Nine9®

Cat.14

www.jic-tools.com.tw

NC Spot Drill

i - Center

Engraving

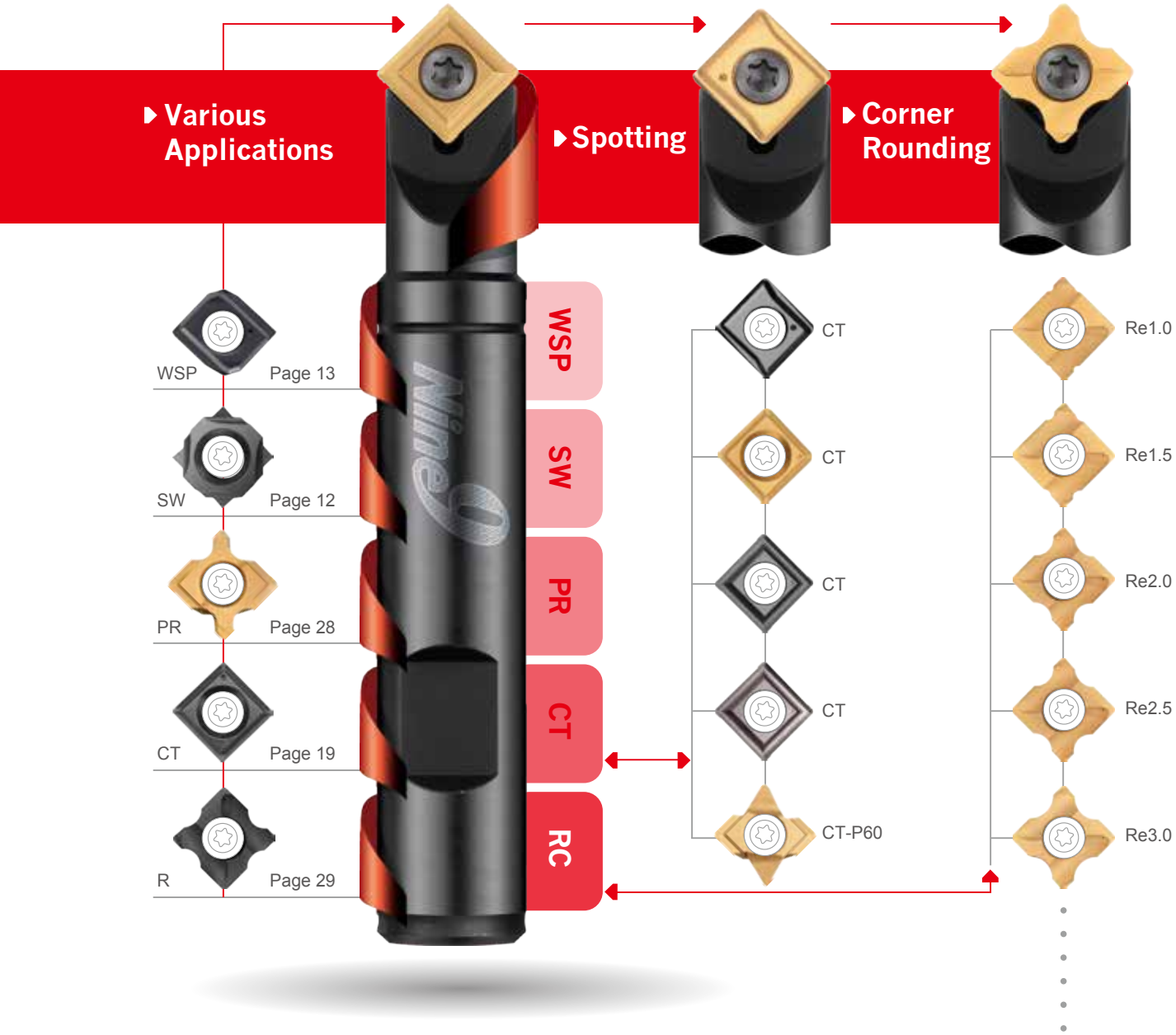
Chamfer Mill

CUTTING TOOLS & TOOL HOLDERS

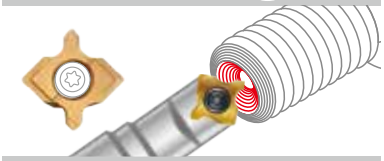
No Need To Choose Nine9 Does It All! >>

Cost Saving | Time Saving | Highly Efficient | Long Tool Life

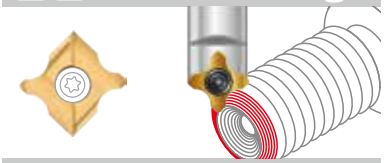
Various inserts can fit on same holder



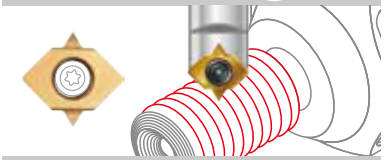
A Center drilling



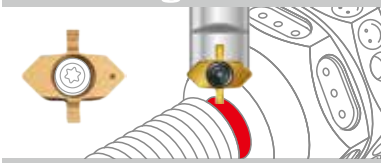
B G Corner rounding



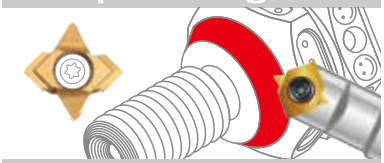
C Thread turning



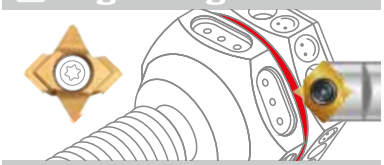
D Gooving



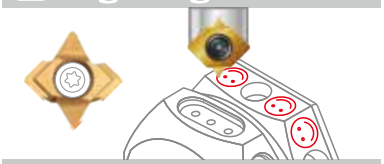
E Taper turning



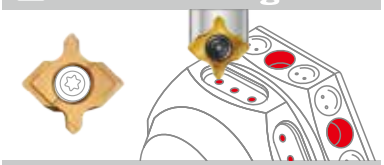
F V-grooving



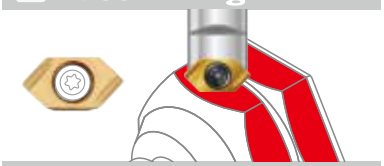
H Engraving



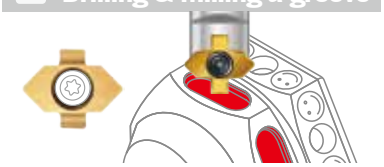
I Center drilling



J Face milling



K Drilling & milling a groove



▲Multifunctional Cutting Tool

- Universal, easy handling and material saving!
- One holder to cover multiple applications!

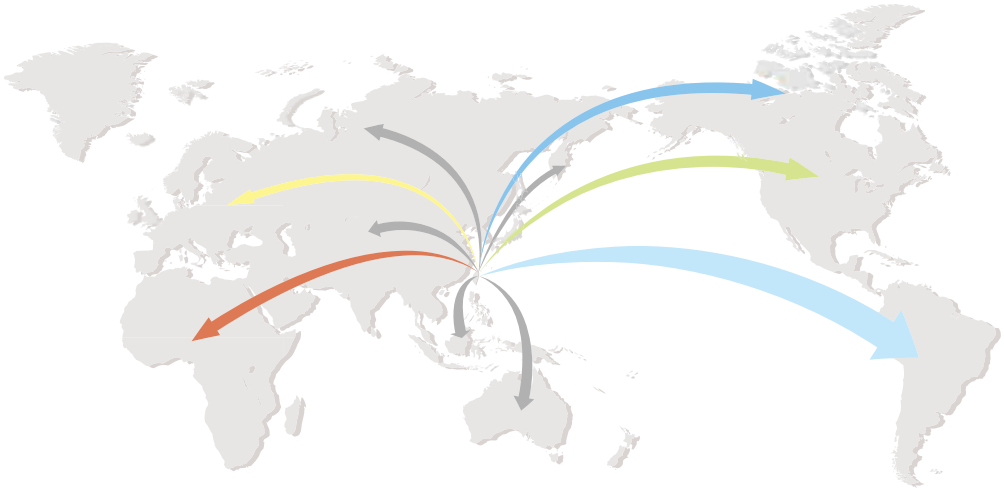
Global Marketing >>

We have invested resources in the design & Manufacture of inserted cutters

Our innovative tooling design upgrades productivity and competitive capability while reducing production requirements in a wide range of industries.

The tooling system is designed to benefit users of machining centers and CNC lathe, turning center and special purpose machines.

Our outstanding R&D capabilities combined with fast delivery provide a strong competitive edge.



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- DC Slim Chuck
- Extension Bar
- ISO 20/25 Tool Holder
- Center Height Adjusting Sleeve
- Torque Screwdriver

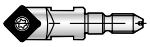
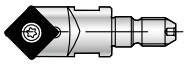
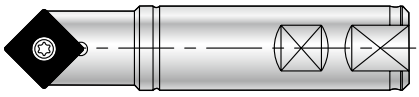
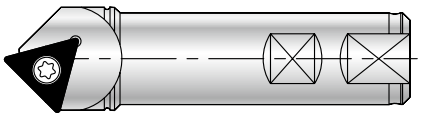
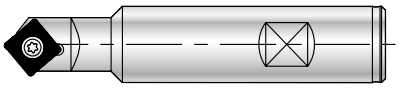
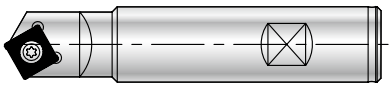
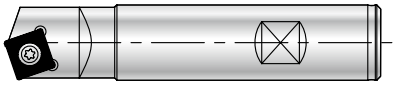
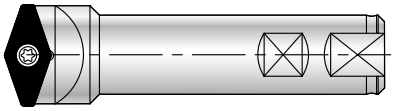
Nine9® Inserts >> Quick Pick

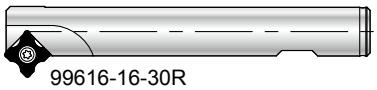
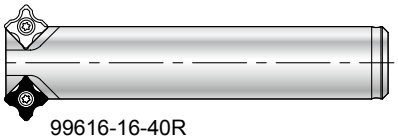
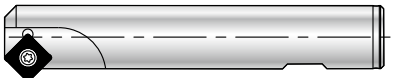
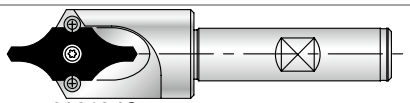
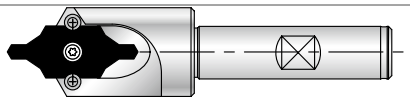
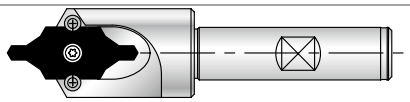
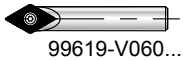
Nine9 inserts apply for moden machining by its special geometry which is able to run at higher speed and feed. In addition,
the indexable insert eliminates the tool's changing time.
Carbide insert with latest coating technogy extends tool life dramatically.
Nine9 insert helps you to save money and increase productivi.

