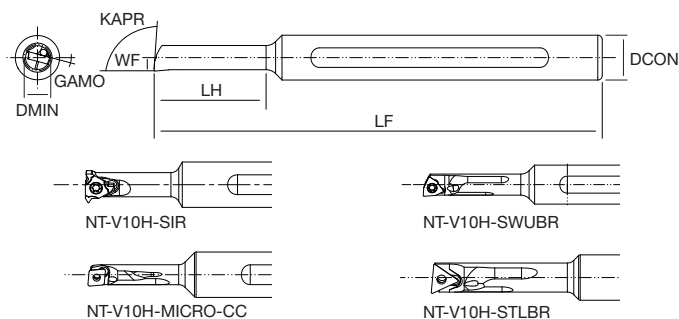
UN THREADS

TP 32	No. of passes	8÷11
TP 24	No. of passes	10÷13
TP 20	No. of passes	12÷15
TP 18	No. of passes	12÷15
TP 16	No. of passes	14÷17

MICRO VORTEX

P M K N S H
H H I I

- Small boring bars with unified dimensions for internal turning and threading operations.
- Vortex technology improve chip ejection and allow overhang until 5xD.
- Optimized coolant jet direction.



Designation		Stock L R	DMIN	DCON	WF	LF	LH	GAMO	KAPR	MIID		
MCC	NT-V10H-MICRO-CC-RH-05	●	5	10	2.5	100	20	15°	93°	MCC		
	NT-V10H-MICRO-CC-RH-06	●	6	10	3.0	100	25	13°	93°	MCC		
WBET	NT-V10H-SWUBR06-06	●	6	10	3.0	100	25	15°	95°	WBET0601		
	NT-V10H-SWUBR06-07	●	7	10	3.5	100	30	13°	95°	WBET0601		
TBET	NT-V10H-STLBR06-07	●	7	10	3.5	100	30	12°	93°	TBET0601		
	NT-V10H-STLBR06-08	●	8	10	4.0	100	35	12°	93°	TBET0601		
07IR	NT-V10H-SIR07-08	●	8	10	4.0	100	20	21°		07IRA60		

Spare Parts



	INSERT SCREW	INSERT WRENCH
NT-V10H-MICRO-CC□□□	NT-ST002	NT-FT06
NT-V10H-SWUBR06□□□	NT-ST003	NT-FT06
NT-V10H-STLBR06□□□	NT-ST003	NT-FT06
NT-V10H-SIR07-08	NT-ST022	NT-FT06



THE BOX INCLUDES:

Model	Contents	Price
VORTEX-MCCR	2 boring bars and 10 inserts MCC.R02L-PPF JP5025	€ 199,00
VORTEX-MWB06R	2 boring bars and 10 inserts WBET060102L-PPF JP5025	€ 199,00
VORTEX-MTB06R	2 boring bars and 10 inserts TBET060102L-PPF JP5025	€ 199,00
VORTEX-M07IR	1 boring bar and 5 inserts 07IRA60-TPM JP5125	€ 119,00

www.nikkotools.com



Via Don F. Tosatto, 8
30174 Mestre - Venezia
+39 041.959179
info@nikkotools.com



\$NKACT21MVX