

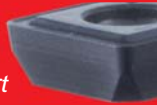
Nine⁹® 45° indexable chamfer mill

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



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



NC2032

- 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 and stainless steel, Al, Al-alloy, Brass, Bronze and most of the non-ferrous metal.



NC9071

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

Cutting Data

Work piece material		Grade of insert	Cutting Speed Vc m/min.	Feed rate mm/tooth		
Material Group	Sample Code (JIS)			N9GX04T002 Max. Chamfering 1.5 mm	N9GX060204 Max. Chamfering 2.5 mm	N9GX090308 Max. Chamfering 4 mm
Carbon steel C<0.3%	SS400	NC9071	150-250-350	0.03 ~ 0.12	0.05 ~ 0.25	0.05 ~ 0.25
Carbon steel C>0.3%	S50C, P5	NC2032	200-300-400	0.03 ~ 0.10	0.05 ~ 0.20	0.05 ~ 0.25
Low alloy steel C<0.3%	SCM420	NC9071	180-240-260	0.03 ~ 0.10	0.05 ~ 0.20	0.05 ~ 0.20
High alloy steel C>0.3%	SKD11	NC2032	120-150-200	0.03 ~ 0.10	0.05 ~ 0.15	0.05 ~ 0.15
Hardened steel <HRC50°	SKD61, <HRC50°	NC2032	80-90-100	0.03 ~ 0.10	0.03 ~ 0.12	0.05 ~ 0.15
Stainless steel	SUS304	NC9071	120-150-180	0.03 ~ 0.10	0.03 ~ 0.15	0.05 ~ 0.20
Casting iron	FC25	NC2032	120-150-180	0.03 ~ 0.10	0.05 ~ 0.15	0.05 ~ 0.20
Al, and non-ferrous metal	A6061	NC9071	200-400-600	0.03 ~ 0.15	0.05 ~ 0.25	0.05 ~ 0.25

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

Ji Jimmore International Corp.

No.120-2, Sec.2 Fusing Rd., South District,
Taichung City 40252, Taiwan
Tel: +886-(0)4-22605352 Fax: +886-(0)4-22608765
E-mail: info@jimmore.com.tw ; jimmore@seed.net.tw
<http://www.jic-tools.com.tw>

Distributor :

2009.04 Cat. No.:ICM:1000PC

45° indexable chamfer mill



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

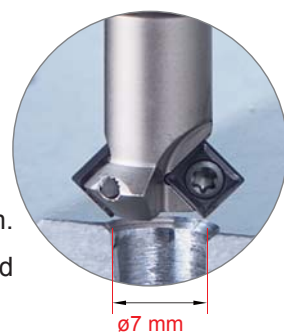


Cat. No. 01

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 $\varnothing 7$ 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.

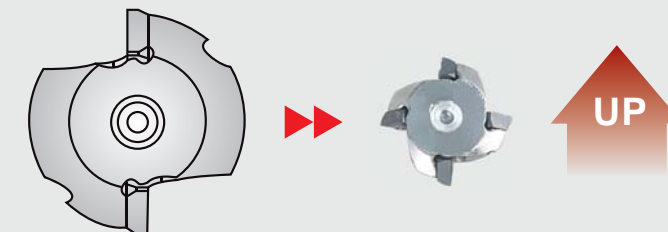


Applications:

- 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



$$\text{Feed Rate} = \text{Feed per Tooth} \times \text{Spindle Speed} \times \text{No. of Flute} \text{ mm/min.}$$

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

Cylindrical Shank Holders

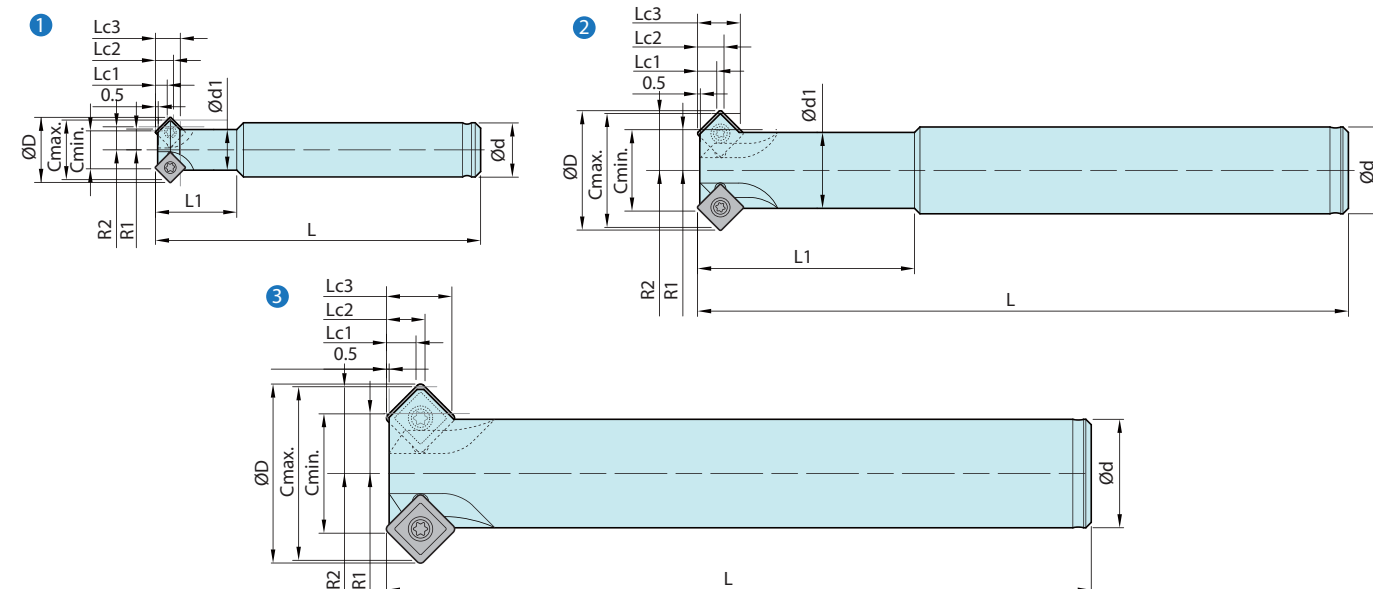


Fig.	Part No.	Type	Cmin. \varnothing	Cmax. \varnothing	Shank \varnothing	$\varnothing d1$	$\varnothing D$	R1	R2	L	L1	Lc1	Lc2	Lc3	Z	Insert Screw / Key
1	00-99616-C10	BC10-C07-60	7	11	10	7.5	12	3.8	4.3	60	15	2.2	3.3	4.6	2	N9GX04T002
2	00-99616-C20	BC12-C11-100	11	16	12	9.6	16.2	5.9	8	100	25	2.6	2.9	5.0	4	NS-18037 / NK-T6
2	00-99616-C30	BC16-C15-120	15	21	16	14	22	7.5	11.5	120	40	3.5	4.9	7.9	4	N9GX060204
2	00-99616-C40	BC20-C19-130	19	25	20	18	26	9.5	12.5	130	50	3.5	4.9	7.9	4	NS-22055 / NK-T7
3	00-99616-C50	BC20-C22-130	22	32	20	-	33	11	16	130	-	5.5	7.1	12.1	4	N9GX090308
2	00-99616-C52	BC25-C22-180	22	32	25	20	33	11	16	180	80	5.5	7.1	12.1	4	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	