Products	Grade	Coating	Steel	Stainless Steel	Cast Iron	Non-Ferrous	Hardened Steel Up to 56 HRC
NC Spot Drill	NC10	TiAlN		●	●	◎	
	NC40	TiN	●	○	◎		
	NC2071	TiN	●	◎	○	◎	
	NC9076	DLC		◎		●	
	NC60	Cermet	◎				●
Corner Rounding	NC2071	TiN	●	○	●		
	NC9036	DLC		●		●	
i-Center	NC2033	TiAlN	●	○	●		○
Engraving	NC2032	TiAlN	●	○	●		
	NC2071	TiN	◎	●		◎	
	NC9031	TiN		◎		●	
	NC2035	ALDURA	◎		○		●
	NC9036	DLC		◎		●	
Chamfer Mill	NC2032	TiAlN	●	○	●		◎
	NC9071	TiN	○	●		●	

● Best ◎ Suit ○ Possible

Features
Universal grade for non-ferrous metal, cast iron and stainless steel. General purpose, fully ground cutting edge and relief angle.
Universal grade for all unhardened steel. General purpose, fully ground cutting edge and relief angle .
Universal grade for all unhardened steel. The cutting geometry has been designed to optimize the tool's performance and to use in high speed machining.
For non-ferrous material such as aluminum, acrylic, titanium, brass, copper and long cutting chip material. High positive geometry and sharp edge produces excellent surface finish.
For hardened steel up to 56HRC. Cermet insert reduces heat and low tool wear at the cutting edge.
Universal grade for all unhardened steel and cast iron. The cutting geometry has been designed to optimize the tool's performance.
For non-ferrous material such as aluminum, acrylic, titanium, brass, cooper and stainless steel. High positive geometry and sharp edge produces excellent surface finish.
For carbon steel, alloy steel, high alloy steel and cast iron. 2 Cutting flutes design same as carbide center drill for high performance speed and feed rate.
For all kind of steel from 30~50 HRC, carbon steel, alloy steel and cast iron. TiAlN coating provides a longer tool life.
Universal grade for all kind of steel<30 HRC, non-ferrous metal and stainless steel. The cutting geometry of this insert has been designed with strong tip.
For non ferrous metal, aluminum, brass, copper, plastic, acrylic and stainless steel. Very sharp edge for thin engraving.
For steel with heat treatment from 56 HRC. Latest ALDURA coating to reduce heat and low tool wear.
For non-ferrous material, titanium and stainless steel. Very sharp edge for thin engraving.
For carbon steel, alloy steel, cast iron and hardened steel up to 56 HRC. Upgraded AlTiN coating provides a very long tool life.
For non-ferrous metal, aluminum, al-alloy, brass, copper and stainless steel. Very shape produces excellent surface finish.

Angle	Holder	Inserts	D min.	D max.	Spotting	Chamfering	Grooving	Engraving	Drilling	Page
	NC Spot Drill									
60°	99616-09V	V9MT0802	1	9	•	•	•	•		16
	99616-13V	V9MT12T3	2	13	•	•	•	•		16
82°	99619-V082-3/8	V0820802	2	9	•	•	•	•		17
	99619-V082-5/8	V08212T3	2	14	•	•	•	•		17
90°	99616-06-6...	N9MT05T1	1	6	•	•		•		18
	99616-10...  99616-10-M5	N9MT0802	2	10	•	•	•	•		19
	99616-14...  99616-14-M8	N9MT11T3	3	14	•	•	•	•		21
	 99616-22	N9MT1704	3	22	•	•	•			23
	 99616-25-CT28	N9MT2204	4	25	•	•				24
100°	 99616-20-100		3	16	•	•				25
120°	 99616-20-120	N9MT11T3	3	17	•	•				
142°	 99616-20-142...		3	18	•	•				
	 99619-V142...	V1421604	2	32	•					27
New 142° + 90°	99616-10 / 14 / 22 ...	WSP / M4~M16	3.3	20	•	•	•			13

Angle	Holder	Inserts	D min.	D max.	Spotting	Chamfering	Grooving	Engraving	Drilling	Page
Corner Rounding										
	99616-10..99616-14...RC	N9MT05/N9MT11..RC (2 Cutting edges)	R0.5 R1.0	R1.0 R3.0		•				32
	99616-22...RC	N9MT1704RC (2 Cutting edges)	R4.0	R6.0		•				33
	99616-16-25R	N9MT11T3R (4 Cutting edges)	R1.0	R3.0		•				34
	 99616-16-30R					•				
	 99616-16-40R					•				
Large 45° Chamfering										
	99616-18	N9MT11T308LA	6	18		•				36
	 99616-28					•	* *Side grooving			
Center Drilling / i-Center										
	99616-14...PR	N9MT11T3PR	2.0	3.15					•	28
									*Similar to DIN 332 Form R	
	 99616-IC...	DIN332 Form R	1.0	10					•	43
	 99616-IC...	DIN332 Form A+B	1.0	10					•	
	 99616-IC...	ANSI 60°	5/64”	3/8”					•	
Engraving Tools										
45°	99619-V045...	V04506T1W	0.45	2.1				•		53
60°	 99619-V060...	V06006T1W	0.25	2.7				•		54
60°	99616-10...SW	N9MT0802	0.25	1.1				•		12
90°	99616-10...SW	N9MT0802	0.25	2.0				•		12
	99616-06-6	N9MT05T1	1	6	•	•		•		18

NC Spot Drill >>

NC Spot Drill with indexable carbide insert.

High efficiency! Low cost!

CNC lathes, CNC turning centers and machining centers.

Features

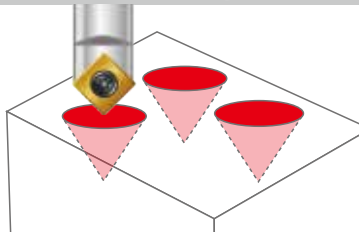
- **Spotting produces better hole position and geometrically uniform holes**
- **Available shank diameter-Ø5, Ø6, Ø10, Ø12, Ø16, Ø20mm, Ø3/8'', Ø1/2'', Ø5/8'', Ø3/4'', M5, M6, M8**
- **One tool will perform multiple applications**
  - Long tool life.
  - Each insert has 2 cutting or 4 cutting edges.
  - Suitable for spotting, chamfering, grooving and engraving.
  - 45° / 60° / 82° / 90° / 100° / 120° / 142° angle for different applications.
  - Increase cutting speed with coated carbide inserts.

▲Machining Center

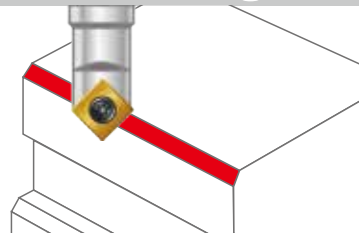
a Engraving
b Spotting
c Chamfering
d Grooving

▼ ALL IN ONE!!

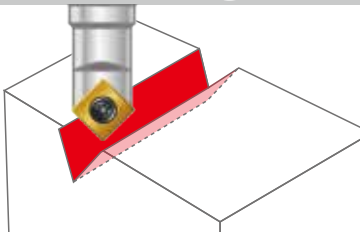
Spotting



Chamfering

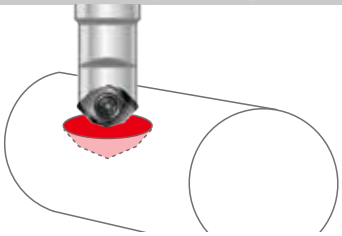


Grooving

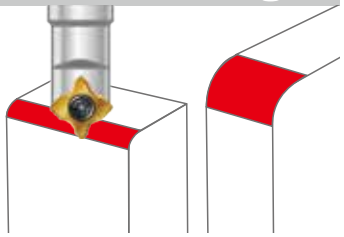


Engraving

W Spotting



Corner Rounding



▲ CNC Lathes

- a External and internal chamfering
- b Grooving
- c Centering
- d Facing

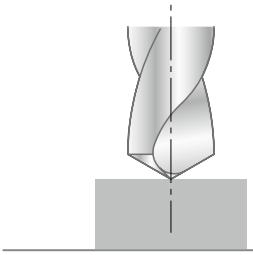
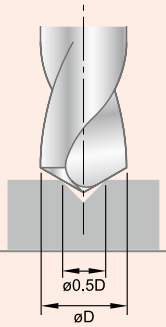
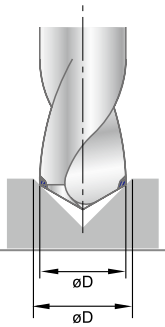
A New Drilling Concept!

0.5xD of spotting >>

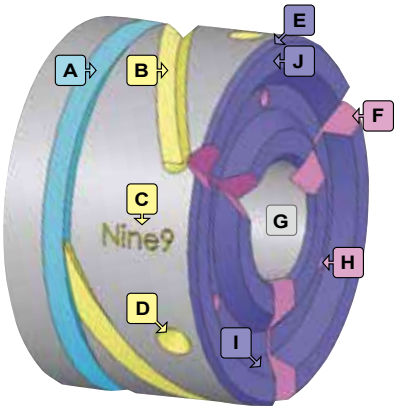
Many drill manufacturers and suppliers state that their drills start drilling on the solid material. You can look forward to the following benefits when using the NC Spot Drill to drill a spot that is half of the drilling diameter.

Drill Benefits >>

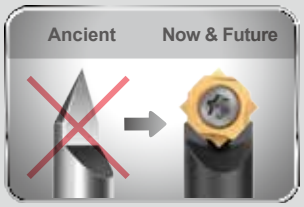
- Higher feed rate.
  Why? Because the drill is guided at the strongest part of cutting edge.
- Better center position.
  Why? Because the spotting is done by a single cutting edge which is out of center, and similar to boring operation.
- Increased tool life.

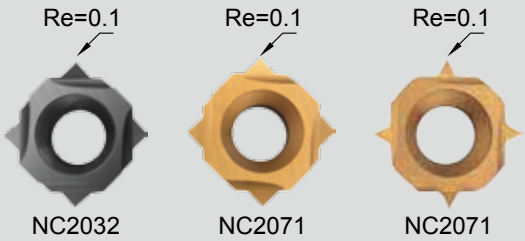
NC Spot Drill	Without Spotting	0.5xD Spotting	Larger Spotting
• Better center position! • Longer tool life!	• Drill has less position accuracy and diameter tolerance.	• Best result! • Higher speed and feed rate. • Better position accuracy and diameter tolerance.	• Longer spotting time! • Guided at the weakest corner of drill. • Shorter tool life
	 Unstable tool life		
✕	○	✕

Various Applications of NC Spot Drill >>

Turning Center	Fig	Applications	Multifunctional Cutting Tool
	A	Grooving	Use on CNC lathes CNC turning centers Machining centers Milling machines SPM macines .....
	B	Helical groove milling	
	C	Engraving	
	D	Spot drilling	
	E	Chamfer turning	
	F	Face groove milling	
	G	Internal turning	
	H	Spot drilling on end surface	
	I	Internal Chamfering	
	J	Facing grooveing	

N9MT080201W Engraving





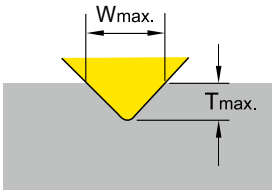
Inserts >>

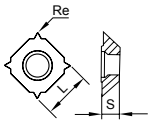
- No need to reset tool length after changing insert or cutting edge.
- Each insert has 4 cutting edges.

