



# REK PLUS SERIES

The all-around solution for shouldering.

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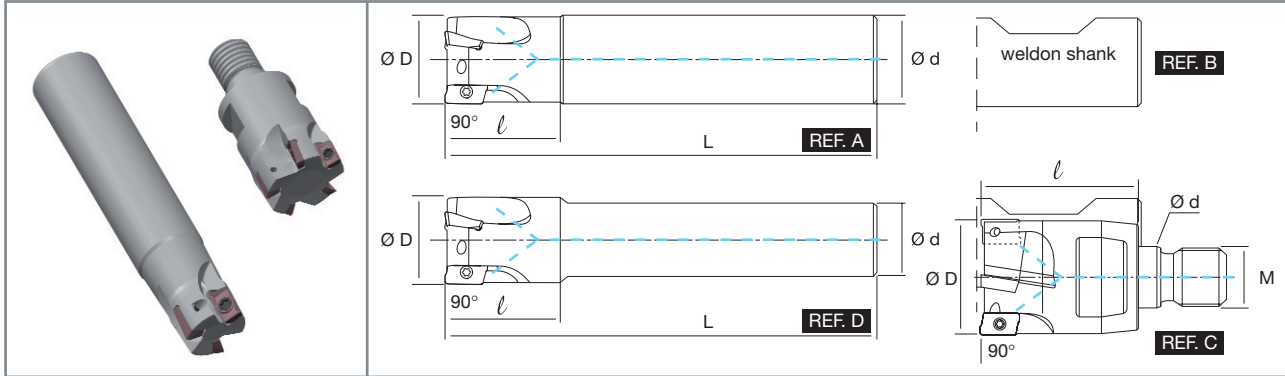


New **helical** type for extremely high performance

**nixko**TOOLS

# REKPLUS SERIES

## HOLDERS



INSERTS	DESCRIPTION				STOCK	DIMENSIONS					REF	☑	🔩	🔧	TORQUE Nm
	NEW	OLD	ØD	Z		Ød	L	l							
NT-RKP11	NT-RKP11	D0155-S16-Z2	NT-AP11H	D0155-S16-Z2	★	15.5	2	16	100	28	A	☑	NT-ST018	NT-FTB08	1.20
		D016-S16-Z2		●	16	2	16	100	28	A	☑	NT-ST018	NT-FTB08	1.20	
		D016-S16-Z2-L150		●	16	2	16	150	28	A	☑	NT-ST018	NT-FTB08	1.20	
		D016-W16-Z2-L080		●	16	2	16	80	28	B	☑	NT-ST018	NT-FTB08	1.20	
		D020-S16-Z3		●	20	3	16	110	28	D	☑	NT-ST018	NT-FTB08	1.20	
		D020-S20-Z3		●	20	3	20	110	28	A	☑	NT-ST018	NT-FTB08	1.20	
		D020-S20-Z3-L200		●	20	3	20	200	28	A	☑	NT-ST018	NT-FTB08	1.20	
		D020-W20-Z3-L090		●	20	3	20	90	28	B	☑	NT-ST018	NT-FTB08	1.20	
		D025-S20-Z3		●	25	3	20	120	35	D	☑	NT-ST018	NT-FTB08	1.20	
		D025-S25-Z3		●	25	3	25	120	35	A	☑	NT-ST018	NT-FTB08	1.20	
		D025-S25-Z4		●	25	4	25	120	35	A	☑	NT-ST018	NT-FTB08	1.20	
		D025-W25-Z4-L100		●	25	4	25	100	35	B	☑	NT-ST018	NT-FTB08	1.20	
		D032-S25-Z4		●	32	4	25	130	35	D	☑	NT-ST018	NT-FTB08	1.20	
		D032-S32-Z4		★	32	4	32	130	35	A	☑	NT-ST018	NT-FTB08	1.20	
D032-S32-Z5	★	32	5	32	130	35	A	☑	NT-ST018	NT-FTB08	1.20				
NT-RKP16	NT-RKP16	D025-S25-Z2	NT-AP16H	D025-S25-Z2	★	25	2	25	120	40	A	☑	NT-ST019	NT-FTB15	3.50
		D032-S32-Z3		★	32	3	32	130	45	A	☑	NT-ST017	NT-FTB15	3.50	
		D040-S32-Z4		★	40	4	32	150	40	A	☑	NT-ST017	NT-FTB15	3.50	

