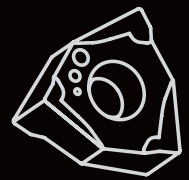




DOUBLE3GON SERIES

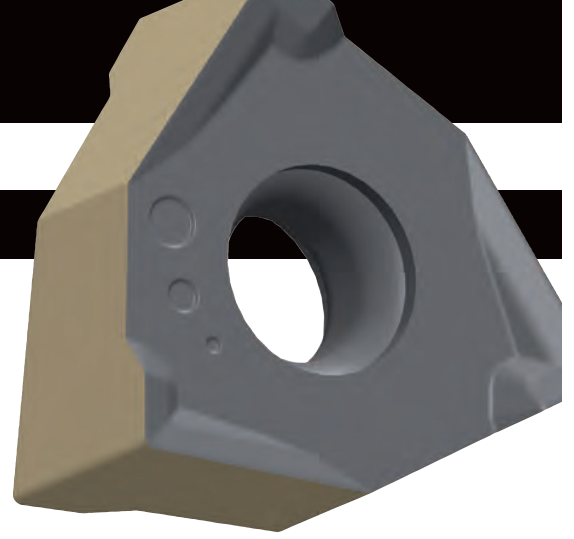
Double up your productivity on shouldering.

ISO **P** **M** **K**



6 edges

nixkoTOOLS



DOUBLE 3GON SERIES

Double up your productivity on shouldering.



- Milling system for 90° shouldering based on double-sided trigonal inserts.
- High reliability thanks to the greater thickness of WNEX inserts.
- Massive savings are enabled by the 6-cutting edges insert design.
- High versatility: 2 cutting geometries combined with 4 different carbide grades for a wide range of applications.



- Sistema di fresatura con inserti trigonali bilaterali per operazioni di spallamento retto.
- Affidabile: grazie all'elevato spessore degli inserti WNEX.
- Economico: costo tagliente molto vantaggioso grazie ai 6 posizionamenti.
- Versatile: 2 geometrie di taglio e 4 gradi di metallo duro garantiscono un vasto campo applicativo.



- Frässystem für 90 ° Eckfräsen basierend auf negative trigonale WSP.
- Hohe Zuverlässigkeit, dank der größeren Dicke der WNEX WSP.
- Große Einsparungen werden durch die 6-Schneiden erreicht.
- Hohe Vielseitigkeit: 2 Schneidgeometrien kombiniert mit 4 verschiedenen Hartmetallsorten für eine Vielzahl von Anwendungen.



- Système de fraisage avec plaquettes triangulaires bilatérales pour des opérations d'épaulement droit.
- Fiable: grâce à l'épaisseur de la plaquette WNEX.
- Economique: coût par arrête très avantageux grâce aux 6 cotés interchangeables.
- Polyvalent: 2 géométries de coupe combinées à 4 nuances de carbure garantissent un large champ d'application.