NC10: • Universal grade for non-ferrous metal and cast iron.

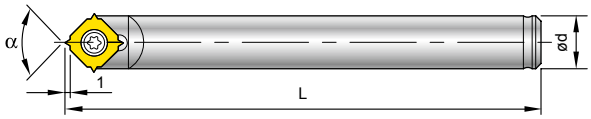
NC40: • Universal grade for all unhardened steel.

60-NC40: • Very positive angle for 60° engraving for all kind of unhardened steel and cast iron.



Code	Parts No.	α	Grade	Coating		Dimensions L	Dimensions S	Dimensions Re	Wmax.	Tmax.
013404	N9MT080201W-60-NC40	60°	K20F	TiN		8	2.38	0.1	1.1	0.8
013405	N9MT080201W-NC40	90°	K20F	TiN		8	2.38	0.1	2.0	0.9
013406	N9MT080201W-NC10	90°	K20F	TiAlN		8	2.38	0.1	2.0	0.9

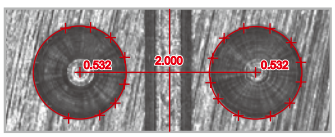
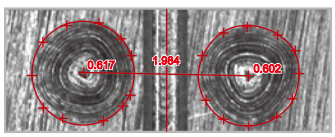
Holder >>



Code	Parts No.	Ød	L	Screw	Key
603001	00-99616-10	10	90	NS-30055 2.0 Nm	NK-T8
613001	00-99616-3/8	3/8”	90		

Mini Spotting >>

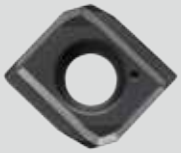
- Engraving inserts can be used for small diameter spotting.
  *Best positioning accuracy!
  *Better surface with spotting by NC Spot Drill in advance.

Tool / Insert	Spindle Speed / Feed Rate			With Spotting	Without Spotting
99616-10 + N9MT080201W NC40	S	3,000 ~ 25,000	r.p.m.		
	f	0.01 ~ 0.02	mm/rev.		

WSP

NEW

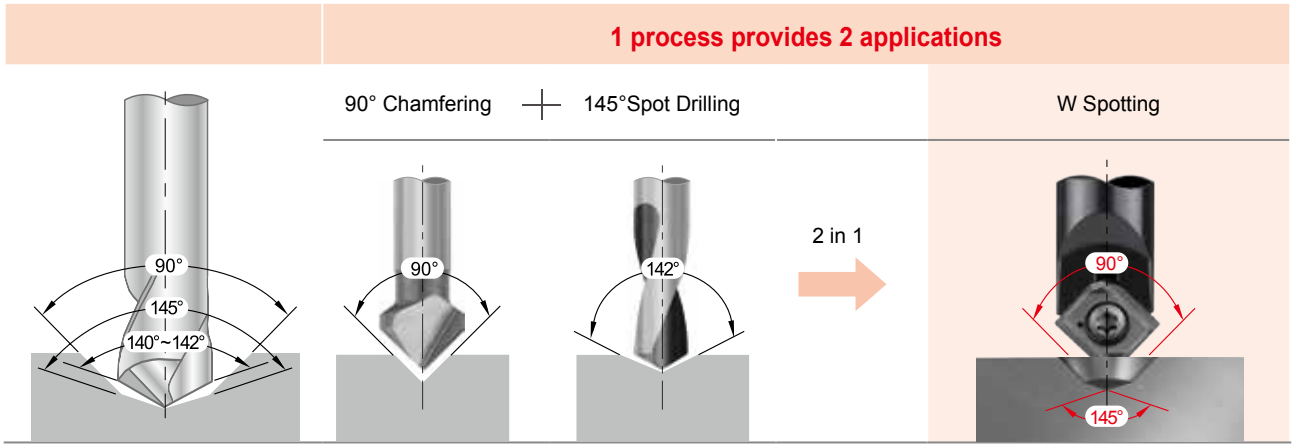
W Spotting New Geometry of Spotting Tool



NC2033

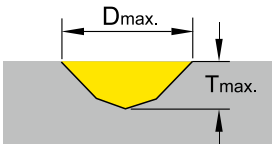
Combined spotting and chamfering 145° + 90° >>

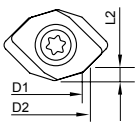
- No chipping.
- Reduces process to one operation. Shortens cycle time.
- Use to spot prior to drilling with high performance drills for higher accuracy of hole position.



Inserts >>

NC2033:
- Fully ground cutting edge and relief angle.
- Universal grade for steel and cast iron.
- Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating		Thread Size	*D1±0.05	D2	L2	Dmax.	Tmax.
013203	N9MT0802M04C-NC2033	K20F	TiAlN		M4x0.7	3.30	4.20	0.93	8	2.83
013204	N9MT0802M05C-NC2033				M5x0.8	4.20	5.25	1.14		2.52
013205	N9MT0802M06C-NC2033				M6x1.0	5.00	6.30	1.39		2.24
014219	N9MT11T3M08C-NC2033	K20F	TiAlN		M8x1.25	6.80	8.40	1.81	13	4.11
014220	N9MT11T3M10C-NC2033				M10x1.5	8.50	10.50	2.28		3.53
014221	N9MT11T3UNC25-NC2033	K20F	TiAlN		1/4-20 UNC	5.08	6.70	1.55	13	4.70
014222	N9MT11T3UNC31-NC2033				5/16-18 UNC	6.53	8.40	1.90		4.20
014223	N9MT11T3UNC38-NC2033				3/8-16 UNC	7.94	10.00	2.22		3.72
New 016205	N9MT1704M12C-NC2033	K20F	TiAlN		M12x1.75	10.25	12.60	2.91	20	6.61
New 016206	N9MT1704M14C-NC2033				M14x2.0	12.00	14.70	3.22		5.87
New 016207	N9MT1704M16C-NC2033				M16x2.0	14.00	16.80	3.51		5.11

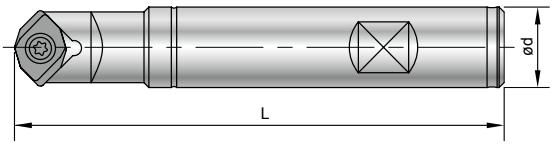
Note: * D1 refer to the Tap Drill sizes.

W Spotting New Geometry of Spotting Tool

NEW

Holder >>

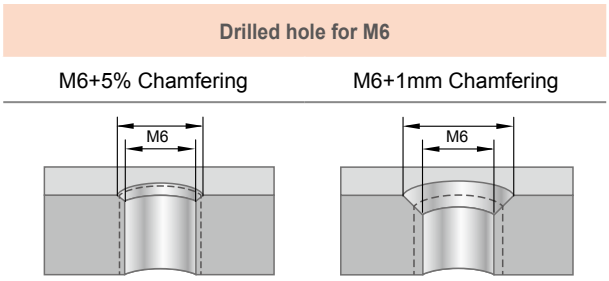
- Utilizes standard ***NC Spot Drill*** holders.
- Holders and inserts are interchangeable.
- Applications: Spotting, grooving and chamfering.



Code	Parts No.	Ød	Insert Type	Thread Size	L	Screw	Key
603001	00-99616-10	10	N9MT0802	M4~M6	89.08±0.29	NS-30055 2.0Nm	NK-T8
613001	00-99616-10-3/8	3/8”					
604004	00-99616-14	16	N9MT11T3	M8~M10	97.55±0.55	NS-35080 2.5Nm	NK-T15
614002	00-99616-14-5/8	5/8”		1/4~3/8 UNC			
606001	00-99616-22	20	N9MT1704	M12~M16	96.24±0.64	NS-50125 5.5Nm	NK-T20
616001	00-99616-22-3/4	3/4"					

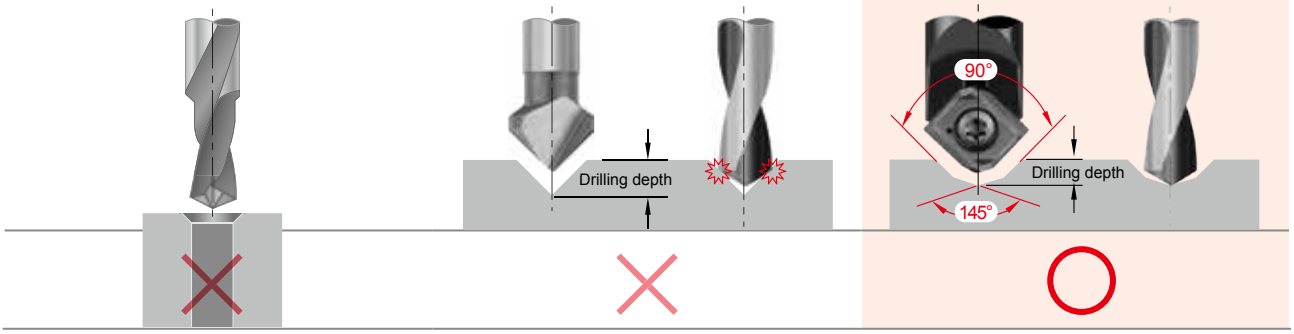
Example >>

- The recommended chamfering is 5% of the nominal diameter of the thread, for example 6.3 mm for M6 thread.
- If you need larger chamfer, it can be calculated the required depth of spotting. (see page 39)

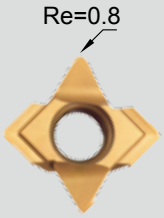


Comparison >>

Carbide Step Drill	Spotting + Drill	W Spotting + Drill
• Tool cost is high • Shorter tool life • Can't drill directly from solid on round parts. Bad position accuracy.	• Longer drilling time • Guided at the weakest corner of drill • Shorter tool life	• Shorter drilling time • Guided at the strongest corner of drill • Longer tool life • Also for chamfering or grooving application



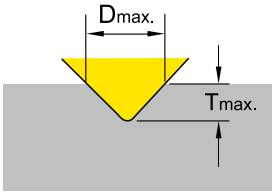
N9MT11T3P60

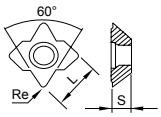


Inserts >>

• Fully ground spotting insert, for 60 degree spotting and engraving.