● stock standard; ★ upcoming introduction

## MODULAR TYPE

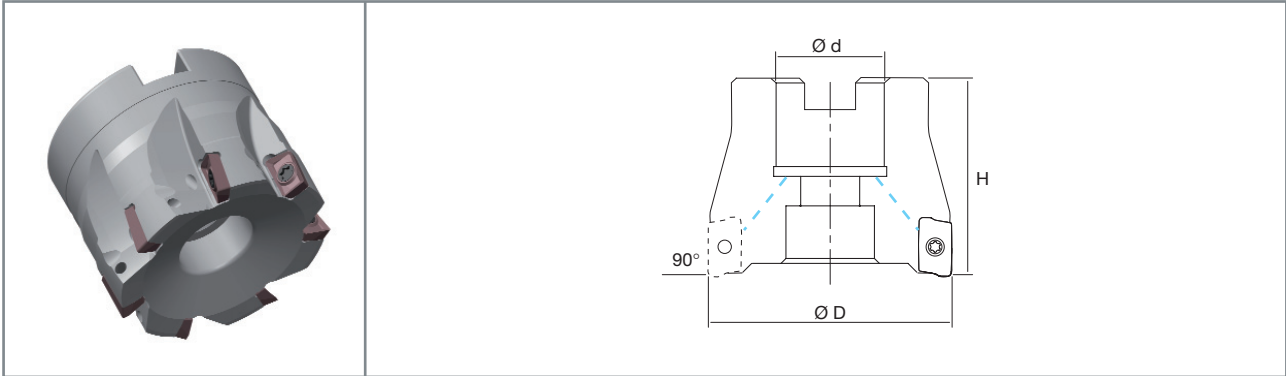
INSERTS	DESCRIPTION				STOCK	DIMENSIONS					REF	☑	🔩	🔧	TORQUE Nm
	NEW	OLD	ØD	Z		Ød	M	l							
NT-RKP11	NT-RKP11	D016-M08-Z2	NT-AP11H	D016-M08-Z2	★	16	2	8.5	M8	25	C	☑	NT-ST018	NT-FTB08	1.20
		D020-M10-Z2		★	20	2	10.5	M10	30	C	☑	NT-ST018	NT-FTB08	1.20	
		D020-M10-Z3		●	20	3	10.5	M10	30	C	☑	NT-ST018	NT-FTB08	1.20	
		D025-M12-Z3		★	25	3	12.5	M12	35	C	☑	NT-ST018	NT-FTB08	1.20	
		D025-M12-Z4		★	25	4	12.5	M12	35	C	☑	NT-ST018	NT-FTB08	1.20	
		D032-M16-Z4		★	32	4	16.5	M16	43	C	☑	NT-ST018	NT-FTB08	1.20	
		D032-M16-Z5		●	32	5	16.5	M16	43	C	☑	NT-ST018	NT-FTB08	1.20	

● stock standard; ★ upcoming introduction



We will continue to supply the equivalent milling cutters without coolant holes (description: NT-AP11 and NT-AP16) until availability of items marked with ★.