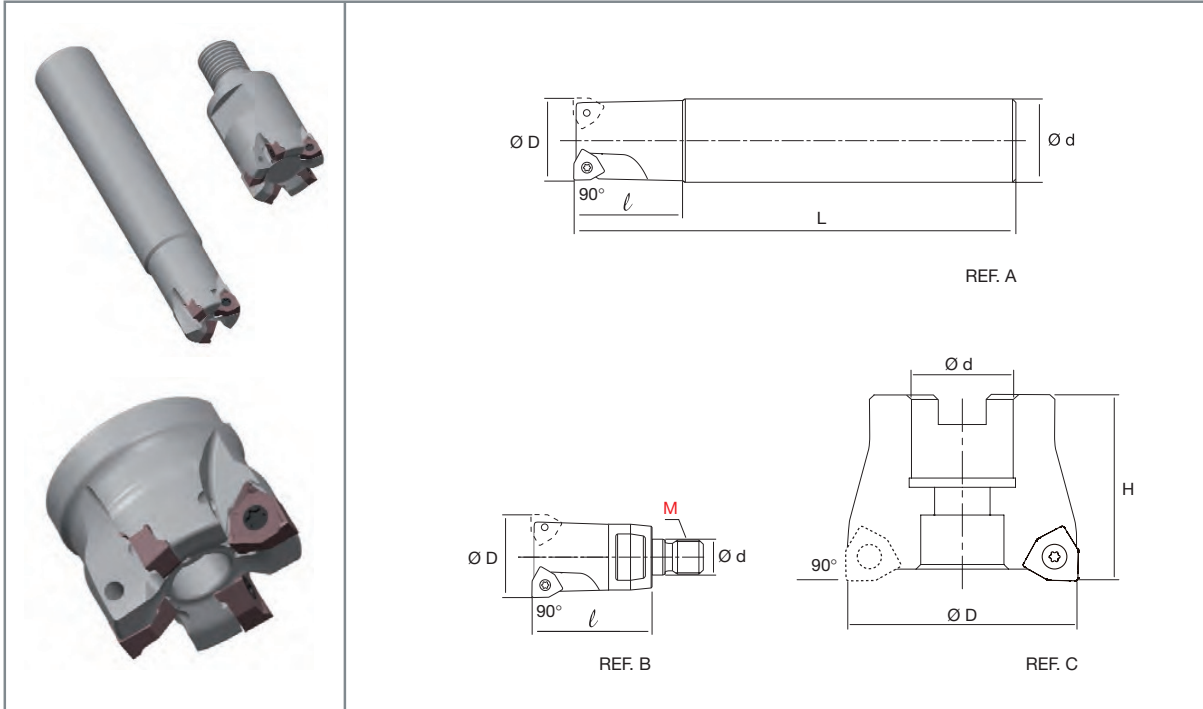


- Sistema de fresado con placas trigonales de doble cara para operaciones en escuadra.
- Fiable: gracias al espesor de las placas WNEX.
- Económico: costo por corte muy ventajoso gracias a la 6 posiciones.
- 2 geometrías de corte y 4 grados de metal duro ofrecen una amplia gama de aplicaciones.



- Треугольные двухсторонние пластины для фрезерования по уступу с углом 90°.
- Повышенная надежность благодаря большей толщине WNEX пластин.
- Значительная экономия благодаря наличию 6-ти режущих кромок.
- Широкая область применения обеспечивается наличием 2-х режущих геометрий и 4-мя сплавами.

HOLDERS



WNEX	DESCRIPTION	STOCK	DIMENSIONS							REF	Drip	Cutter	Drill Bit	TORQUE Nm				
			ØD	Z	Ød	L	l	H										
WNEX0403	NT-WX04H	D020-M10-Z3	●	20	3	10.5	-	28	-	B	✓	NT-ST018	NT-FTB08	1.2				
		D020-S20-Z3	●	20	3	20	110	28	-	A	✓	NT-ST018	NT-FTB08	1.2				
		D025-M12-Z4	●	25	4	12.5	-	30	-	B	✓	NT-ST018	NT-FTB08	1.2				
		D025-S25-Z4	●	25	4	25	120	30	-	A	✓	NT-ST018	NT-FTB08	1.2				
		D032-M16-Z5	●	32	5	16.5	-	40	-	B	✓	NT-ST018	NT-FTB08	1.2				
		D032-S32-Z5	●	32	5	32	130	40	-	A	✓	NT-ST018	NT-FTB08	1.2				
		D040-F16-Z7	●	40	7	16	-	-	40	C	✓	NT-ST018	NT-FTB08	1.2				
		D050-F22-Z9	●	50	9	22	-	-	40	C	✓	NT-ST018	NT-FTB08	1.2				
WNEX0806	NT-WX08H	D050-F22-Z4	●	50	4	22	-	-	40	C	✓	NT-ST017	NT-FTB15	3.5				
		D050-F22-Z5	●	50	5	22	-	-	40	C	✓	NT-ST017	NT-FTB15	3.5				
		D063-F22-Z6	●	63	6	22	-	-	40	C	✓	NT-ST017	NT-FTB15	3.5				
		D080-F27-Z7	●	80	7	27	-	-	50	C	✓	NT-ST017	NT-FTB15	3.5				
		D100-F32-Z8	●	100	8	32	-	-	50	C	✓	NT-ST017	NT-FTB15	3.5				

● stock standard

DOUBLE3GON SERIES

INSERTS

DESCRIPTION							HC			
		IC	T	r	b	Ød	JP8525	JC8530	JP9525	JC7530
GP	WNEX 040304R-GP	6.72	3.30	0.4	0.90	3.10	●	●	●	●
	WNEX 080608R-GP	12.50	6.45	0.8	1.50	4.40	●	●	●	●
TE	WNEX 080608R-TE	12.50	6.45	0.8	1.50	4.40	●	●	●	●