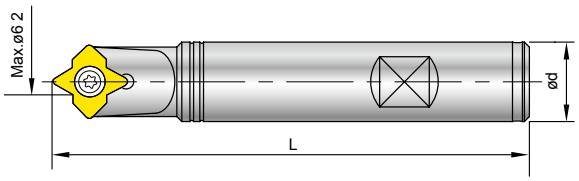
NC40: • Universal grade for all unhardened steel and cast iron.
• Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating		Dimensions			Dmax.	Tmax.
					L	S	Re		
014204	N9MT11T3P60-NC40	P35	TiN		11	3.97	0.8	6.2	4

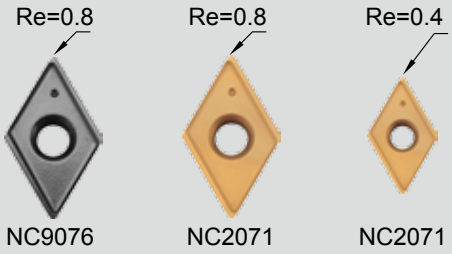
Holder >>

• 60 degree spotting drill with indexable insert.
• A single cutting edge design creates higher precision and position when spotting.
• Applications: For spotting, engraving, small grooving on milling machines, machining centers.



Code	Parts No.	Ød	L	Screw	Key
604002	00-99616-14-12	12	100	NS-35080 2.5 Nm	NK-T15
604004	00-99616-14	16	100		

V9MT0802 / V9MT12T3

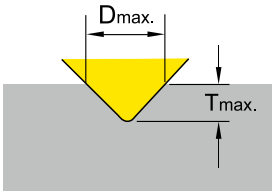


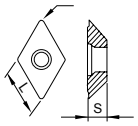
Inserts >>

- 60 degree indexable spotting insert, Dmax 13mm.
- Special geometry with supporting edges for using in high speed machining.
- Excellent tool for grooving. Saving machining time!

NC2071:
- Universal grade for all unhardened steel and cast iron.
- Each insert has 2 cutting edges.

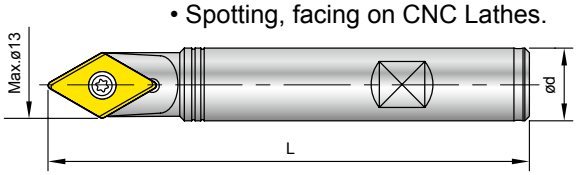
NC9076:
- For non-ferrous material such as aluminum, al-alloy, titanium brass, copper and long cutting chip metal.
- Produces excellent surface finish on non-ferrous metal.
- Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating		Dimensions			Dmax.	Tmax.
					L	S	Re		
019201	V9MT0802CT-NC2071	K20F	TiN		8	2.38	0.4	9	7.3
015201	V9MT12T3CT-NC2071	K20F	TiN		12.7	3.97	0.8	13	10.3
015202	V9MT12T3CT-NC9076	K20F	DLC						

Holder >>

- A single cutting edge creates higher precision and position when spotting.
- Applications:
  - Spotting, engraving, grooving and chamfering on milling machines, machining centers.
  - Spotting, facing on CNC Lathes.



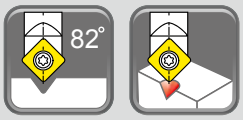
Code	Parts No.	Insert Type	Ød	L	Screw	Key
609001	00-99616-09V	V9MT08	10	60	NS-25045 1.2Nm	NK-T7
605001	00-99616-13V	V9MT12	16	100	NS-35080 2.5 Nm	NK-T15
615001	00-99616-13V-5/8		5/8”	100		

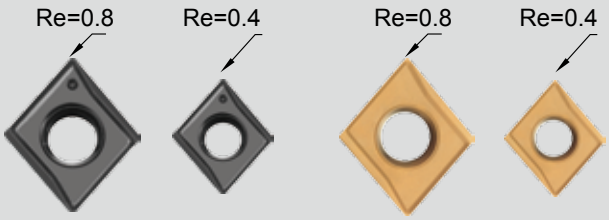
Single Set >>

- User friendly, each set is fitted with one complimentary insert.

Code	Parts No.	Ød	Total Length	Insert fitted	Dmax.	Tmax.
605101-5201	00-99616-13V-02S	16	100	V9MT12T3CT-NC2071	13	10.3
605101-5202	00-99616-13V-02SAL	16	100	V9MT12T3CT-NC9076	13	10.3

V0820802 / V08212T3



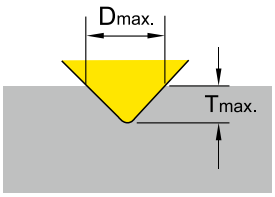


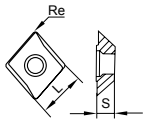
Inserts >>

- 82 degree indexable spotting insert.
- Match the geometry of Amercian standard flat head screw hole.
- Special geometry with supporting edges for use in high speed machining.

NC2071:
- Universal grade for all unhardened steel and cast iron.
- Each insert has 2 cutting edges.

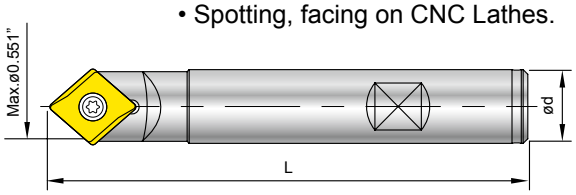
NC9076:
- For non-ferrous material such as aluminum, al-alloy, titanium brass, copper and long cutting chip metal.
- Produces excellent surface finish on non-ferrous metal.
- Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating		Dimensions			Dmax.	Tmax.
					L	S	Re		
0108201	V0820802-NC2071	K20F	TiN		8	2.38	0.4	9	4.8
0108202	V0820802-NC9076	K20F	DLC		8	2.38	0.4	9	4.8
0108211	V08212T3-NC2071	K20F	TiN		12.7	3.97	0.8	14	7.5
0108212	V08212T3-NC9076	K20F	DLC		12.7	3.97	0.8	14	7.5

Holder >>

- 82 degree spotting drill with indexable insert.
- Special cutting edge design gives higher precision and position when spotting.
- Applications : • Spotting, engraving, grooving and chamfering on milling machines, machining centers.
  • Spotting, facing on CNC Lathes.

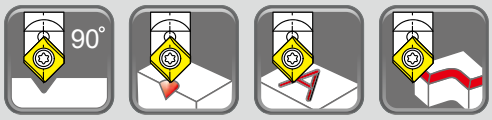


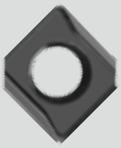
Ø3/8"

Ø5/8"

Code	Parts No.	Insert Type	Ød	L	Screw	Key
693001	00-99619-V082-3/8	V0820802	3/8"	3.5"	NS-30055 2.0 Nm	NK-T8
693002	00-99619-V082-5/8	V08212T3	5/8"	4"	NS-35080 2.5 Nm	NK-T15

N9MT05T1





NC9076

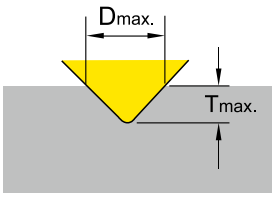
NC2071

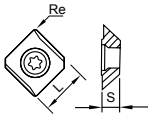
Inserts >>

- Mini spotting drill with indexable insert, low cutting power required.
- Especially good for Swiss type automatic lathes and CNC lathes.

NC2071:
- Universal grade for all unhardened steel and cast iron.
- Geometry with supporting edges to stabilize the cutting condition on low power machine.
- Each insert has 2 cutting edges.

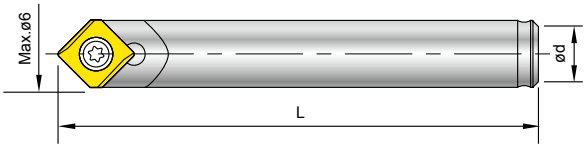
NC9076:
- For non-ferrous material such as aluminum, titanium, brass, copper and stainless steel.
- Produces excellent surface finish on non-ferrous metal.
- Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating		Dimensions			Dmax.	Tmax.
					L	S	Re		
011201	N9MT05T1CT-NC2071	K20F	TiN		5	1.8	0.4	6	2.8
011202	N9MT05T1CT-NC9076	K20F	DLC						

Holder >>

- Smallest indexable spotting drill holder.
- Single cutting edge design gives higher precision when spotting.
- Applications : • Spotting, engraving, and chamfering on milling machines, machining centers.
  • Spotting, facing on CNC Lathes.



Ø5

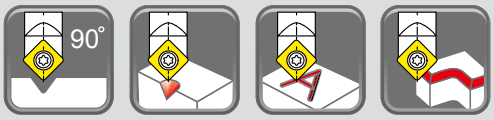
Ø6

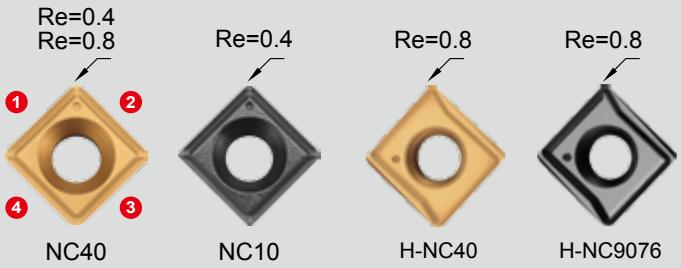
Ø6

Code	Parts No.	Ød	L	Screw	Key
601001	00-99616-06-6	6	35	NS-20036 0.8 Nm	NK-T6
601002	00-99616-06-5	5	35		
601003	00-99616-06-6L	6	60		

Note:601003 is carbide shank holder.

N9MT0802





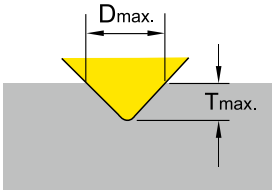
Inserts >>

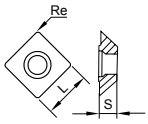
NC40:
- General purpose, universal grade for all unhardened steel.
- Each insert has 4 cutting edges.

NC10:
- High positive angle and fully ground cutting edge and relief angle.
- Universal grade for non-ferrous metal, cast iron and stainless steel.
- Each insert has 4 cutting edges.

H-NC40:
- Best choice for spotting application.
- Special geometry with supporting edges for use in high speed machining.
- Universal grade for all kind of steel and cast iron.
- Each insert has 2 cutting edges.