HOLDERS



INSERTS	DESCRIPTION				STOCK	DIMENSIONS				Lubrication	Screw	Key	TORQUE Nm
	NEW		OLD			ØD	Z	Ød	H				
NT-RKP11	NT-RKP11	D040-F16-Z5	NT-AP11H	D040-F16-Z5	●	40	5	16	40	✓	NT-ST018	NT-FTB08	1.20
		D040-F16-Z6		D040-F16-Z6	●	40	6	16	40	✓	NT-ST018	NT-FTB08	1.20
		D050-F22-Z5		D050-F22-Z5	★	50	5	22	40	✓	NT-ST018	NT-FTB08	1.20
		D050-F22-Z7		D050-F22-Z7	★	50	7	22	40	✓	NT-ST018	NT-FTB08	1.20
		D063-F22-Z6		D063-F22-Z6	●	63	6	22	40	✓	NT-ST018	NT-FTB08	1.20
		D063-F22-Z8		D063-F22-Z8	●	63	8	22	40	✓	NT-ST018	NT-FTB08	1.20
		D080-F27-Z7		D080-F27-Z7	●	80	7	27	50	✓	NT-ST018	NT-FTB08	1.20
		D080-F27-Z10		D080-F27-Z10	●	80	10	27	50	✓	NT-ST018	NT-FTB08	1.20
NT-RKP16	NT-RKP16	D040-F16-Z4	NT-AP16H	D040-F16-Z4	●	40	4	16	40	✓	NT-ST017	NT-FTB15	3.50
		D050-F22-Z4		D050-F22-Z4	★	50	4	22	50	✓	NT-ST017	NT-FTB15	3.50
		D050-F22-Z5		D050-F22-Z5	●	50	5	22	50	✓	NT-ST017	NT-FTB15	3.50
		D063-F22-Z5		D063-F22-Z5	●	63	5	22	50	✓	NT-ST017	NT-FTB15	3.50
		D063-F22-Z6		D063-F22-Z6	★	63	6	22	50	✓	NT-ST017	NT-FTB15	3.50
		D080-F27-Z6		D080-F27-Z6	★	80	6	27	50	✓	NT-ST017	NT-FTB15	3.50
		D080-F27-Z8		D080-F27-Z8	★	80	8	27	50	✓	NT-ST017	NT-FTB15	3.50
		D100-F32-Z8		D100-F32-Z8	●	100	8	32	50	✓	NT-ST017	NT-FTB15	3.50

● stock standard; ★ upcoming introduction



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# REKPLUS SERIES

## INSERTS

		DESCRIPTION		RADIUS	HC							HW	HT			
					JP5520	JP5530	JP8625	JP9535	JP9635	JC7515	JP7615	JP7525	JU6520	JU4525		
					NEW	OLD										
STRAIGHT TYPE	SC		NT-RKP 11R08M-SC	APMT 113508ER-SC	0.8	●	●		★							
			NT-RKP 16R08M-SC	APMT 160408ER-SC	0.8	●	●		★							
	GP		NT-RKP 11R08M-GP	APMT 113508ER-GP	0.8	●	●		★		●		●		●	
			NT-RKP 16R08M-GP	APMT 160408ER-GP	0.8	●	●		★		●		●		●	
	TE		NT-RKP 11R08M-TE	APMT 113508ER-TE	0.8	●	●					●				
			NT-RKP 16R08M-TE	APMT 160408ER-TE	0.8	●	●					●				
	AL		POLISHED	NT-RKP 11R04G-AL	APGT 113504FR-AL	0.4								●		
				11R08G-AL	113508FR-AL	0.8								●		
				NT-RKP 16R08G-AL	APGT 160408FR-AL	0.8								●		
	HELICAL TYPE	HSC		New	NT-RKP 11R04M-HSC	-	0.4			★		★				
				11R08M-HSC	-	0.8			●		●					
				11R12M-HSC	-	1.2				★		★				
				NT-RKP 16R08M-HSC	-	0.8				●		●				
				16R12M-HSC	-	1.2				★		★				
HGP			New	NT-RKP 11R04M-HGP	-	0.4			★		★					
				11R08M-HGP	-	0.8			●		●		●			
				11R12M-HGP	-	1.2				★		★				
				11R16M-HGP	-	1.6				★		★				
				NT-RKP 16R08M-HGP	-	0.8				●		●		●		
				16R12M-HGP	-	1.2				★		★				
				16R16M-HGP	-	1.6				★		★				
				16R20M-HGP	-	2.0				★		★				
	16R31M-HGP	-	3.1				★		★							