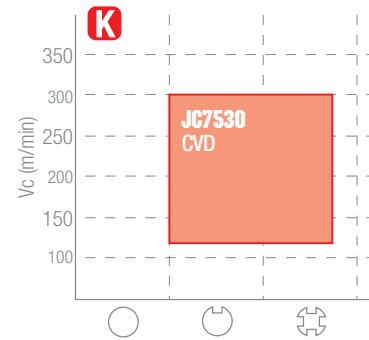
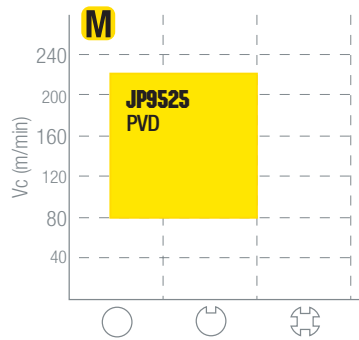
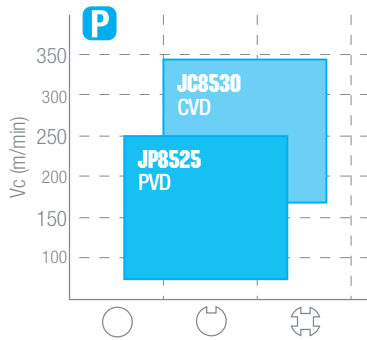
● stock standard

HC: coated carbide

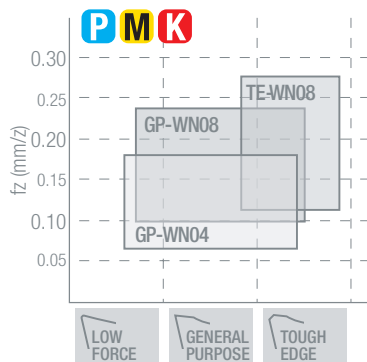
JP: PVD coating

JC: CVD coating

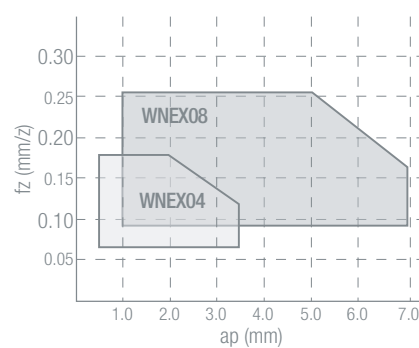
GRADES APPLICATION CHART



CHIPBREAKERS APPLICATION CHART



INSERTS APPLICATION CHART



CUTTING SPEED (Vc m/min)

Gr.	MATERIAL			JP8525	JC8530	JP9525	JC7530
P1	Free cutting steel and structural steel	Rm < 500 N/mm ²	(9SMn28 / 1.0715 / AVP)	200 ÷ 250	260 ÷ 330		
P2	Carbon steel and low alloy steel	Rm 500-700 N/mm ²	(C40 / 1.0511)	170 ÷ 210	220 ÷ 280		
P3	Medium alloy steel and heat treated steel	Rm 600-800 N/mm ²	(42CrMo4 / 1.7225)	140 ÷ 170	180 ÷ 220		
P4	High alloy steel	Rm 800-1000 N/mm ²	(100Cr6 / 1.3505)	110 ÷ 140	140 ÷ 180		
P5	Tool steel	Rm 900-1200 N/mm ²	(X210Cr12 / 1.2080 / K100)	70 ÷ 100	100 ÷ 120		
P6	High tensile strength steel	Rm 1200-1600 N/mm ²	(X2NiCrMo18.9.5 / 1.6358 / W720)	60 ÷ 80	80 ÷ 100		
M1	Ferritic stainless steel	Rm 400-700 N/mm ²	(X40Cr13 / 1.4034 / AISI420)			130 ÷ 220	
M2	Austenitic stainless steel (good machinability)	Rm 500-750 N/mm ²	(X5CrNi18.10 / 1.4301 / AISI304)			110 ÷ 180	
M3	Austenitic stainless steel (medium machinability)	Rm 550-850 N/mm ²	(X2CrNiMo18.12 / 1.4435 / AISI316L)			90 ÷ 150	
M4	Austenitic stainless steel (low machinability)	Rm 650-950 N/mm ²	(X2CrNiMoN25.7.4 / 1.4410 / Super Duplex)			80 ÷ 140	
M5	Martensitic stainless steel	Rm 800-1250 N/mm ²	(X5CrNiNb16.4 / 1.4542 / 17-4PH)			70 ÷ 120	
K1	Grey cast iron	HB 150-250	(GG-25 / 0.6025)				160 ÷ 280
K2	Nodular cast iron	HB 150-350	(GGG-50 / 0.7050)				140 ÷ 240
K3	Austenitic cast iron	HB 120-260	(GGL-NiCr20.2 / 0.6660)				120 ÷ 160
K4	ADI cast iron	HB 250-500	(GJS-1000-5 / ADI 1000)				80 ÷ 140