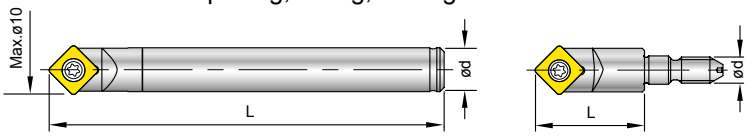
H-NC9076:
- High positive geometry and sharp edge.
- For non-ferrous material such as aluminum, titanium, brass, copper and long cutting chip metal.
- Produces excellent surface finish on non-ferrous metal.
- Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating		Dimensions L	Dimensions S	Dimensions Re	Dmax.	Tmax.
013401	N9MT080208CT-NC40	K20F	TiN		8.31	2.38	0.8	10	4.5
013402	N9MT080204CT-NC40	K20F	TiN		8.31	2.38	0.4		
013403	N9MT080204CT-NC10	K20F	TiAlN		8.31	2.38	0.4		
013201	N9MT0802CT2T-H-NC40	K20F	TiN		8.31	2.38	0.8		
013202	N9MT0802CT2T-H-NC9076	K20F	DLC		8.31	2.38	0.8		

Holder >>

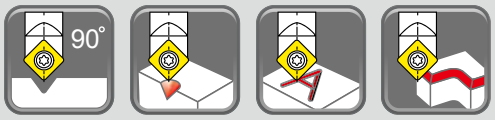
- Indexable insert spotting drill holder.
- Single cutting edge design gives higher precision when spotting.
- Applications :
  - Spotting, engraving, grooving and chamfering on milling machines, machining centers.
  - Spotting, facing, turning on CNC Lathes.



Code	Parts No.	Ød	L	Screw	Key
603001	00-99616-10	10	90	NS-30055 2.0 Nm	NK-T8
603003	00-99616-10-SL10	10	90		
613001	00-99616-10-3/8	3/8”	90		
623001	00-99616-10-M5	M5	25		
623002	00-99616-10-M6	M6	25		

Note:
- 603003 with side lock flat on shank.
- Nine9 extension bar for M5,M6 screw fit holder, see page 66.

N9MT0802



Single Set >>

• User friendly, each set is fitted with one complimentary insert.

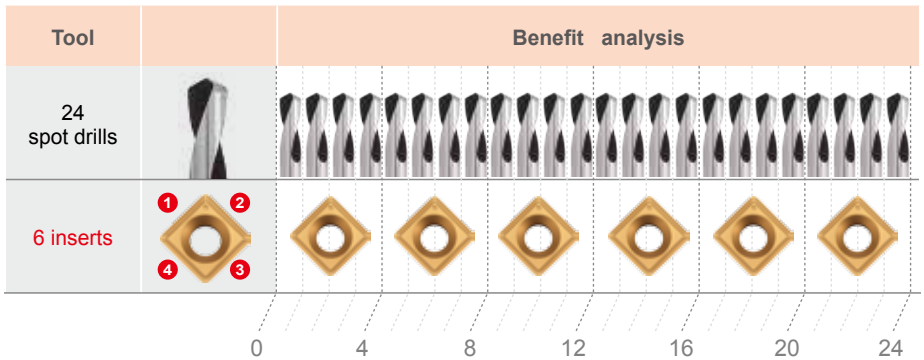
Code	Parts No.	Ød	Total Length	Insert fitted	Dmax.	Tmax.
603101-3401	00-99616-10-02S	10	90	N9MT080208CT-NC40	10	4.5
603101-3403	00-99616-10-02SAL	10	90	N9MT080204CT-NC10	10	4.5
603101-3201	00-99616-10-H-02S	10	90	N9MT0802CT2T-H-NC40	10	4.5
613101-3401	00-99616-10-3/8-02S	3/8”	3.54”	N9MT080208CT-NC40	0.394”	0.177”
613101-3403	00-99616-10-3/8-02SAL	3/8”	3.54”	N9MT080204CT-NC10	0.394”	0.177”

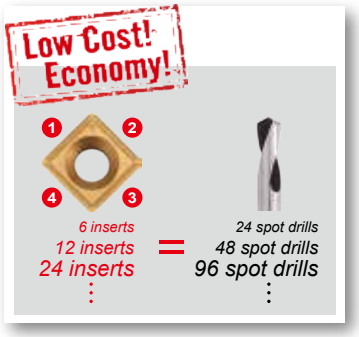
Starter Package >>

• Selected package for starter who wants to try NC Spot Drill.
• Included one insert on tool holder and five inserts in the pocket.
• Total 6 inserts are equal to 24 spot drills.

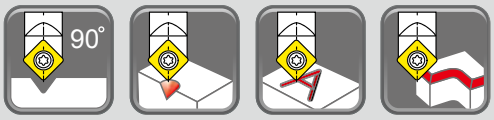
Code	Parts No.	Ød	Insert included	Content
603201-3401	00-99616-10-ME6	10	N9MT080208CT-NC40	1 tool holder + 6 inserts + 1 key
603201-3403	00-99616-10-ME6AL	10	N9MT080204CT-NC10	
603201-3201	00-99616-10-H-ME6	10	N9MT0802CT2T-H-NC40	
613201-3401	00-99616-10-IN6	3/8”	N9MT080208CT-NC40	
613201-3403	00-99616-10-IN6AL	3/8”	N9MT080204CT-NC10	

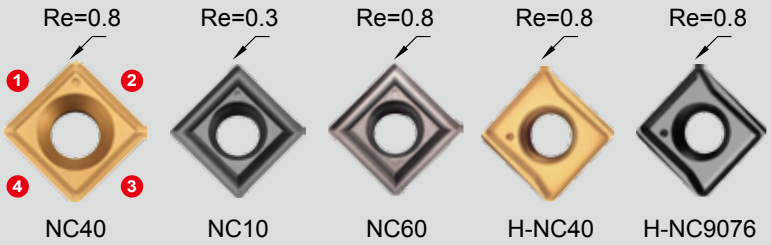
Comparison >>





N9MT11T3





Inserts >>

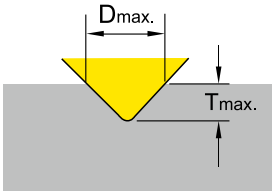
NC40:
- General purpose, universal grade for all unhardened steel.
- Each insert has 4 cutting edges.

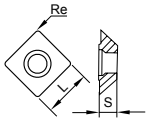
NC10:
- High positive angle and fully ground cutting edge and relief angle.
- Universal grade for non-ferrous metal, cast iron and stainless steel.
- Each insert has 4 cutting edges.

NC60:
- Cermet insert, for hardened steel up to HRC56 .
- Each insert has 4 cutting edges.

H-NC40:
- Best choice for spotting application.
- Special geometry with supporting edges for use in high speed machining.
- Universal grade for all kind of steel and cast iron.
- Each insert has 2 cutting edges.

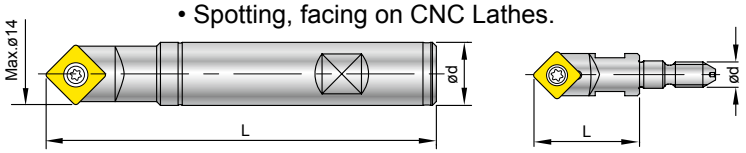
H-NC9076:
- High positive geometry and sharp edge.
- For non-ferrous material such as aluminum, titanium, brass, copper and long cutting chip metal.
- Produces excellent surface finish on non-ferrous metal.
- Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating		Dimensions L	S	Re	Dmax.	Tmax.
014401	N9MT11T3CT-NC40	P35	TiN		11	3.97	0.8	14	7
014402	N9MT11T3CT-NC10	K10F	TiAlN		11	3.97	0.3		
014403	N9MT11T3CT-NC60	CERMET			11	3.97	0.8		
014202	N9MT11T3CT2T-H-NC40	K20F	TiN		11	3.97	0.8		
014203	N9MT11T3CT2T-H-NC9076	K20F	DLC		11	3.97	0.8		

Holder >>

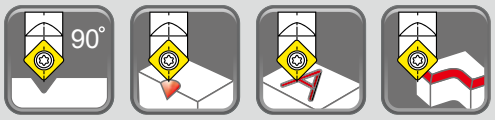
- Single cutting edge design gives higher precision when spotting.
- Applications : • Spotting, engraving, grooving and chamfering on milling machines, machining centers.
  • Spotting, facing on CNC Lathes.



Code	Parts No.	Ød	L	Screw	Key
604002	00-99616-14-12	12	100	NS-35080 2.5 Nm	NK-T15
604004	00-99616-14	16	100		
604007	00-99616-14-150L	16	150		
604009	00-99616-14-220L	20	220		
614001	00-99616-14-1/2	1/2”	4“		
614002	00-99616-14-5/8	5/8”	4”		
624001	00-99616-14-M8	M8	30		

Note: • Nine9 extension bar for M8 screw fit holder, see page 66.

N9MT11T3



Single Set >>

• User friendly, each set is fitted with one complimentary insert.

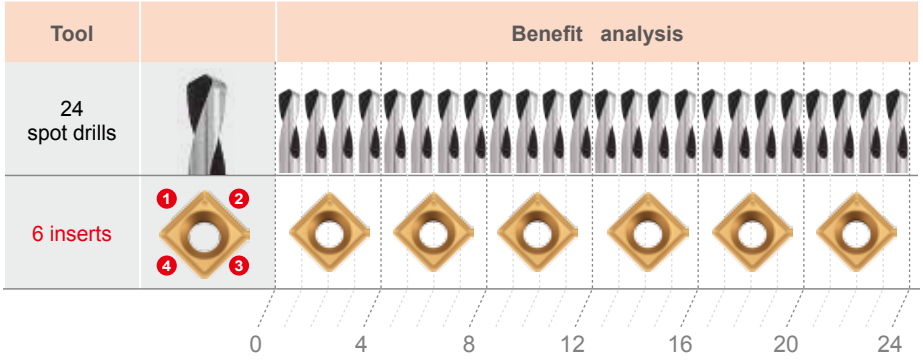
Code	Parts No.	Ød	Total Length	Insert fitted	Dmax.	Tmax.
604102-4401	00-99616-14-12-02S	12	100	N9MT11T3CT-NC40	14	7
604102-4402	00-99616-14-12-02SAL			N9MT11T3CT-NC10	14	7
604102-4202	00-99616-14-12-H-02S			N9MT11T3CT2T-H-NC40	14	7
604104-4401	00-99616-14-02S	16		N9MT11T3CT-NC40	14	7
604104-4402	00-99616-14-02SAL			N9MT11T3CT-NC10	14	7
604104-4202	00-99616-14-H-02S			N9MT11T3CT2T-H-NC40	14	7
614101-4401	00-99616-14-1/2-02S	1/2”	4”	N9MT11T3CT-NC40	0.551”	0.276”
614101-4402	00-99616-14-1/2-02SAL			N9MT11T3CT-NC10	0.551”	0.276”
614102-4401	00-99616-14-5/8-02S	5/8”		N9MT11T3CT-NC40	0.551”	0.276”
614102-4402	00-99616-14-5/8-02SAL			N9MT11T3CT-NC10	0.551”	0.276”

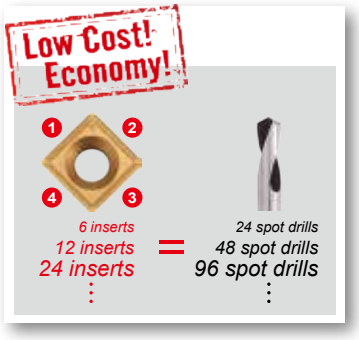
Starter Package >>

• Selected package for starter who wants to try NC Spot Drill.
• Included one insert on tool holder and five inserts in the pocket.
• Total 6 inserts are equal to 24 spot drills.