● stock standard; ★ upcoming introduction

HC: coated carbide

JP: PVD coating

HW: uncoated carbide

JC: CVD coating

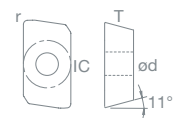
HT: cermet

JU: uncoated

## A NEW GENERATION OF INSERTS FOR EXTREMELY HIGH PERFORMANCE

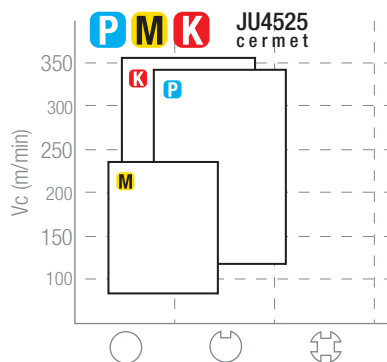
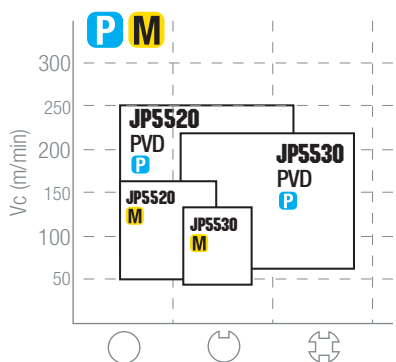
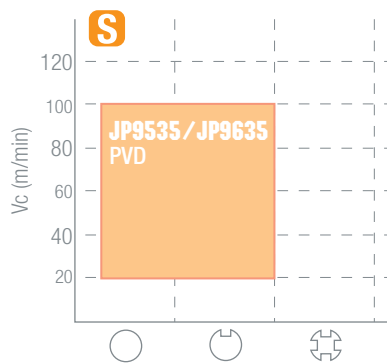
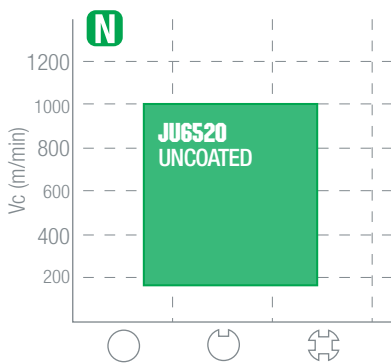
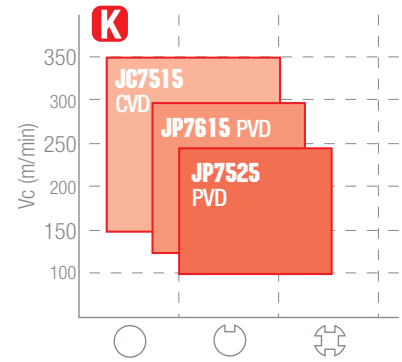
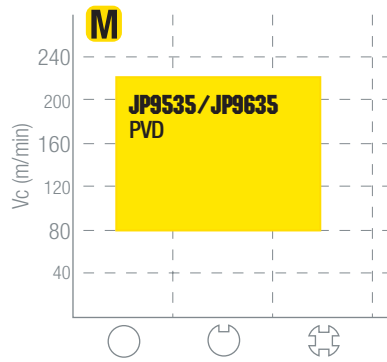
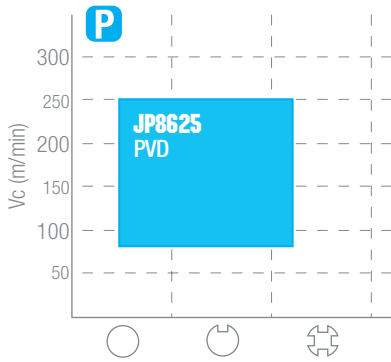
HELICAL TYPE	CUTTING EDGE PROFILE	NO SIGNS ON SHOULDERING WALL	EXCELLENT SURFACE FINISHING

