



DOUBLEREK SYSTEM

Reliable shouldering applications with superior accuracy

<h1>DRK</h1> <h2>DOUBLEREK</h2>	HC: coated carbide HF: micrograin carbide CVD: chemical vapour deposition PVD: physical vapour deposition						HF	HC	HF	HC	HF	HC															
	PVD	CVD	PVD	CVD	PVD	CVD	JP5530	JG7515	JP7525	JG8520	JP9535	JG9540															
<ul style="list-style-type: none"> Shoulder milling 90° Double-sided insert Rectangular shape with hole 4 cutting edges Large size for high depth of cut (APMX = 15 mm) High rake angle allows soft cutting action Precision ground with large wiper facet for perfect finishing 	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: 1st choice)																				
	P	60	230				150	350																			
	M	60	150				60	200	140	260																	
	K	120	350	100	240	130	250																				
	N																										
	S							40	100	40	100																
	H																										

Designation		RE	IC	S	D1	BS	Stock																				
CARBIDE 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	3.20	●	●	●	▲																	

● stock standard, ▲ upcoming introduction

CONVENTIONAL DOUBLEREK



much thicker than conventional solutions

DOUBLEREK GP

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

TE

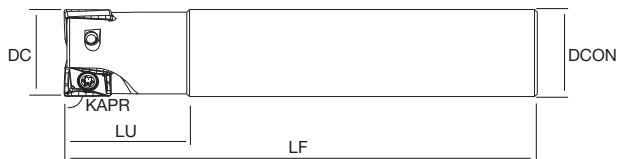
a_s	a_p	1.00	4.00	7.00
40÷100% DC	f_z	0.14	0.17	0.20
a_s	a_p	1.00	8.00	15.0
10÷30% DC	f_z	0.16	0.20	0.24
a_s	a_p	1.00	8.00	15.0
<10% DC	f_z	0.20	0.25	0.30

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

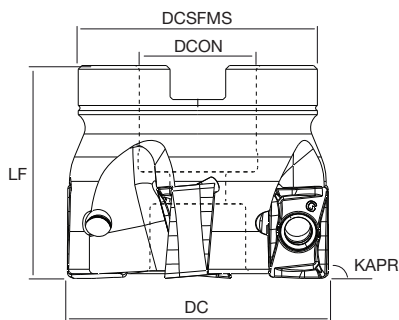
DOUBLEREK

P	M	K	N	S	H
H	I	H		I	

- Shoulder milling
- KAPR = 90°
- Internal coolant
- Economical double-sided system
- Long effective cutting edge
- Reliable and versatile system
- Stable, reliable and easy insert positioning



CYLINDRICAL



ARBOR



	Designation	Stock	DC	ZEFP	DCON	DCSFMS	LF	LU	WT	MIID		
CYLINDRICAL	NT-DRK17 D032-S32-Z02	●	32	2	32		130	45	0.8	NT-DRK17		
	NT-DRK17 D040-S32-Z03	●	40	3	32		150	40	1.1	NT-DRK17		
ARBOR	NT-DRK17 D050-F22-Z04	●	50	4	22	45	40		0.4	NT-DRK17		
	NT-DRK17 D063-F22-Z05	●	63	5	22	55	40		0.7	NT-DRK17		
	NT-DRK17 D063-F22-Z06	●	63	6	22	55	40		0.7	NT-DRK17		
	NT-DRK17 D080-F27-Z06	●	80	6	27	60	50		1.3	NT-DRK17		
	NT-DRK17 D080-F27-Z07	●	80	7	27	60	50		1.3	NT-DRK17		
	NT-DRK17 D100-F32-Z07	●	100	7	32	78	50		1.9	NT-DRK17		
	NT-DRK17 D100-F32-Z09	●	100	9	32	78	50		1.9	NT-DRK17		
	NT-DRK17 D125-F40-Z08	●	125	8	40	80	63		2.9	NT-DRK17		
NT-DRK17 D125-F40-Z10	●	125	10	40	80	63		2.9	NT-DRK17			

Spare Parts

INSERT SCREW



INSERT WRENCH



NT-DRK17 D□□□

NT-ST037

NT-FTB15



**large contact surfaces
for stable and reliable operation**

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