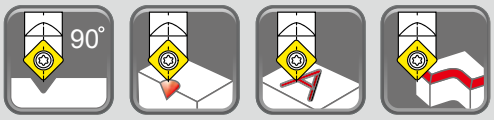
Code	Parts No.	Ød	Insert included	Content
604202-4401	00-99616-14-12-ME6	12	N9MT11T3CT-NC40	1 tool holder + 6 inserts + 1 key
604202-4402	00-99616-14-12-ME6AL		N9MT11T3CT-NC10	
604202-4202	00-99616-14-12-H-ME6		N9MT11T3CT2T-H-NC40	
604204-4401	00-99616-14-ME6	16	N9MT11T3CT-NC40	
604204-4402	00-99616-14-ME6AL		N9MT11T3CT-NC10	
604204-4403	00-99616-14-ME6HS		N9MT11T3CT-NC60	
604204-4202	00-99616-14-H-ME6		N9MT11T3CT2T-H-NC40	
614202-4401	00-99616-14-IN6	5/8”	N9MT11T3CT-NC40	
614202-4402	00-99616-14-IN6AL		N9MT11T3CT-NC10	

Comparison >>





N9MT1704

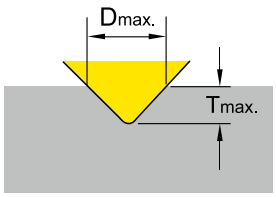


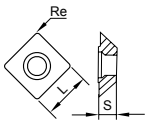
NC2071

Inserts >>

• 90 degree indexable spot drill insert, Dmax 22mm.

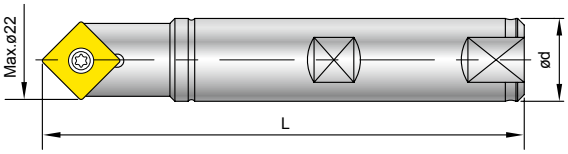
NC2071 : • High positive geometry,
fully ground cutting edge and relief angle.
• Universal grade for all unhardened steel and cast iron.
• Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating		Dimensions			Dmax.	Tmax.
					L	S	Re		
016201	N9MT1704CT-NC2071	K20F	TiN		17	4.76	1.2	22	10.4

Holder >>

• 90 degree spotting drill with indexable insert.
• Single cutting edge design gives high precision when spotting.
• Applications : • Spotting, engraving, grooving and chamfering on milling machines, machining centers.
• Spotting, facing on CNC Lathes.



Ø20

Code	Parts No.	Ød	L	Screw	Key
606001	00-99616-22	20	100	NS-50125 5.5 Nm	NK-T20
606002	00-99616-22-25	25	150		

Single Set >>

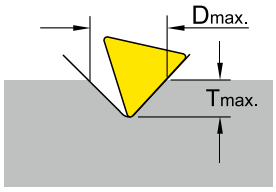
• User friendly, each set is fitted with one complimentary insert.

Code	Parts No.	Ød	Total Length	Insert fitted	Dmax.	Tmax.
606101-6201	00-99616-22-02S	20	100	N9MT1704CT-NC2071	22	10.4

N9MT220408

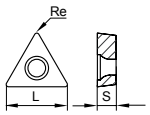
NC40

Inserts >>



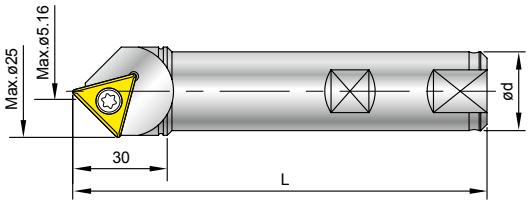
- For spotting diameter up to 25mm.
- Fully ground cutting edge and relief angle.

NC40:
- Universal grade for carbon steel, alloy steel and cast iron.
- Each insert has 3 cutting edges.

Code	Parts No.	Grade	Coating		Dimensions			Dmax.	Tmax.
					L	S	Re		
017301	N9MT220408CT-NC40	P35	TiN		20.83	4.76	---	25	12.2

Holder >>

- Large spotting diameter with indexable insert.
- Single cutting edge design gives high precision when spotting.
- Applications : spotting and chamfering on milling machine, machining centers.

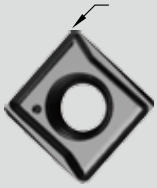


Ø25

Code	Parts No.	Ød	L	Screw	Key
607001	00-99616-25-CT28	25	120	NS-40100 3.5 Nm	NK-T15
617001	00-99616-1-CT28	1”	4.72”		

N9MT11T3CT2T

H-NC40

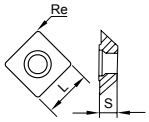


H-NC9076

Inserts >>

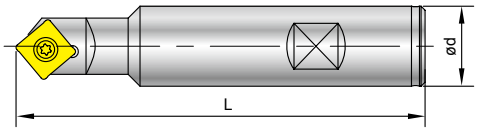
H-NC40:
- Universal grade for all kind of steel and cast iron.
- Each insert has 2 cutting edges.

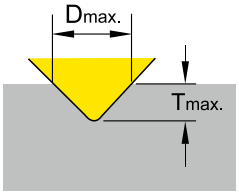
H-NC9076:
- High positive geometry and sharp edge.
- For non-ferrous material such as aluminum, titanium, brass, copper and long cutting chip metal.
- Produces excellent surface finish when chamfering non-ferrous metal.
- Each insert has 2 cutting edges.

Code	Parts No.	Grade	Coating		Dimensions		
					L	S	Re
014202	N9MT11T3CT2T-H-NC40	K20F	TiN		11	3.97	0.8
014203	N9MT11T3CT2T-H-NC9076		DLC		11	3.97	0.8

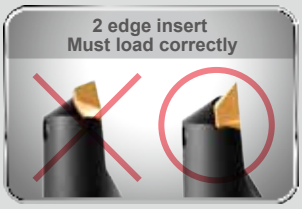
Holder >>

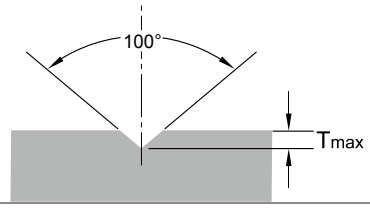
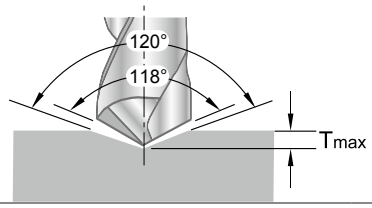
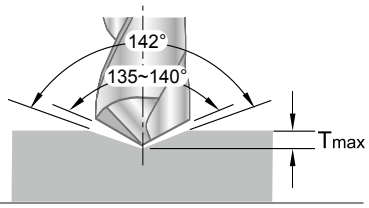
- Indexable insert spotting drill holders for 100°/120°/142° spotting.
- Spotting produces better hole position and geometrically uniform holes.
- Increase tool life of the next drilling operation.



Code	Parts No.	Angle	Ød	L	Screw / Key	Dmax.	Tmax.	
604011	00-99616-20-100	100°	20	100		16	6.3	
604013	00-99616-20-120	120°	20	100	NS-35080 2.5 Nm	17	4.76	
614003	00-99616-3/4-120	120°	3/4”	100		0.669”	0.187”	
604014	00-99616-20-142	142°	20	100	NK-T15	18.5	3.16	
614004	00-99616-3/4-142	142°	3/4”	100		0.728”	0.124”	

N9MT11T3CT2T



100 degree	120 degree	142 degree
		
• For aircraft 100° normal rivet hole and screw hole.	• For spotting before drilling by 118° point angle drill. • 60° chamfering.	• For spotting before drilling by 135°~140° point angle high performance drill.

Single Set >>

• User friendly, each set is fitted with one complimentary insert.

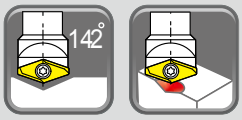
Code	Parts No.	Angle	Ød	Total Length	Insert fitted	Dmax.	Tmax.
604111-4202	00-99616-20-100-H-02S	100°	20	100	N9MT11T3CT2T-H-NC40	16	6.3
604113-4202	00-99616-20-120-H-02S	120°	20	100		17	4.76
614103-4202	00-99616-3/4-120-H-02S		4”	4”		0.669”	0.187”
604114-4202	00-99616-20-142-H-02S	142°	20	100		18.5	3.16
614104-4202	00-99616-3/4-142-H-02S		4”	4”		0.728”	0.124”

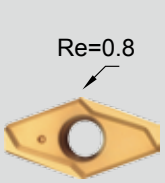
Starter Package >>

• Selected package for starter who wants to try NC Spot Drill.
• Included one holder and 6 inserts.

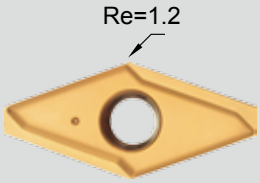
Code	Parts No.	Angle	Ød	Insert included	Content
604211-4202	00-99616-20-100-H-ME6	100°	20	N9MT11T3CT2T-H-NC40	1 tool holder + 6 inserts + 1 key
604213-4202	00-99616-20-120-H-ME6	120°	20		
614203-4202	00-99616-3/4-120-H-IN6	120°	3/4”		
604214-4202	00-99616-20-142-H-ME6	142°	20		
614204-4202	00-99616-3/4-142-H-IN6	142°	3/4”		

V14208 / V14216





V1420803-NC2071

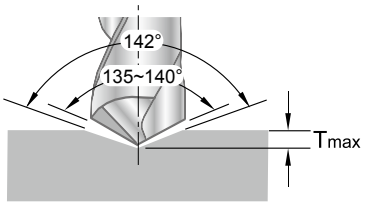


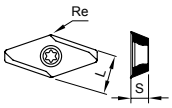
V1421604-NC2071

Inserts >>

- For spotting before drilling by 135° - 140° point angle high performance drill.
- 142 degree indexable spotting drills. Maximum diameter up to 32mm.