(material: C40; Vc: 180m/min; fz: 0.08mm/z; ap: 5mm; ae: 0.6mm)



NT-RKP11	NT-RKP16
IC 6.35	IC 9.53
T 3.50	T 4.76
Ød 2.80	Ød 4.50

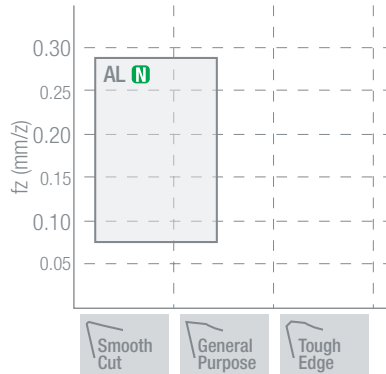
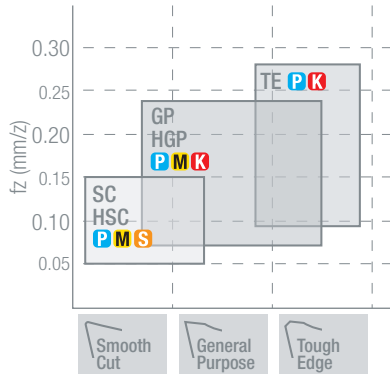
GRADES APPLICATION CHART



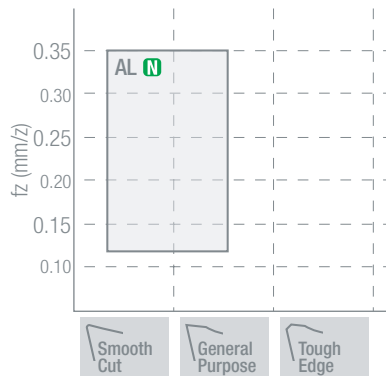
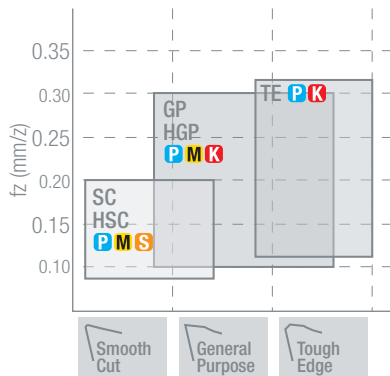
# REKPLUS SERIES

## CHIPBREAKERS APPLICATION CHART

### NT-RKP11



### NT-RKP16



JU4525 cermet → fz-20%  
Please reduce the feed rate by 20%

CUTTING SPEED (Vc m/min)

