

New Product Information

06/2021
NPI

REKPLUS JP5540

Shoulder Milling



nikkoTOOLS



RKP11

REKPLUS

HF: micrograin carbide
PVD: physical vapour deposition

JP5540

- Shoulder milling 90°
- Positive helical inserts for low cutting force and high accuracy machining
- Rectangular shape with hole
- 2 cutting edges
- JP5540 state of the art PVD multilayer coating on a tough micrograin substrate
- Multi-material universal use ISO P - ISO M - ISO S
- Maximum depth of cut APMX = 8 mm

Stable machining, light cut: ● 1st choice ○ suitable
General machining, medium cut: ● 1st choice ○ suitable ●
Unstable machining, heavy cut: ⚙ 1st choice ⚙ suitable ⚙

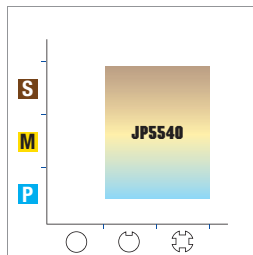
Dimensions ISO **Vc(m/min) - suggested cutting speed range (bold: 1st choice)**

ISO	Vc(m/min)
P	60, 220
M	60, 200
K	
N	
S	40, 100
H	

Designation		RE	IC	S	D1	AN	Stock													
HGP general purpose	NT-RKP11R08M-HGP	0.8	6.35	3.50	2.80	11°	●													
HSC low cutting force	NT-RKP11R08M-HSC	0.8	6.35	3.50	2.80	11°	●													

● stock standard

APPLICATION CHART



HGP general purpose

40÷100% DC	a_e	a_p	1.00 2.50 4.00
	f_z		0.06 0.09 0.12
10÷30% DC	a_e	a_p	1.00 4.50 8.00
	f_z		0.08 0.11 0.14
<10% DC	a_e	a_p	1.00 4.50 8.00
	f_z		0.10 0.15 0.20

HSC low cutting force

40÷100% DC	a_e	a_p	1.00 2.50 4.00
	f_z		0.04 0.07 0.10
10÷30% DC	a_e	a_p	1.00 4.50 8.00
	f_z		0.06 0.09 0.12
<10% DC	a_e	a_p	1.00 4.50 8.00
	f_z		0.08 0.12 0.16

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)



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