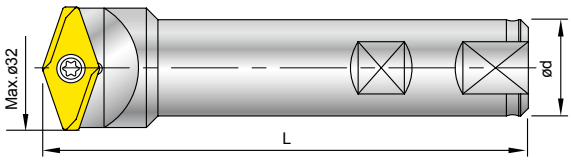
NC2071:
- High positive geometry, fully ground cutting edge and relief angle.
- Universal grade for all unhardened steel and cast iron.
- Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating		Dimensions			Dmax.	Tmax.
					L	S	Re		
0114201	V1420803-NC2071	K20F	TiN		8	2.38	0.8	16	2.8
0114211	V1421604-NC2071		TiN		14	4.76	1.2	32	5.5

Holder >>

- Using spotting first may increase higher speed and feed rate of the after drills.
- Extend your drill life with 142° spotting. Reduce your drilling cost.
- Higher accuracy of positioning and diameter tolerance !

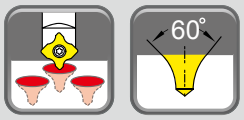


Ø16

Ø25

Code	Parts No.	Insert Type	Ød	L	Screw	Key
696001	00-99619-V142-16	V1420803	16	100	NS-30072 2.0 Nm	NK-T9
696002	00-99619-V142-32	V1421604	25	120	NS-50125 5.5 Nm	NK-T20

N9MT11T3PR Radius Center Drilling

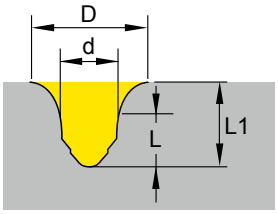


NC40

Inserts >>

- Create 60° center holes SIMILAR to DIN 332 Form R, radius 2.0 / 2.5 / 3.5mm
- Carbide insert can stand very long tool life.
- Easy tool length setting, saving tool changing time.

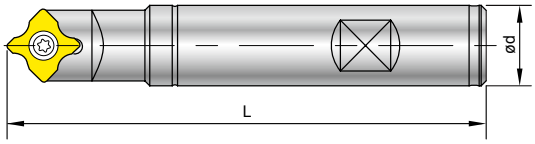
NC40:
- Universal grade for all unhardened steel and cast iron.
- Radius curve eliminates the sharp transition from drill point to countersink angle.
- The risk of breakage is reduced.
- Each insert has 2 cutting edges.



Code	Parts No.	Grade	Coating	Dimensions			
				d	D	L	L1
014205	N9MT11T3PR20-NC40	P35	TiN	2.0	5.4	2.7	3.3
014206	N9MT11T3PR25-NC40			2.5	5.9	3.0	3.7
014207	N9MT11T3PR30-NC40			3.0	6.4	3.3	4.0

Holder >>

- PR holder has small offset value.
- Also apply as a 90° spotting drill while fitted with N9MT11T3CT2T-H insert (page 25).

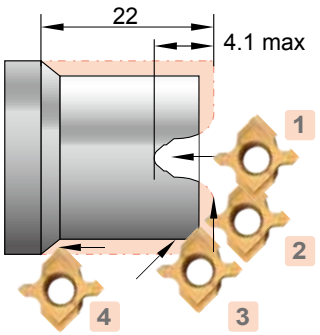


Ø16

Code	Parts No.	Ød	L	Screw	Key
604004PR	00-99616-14-PR	16	100	NS-35080 2.5 Nm	NK-T15

Turning and Centering Capacity on CNC Lathes

	Action
1	Center Drilling
2	Facing
3	Chamfering
4	External Turning



Corner Rounding >>

Various corner radius inserts can fit on same holder

Carbide insert can stand very long tool life

Produces smooth and excellent surface finish on workpiece.

Features

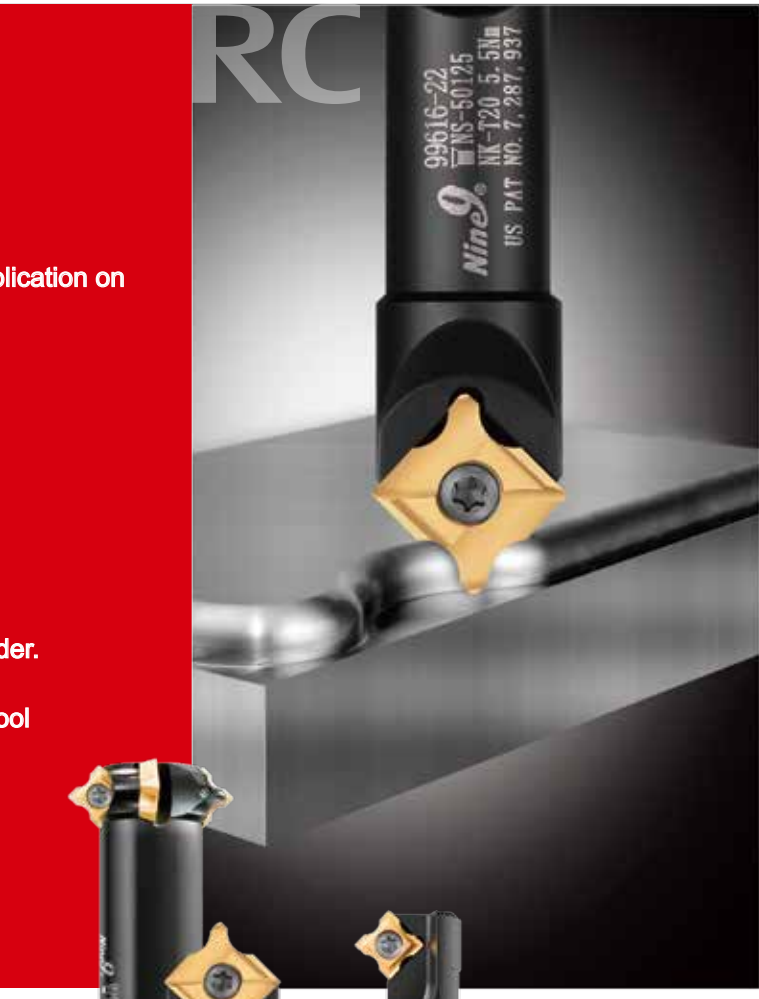
RC

Type of RC

- Each insert has 2 cutting edges.
- Combination corner rounding and 45° chamfering application on same insert.
- Higher cutting speed and feed rate.
- Very small X offset, good for contour chamfering.

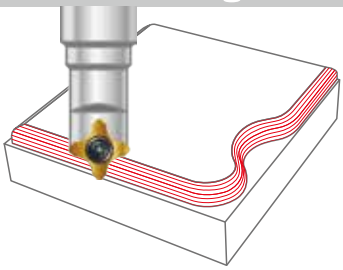
Type of R

- Each insert has 4 cutting edges.
- R1.0 ~ R3.0 inserts are interchangeable on same holder.
- For front and back chamfering.
- Tool offset can be set after measuring tool length by tool presetter or Z-Zero Setter.



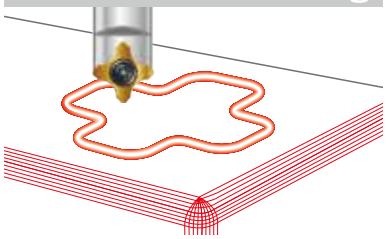
RC

Corner Rounding



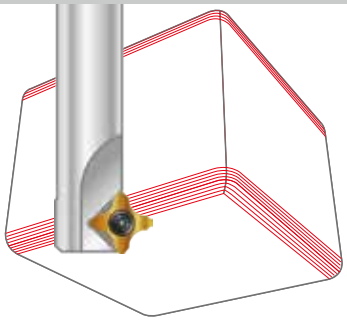
RC

Circular Corner Rounding



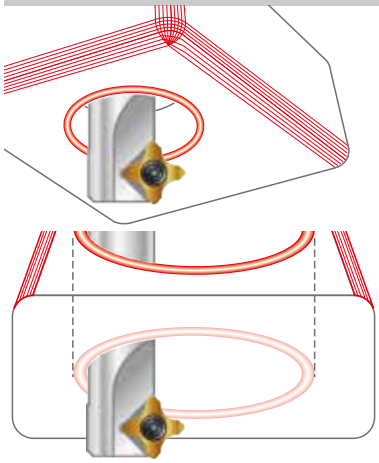
R

Front & Back Corner Rounding



R

Backward Circular Corner Rounding



R

- Inserts are CNC ground for precision radius and location.
- Optimizes the tool performance and reduces the cutting time.

N9MT05T1RC

NEW

RC0.5~RC1.0
All are interchangeable
on same holder

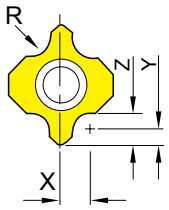
NC2071 NC9036

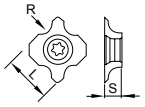
Inserts >>

- Various corner radius inserts can fit on same holder.
- Very small X offset 1.25mm for radius 0.5,
  good for small components needs a small corner rounding for removing burrs.

NC2071:
- Universal grade for all unhardened steel and cast iron.
- Inserts are CNC ground for precision radius location.
- Each insert has 2 cutting edges.

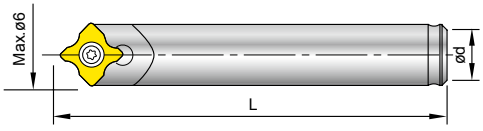
New NC9036:
- For non-ferrous material such as aluminum, acrylic, titanium, brass, copper and stainless steel.
- High positive geometry and sharp edge produces excellent surface finish.
- Each insert has 2 cutting edges.



Insert Radius	Code	Parts No.	Grade	Coating	offset X	offset Y	offset Z		Dimensions L	Dimensions S
New 0.5	011203	N9MT05T1RC050-NC2071	K20F	TiN	1.25	0.75	1.25		5	1.8
	011206	N9MT05T1RC050-NC9036		DLC						
New 0.75	011204	N9MT05T1RC075-NC2071		TiN	1.50		1.50			
	011207	N9MT05T1RC075-NC9036		DLC						
New 1.0	011205	N9MT05T1RC100-NC2071		TiN	1.75		1.75			
	011208	N9MT05T1RC100-NC9036		DLC						

Holder >>

- For corner rounding using ***NC Spot Drill*** shank.



Ø5

Ø6

Ø6

Code	Parts No.	Ød	L	Screw	Key
601001	00-99616-06-6	6	35	NS-20036 0.8 Nm	NK-T6
601002	00-99616-06-5	5	35		
601003	00-99616-06-6L	6	60		

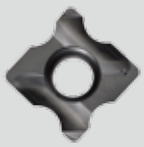
* 601003 is carbide shank holder

N9MT11T3RC

NEW

RC1.0~RC3.0
All are interchangeable on same holder

NC40



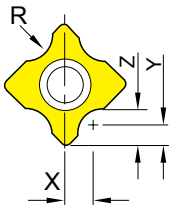
NC9036

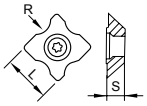
Inserts >>

- Higher cutting speed and feed rate.
- Combination corner rounding and 45° chamfering application on same insert.
- Various corner radius inserts can fit on same holder.