Gr.	MATERIAL		
P1	Free cutting steel and structural steel	Rm < 500 N/mm <sup>2</sup>	(9SMn28 / 1.0715 / AVP)
P2	Carbon steel and low alloy steel	Rm 500-700 N/mm <sup>2</sup>	(C40 / 1.0511)
P3	Medium alloy steel and heat treated steel	Rm 600-800 N/mm <sup>2</sup>	(42CrMo4 / 1.7225)
P4	High alloy steel	Rm 800-1000 N/mm <sup>2</sup>	(100Cr6 / 1.3505)
P5	Tool steel	Rm 900-1200 N/mm <sup>2</sup>	(X210Cr12 / 1.2080 / K100)
P6	High tensile strength steel	Rm 1200-1600 N/mm <sup>2</sup>	(X2NiCrMo18.9.5 / 1.6358 / W720)
M1	Ferritic stainless steel	Rm 400-700 N/mm <sup>2</sup>	(X40Cr13 / 1.4034 / AISI420)
M2	Austenitic stainless steel (good machinability)	Rm 500-750 N/mm <sup>2</sup>	(X5CrNi18.10 / 1.4301 / AISI304)
M3	Austenitic stainless steel (medium machinability)	Rm 550-850 N/mm <sup>2</sup>	(X2CrNiMo18.12 / 1.4435 / AISI316L)
M4	Martensitic stainless steel	Rm 650-950 N/mm <sup>2</sup>	(X2CrNiMoN25.7.4 / 1.4410 / Super Duplex)
M5	PH stainless steel	Rm 800-1250 N/mm <sup>2</sup>	(X5CrNiNb16.4 / 1.4542 / 17-4PH)
K1	Grey cast iron	HB 150-250	(GG-25 / 0.6025)
K2	Nodular cast iron	HB 150-350	(GGG-50 / 0.7050)
K3	Austenitic cast iron	HB 120-260	(GGL-NiCr20.2 / 0.6660)
K4	ADI cast iron	HB 250-500	(GJS-1000-5 / ADI 1000)
N1	Aluminium alloys < 12% Si		(AlMgSi0.5 / 3.3206)
N2	Aluminium alloys > 12% Si		(AlSi12 / 3.2582)
N3	Copper alloys		(E-Cu57 / 2.0060)
N4	Brass alloys and bronze alloys		(CuZn20Al2 / 2.0460)
S1	Heat resistant super alloys HRSA (good machinability)	HRC < 25	(NiCr17Mo17FeW / 2.4802 / Hastelloy)
S2	Heat resistant super alloys HRSA (medium machinability)	HRC 25-35	(NiCr20Ti / 2.4630 / Nimonic 80)
S3	Heat resistant super alloys HRSA (low machinability)	HRC 35-45	(NiCr19Fe19NbMo / 2.4668 / Inconel 718)
S4	Low alloy titanium		(Ti99.6 / 3.7055 / Titanium grade 3)
S5	High alloy titanium		(Ti5Al2.5Sn / 3.7115 / Titanium grade 6)

Gr.	JP5520	JP5530	JP8625	JP9535	JP9635	JC7515	JP7615	JP7525	JU6520	JU4525
P1	200 ÷ 250	180 ÷ 230	200 ÷ 250							250 ÷ 350
P2	160 ÷ 220	150 ÷ 210	160 ÷ 220							220 ÷ 300
P3	140 ÷ 200	120 ÷ 180	140 ÷ 200							200 ÷ 280
P4	120 ÷ 160	100 ÷ 150	120 ÷ 160							160 ÷ 220
P5	100 ÷ 140	80 ÷ 130	100 ÷ 140							
P6	80 ÷ 120	60 ÷ 110	80 ÷ 120							
M1	100 ÷ 160	90 ÷ 150		120 ÷ 220	120 ÷ 220					140 ÷ 240
M2	80 ÷ 140	80 ÷ 130		100 ÷ 200	100 ÷ 200					120 ÷ 200
M3	60 ÷ 120	60 ÷ 100		120 ÷ 180	120 ÷ 180					100 ÷ 180
M4				90 ÷ 150	90 ÷ 150					
M5				80 ÷ 140	80 ÷ 140					
K1						200 ÷ 350	160 ÷ 250	150 ÷ 240		250 ÷ 380
K2						180 ÷ 280	140 ÷ 220	120 ÷ 200		200 ÷ 300
K3						140 ÷ 200	120 ÷ 160	100 ÷ 150		160 ÷ 220
K4						120 ÷ 180				
N1									400 ÷ 1000	
N2									300 ÷ 600	
N3									300 ÷ 500	
N4									200 ÷ 400	
S1				30 ÷ 60	30 ÷ 60					
S2				30 ÷ 50	30 ÷ 50					
S3				20 ÷ 40	20 ÷ 40					
S4				50 ÷ 100	50 ÷ 100					
S5				40 ÷ 80	40 ÷ 80					

