

MICROVORTEX 



# MICROVORTEX

Turning and Threading of small bores

**Choose your favorite set!**

- Turning box € 199
- Threading box € 119

**nikko**TOOLS

<h1>MICRO</h1> <h2>TURNING-THREADING</h2> <ul style="list-style-type: none"> <li>Small insert series for internal turning and threading applications.</li> <li>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.</li> <li>Turning inserts are combined with PPF ground chipbreaker, a very sharp solution recommended for super-finishing applications.</li> <li>Threading inserts are available with TPM chipbreaker that guarantees perfect chip control even in very small hole machining.</li> </ul>	HF: micrograin carbide HT: cermet PVD: physical vapour deposition	HT	HF PVD	HF PVD													
	Stable machining, light cut  1 <sup>st</sup> choice  suitable General machining, medium cut  1 <sup>st</sup> choice  suitable Unstable machining, heavy cut  1 <sup>st</sup> choice  suitable	<b>JU4015</b>	<b>JP5025</b>	<b>JP5125</b>													
		<b>Dimensions</b> ISO <b>Vc(m/min) - suggested cutting speed range (bold: 1<sup>st</sup> choice)</b>															
RE IC S D1 <b>THICKNESS AND HOLE</b> AN <b>CLEARANCE ANGLE</b>		<b>P</b> 200 60 60 380 180 180 <b>M</b> 160 60 60 280 120 120 <b>K</b> 200 80 80 400 150 150 <b>N</b> <b>S</b> 30 30 60 60 <b>H</b>															

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

● stock standard

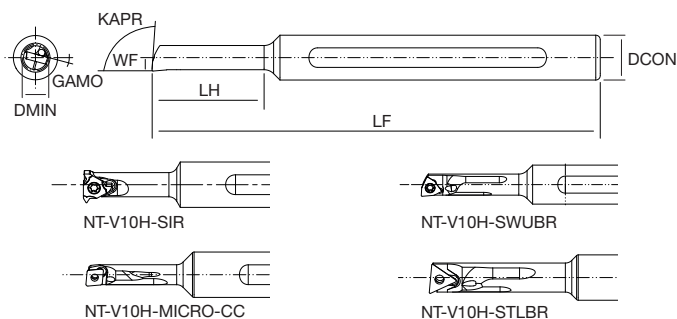
PPF	M THREADS			UN THREADS					
RE 0.2	$a_p$	0.05	<b>0.30</b>	TP 0.50	No. of passes	8÷11	TP 32	No. of passes	8÷11
	$f_n$	0.04	<b>0.06</b>	TP 0.75	No. of passes	8÷11	TP 24	No. of passes	10÷13
RE 0.4	$a_p$	0.05	<b>0.30</b>	TP 1.00	No. of passes	10÷13	TP 20	No. of passes	12÷15
	$f_n$	0.06	<b>0.08</b>	TP 1.25	No. of passes	12÷15	TP 18	No. of passes	12÷15
				TP 1.50	No. of passes	12÷15	TP 16	No. of passes	14÷17

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

### 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:



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

[www.nikkotools.com](http://www.nikkotools.com)



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