NC40:
- Universal grade for all unhardened steel and cast iron.
- Inserts are CNC ground for precision radius location.
- Each insert has 2 cutting edges.

New NC9036:
- For non-ferrous material such as aluminum, acrylic, titanium, brass, copper and stainless steel.
- High positive geometry and sharp edge produces excellent surface finish.
- Each insert has 2 cutting edges.

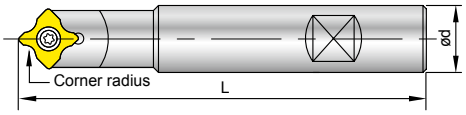


Insert Radius	Code	Parts No.	Grade	Coating	offset				Dimensions	
					X	Y	Z		L	S
1.0	014209	N9MT11T3RC10-NC40	K20F	TiN	2.75	1.5	2.5		11.11	3.97
	014224	N9MT11T3RC10-NC9036		DLC						
1.5	014210	N9MT11T3RC15-NC40		TiN	3.25	1.5	3			
	014225	N9MT11T3RC15-NC9036		DLC						
2.0	014211	N9MT11T3RC20-NC40		TiN	3.75	1.5	3.5			
	014226	N9MT11T3RC20-NC9036		DLC						
2.5	014212	N9MT11T3RC25-NC40		TiN	4.25	1.5	4			
	014227	N9MT11T3RC25-NC9036		DLC						
3.0	014213	N9MT11T3RC30-NC40		TiN	4.75	1.4	4.4			
	014228	N9MT11T3RC30-NC9036		DLC						
1/64	014214	N9MT11T3RC1/64-NC40		TiN	0.086”	0.059”	0.0747”		0.437”	0.156”
	014229	N9MT11T3RC1/64-NC9036		DLC						
1/32	014215	N9MT11T3RC1/32-NC40		TiN	0.101”	0.059”	0.090”			
	014230	N9MT11T3RC1/32-NC9036		DLC						
1/16	014216	N9MT11T3RC1/16-NC40		TiN	0.133”	0.059”	0.122”			
	014231	N9MT11T3RC1/16-NC9036		DLC						
3/32	014217	N9MT11T3RC3/32-NC40		TiN	0.164”	0.059”	0.153”			
	014232	N9MT11T3RC3/32-NC9036		DLC						
1/8	014218	N9MT11T3RC 1/8-NC40		TiN	0.199”	0.055”	0.180”			
	014233	N9MT11T3RC 1/8-NC9036		DLC						

Holder >>

- For corner rounding using ***NC Spot Drill*** shank.

Code	Parts No.	Ød	L	Screw/ Key
604002	00-99616-14-12	12	100	NS-35080 2.5 Nm
604004	00-99616-14	16	100	
614001	00-99616-14-1/2	1/2”	4”	NK-T15
614002	00-99616-14-5/8	5/8”	4”	



Ø12 . Ø16

N9MT1704RC

RC4.0~RC6.0
All are interchangeable on same holder

NC2071

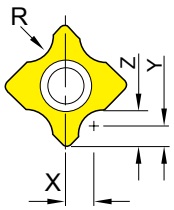
NC9036

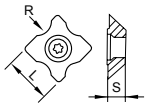
Inserts >>

- Higher cutting speed and feed rate.
- Combination corner rounding and 45° chamfering application on same insert.
- Various corner radius inserts can fit on same holder.

NC2071:
- Universal grade for all unhardened steel and cast iron.
- Inserts are CNC ground for precision radius location.
- Each insert has 2 cutting edges.

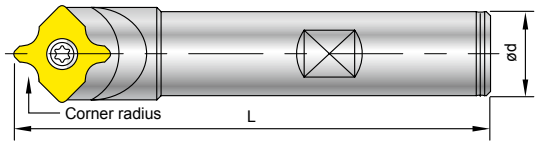
New NC9036:
- For non-ferrous material such as aluminum, acrylic, titanium, brass, copper and stainless steel.
- High positive geometry and sharp edge produces excellent surface finish.
- Each insert has 2 cutting edges.



Corner radius(R)	Code	Parts No.	Grade	Coating	offset				Dimensions	
					X	Y	Z		L	S
4.0	016202	N9MT1704RC40-NC2071	K20F	TiN	6.15	2	6		17	4.76
4.0	016208	N9MT1704RC40-NC9036		DLC	6.15	2	6			
5.0	016203	N9MT1704RC50-NC2071		TiN	7.1	2	7			
5.0	016209	N9MT1704RC50-NC9036		DLC	7.1	2	7			
6.0	016204	N9MT1704RC60-NC2071		TiN	8.1	2	8			
6.0	016210	N9MT1704RC60-NC9036		DLC	8.1	2	8			

Holder >>

- For corner rounding using ***NC Spot Drill*** shank.
- Good for small work pieces, which need large corner rounding.



Ø20.Ø25

Code	Parts No.	Ød	L	Screw	Key
601001	00-99616-22	20	100	NS-50125 5.5 Nm	NK-T20
601002	00-99616-22-25	25	150		

N9MT11T3R

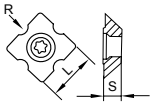
R1.0~R3.0
All are interchangeable on same holder

R1.0 R1.5 R2.0 R2.5 R3.0

Inserts >>

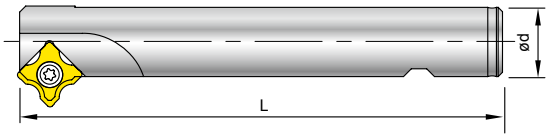
- For front and back corner rounding.
- Various corner radius inserts can fit on same holder.
- Carbide insert can stand very long tool life.
- Each insert has 4 cutting edges.

NC2071: • Universal grade for all unhardened steel and cast iron.
• Inserts are CNC ground for precision radius location.

Corner radius(R)	Code	Parts No.	Grade	Coating		Dimensions	
						L	S
1.0	014404	N9MT11T3R10-NC2071	P35	TiN		11.11	3.97
1.5	014405	N9MT11T3R15-NC2071	P35	TiN			
2.0	014406	N9MT11T3R20-NC2071	P35	TiN			
2.5	014407	N9MT11T3R25-NC2071	P35	TiN			
3.0	014408	N9MT11T3R30-NC2071	P35	TiN			

Holder >>

- Center of radius of each tool is dedicated.
- Tool offset can be set after measuring tool length by tool presetter or Z-Zero Setter.



Code	Parts No.	Ød	L	Z	Screw	Key
604015	00-99616-16-25R	16	100	1	NS-35080 2.5 Nm	NK-T15
604019	00-99616-16-30R	16	120	1		
604020	00-99616-25-40R	25	150	4		

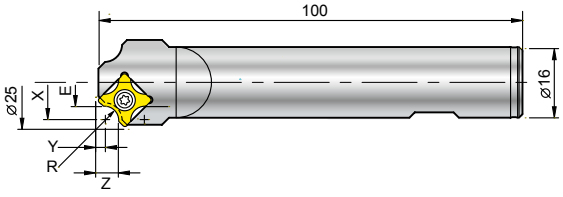
More >>

- Also can fit with N9MT11T308LA inserts for front and back chamfering. (Please see page 36)

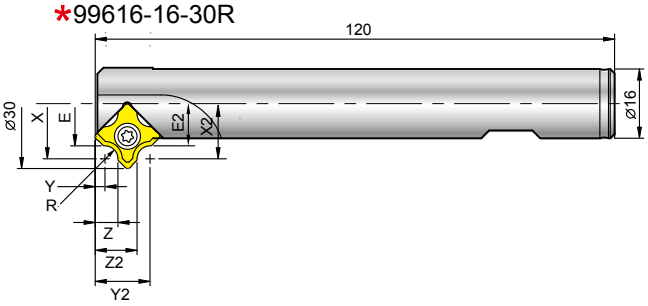
N9MT11T3R

Cutting Position >>

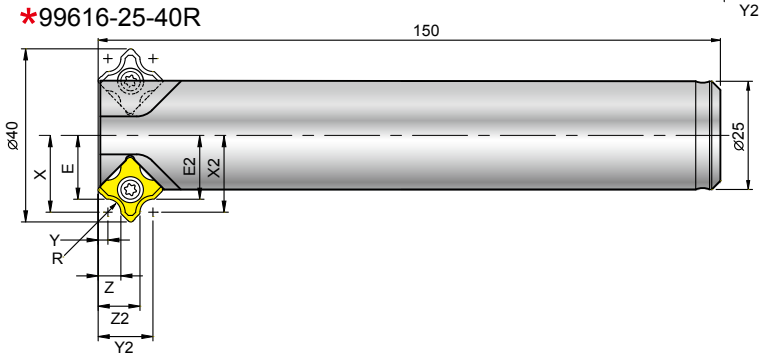
99616-16-25R



*99616-16-30R



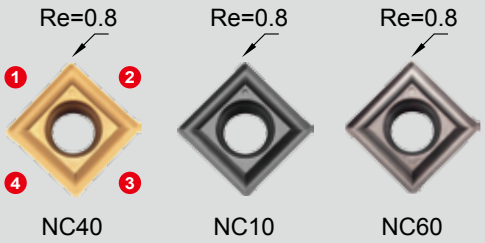
*99616-25-40R



99616-16-30R & 99616-25-40R
*For front and back corner rounding.
*Eliminates 2nd operation or de-burring time.

Insert Radius	Holder	Front Chamfering				Back Chamfering				Z
		E	X	Y	Z	E2	X2	Y2	Z2	
R1.0	00-99616-16-25R	8.25	9.25	3.25	4.25	----	----	----	----	1
	00-99616-16-30R	10.75	11.75	3.25	4.25	10.75	11.75	11.65	10.65	1
	00-99616-25-40R	15.75	16.75	3.25	4.25	15.75	16.75	11.65	10.65	4
R1.5	00-99616-16-25R	8	9.5	3	4.5	----	----	----	----	1
	00-99616-16-30R	10.5	12	3	4.5	10.5	12	11.9	10.4	1
	00-99616-25-40R	15.5	17	3	4.5	15.5	17	11.9	10.4	4
R2.0	00-99616-16-25R	7.75	9.75	2.75	4.75	----	----	----	----	1
	00-99616-16-30R	10.25	12.25	2.75	4.75	10.25	12.25	12.15	10.15	1
	00-99616-25-40R	15.25	17.25	2.75	4.75	15.25	17.25	12.15	10.15	4
R2.5	00-99616-16-25R	7.5	10	2.5	5	----	----	----	----	1
	00-99616-16-30R	10	12.5	2.5	5	10	12.5	12.4	9.9	1
	00-99616-25-40R	15	17.5	2.5	5	15	17.5	12.4	9.9	4
R3.0	00-99616-16-25R	7.25	10.25	2.25	5.25	----	----	----	----	1
	00-99616-16-30R	9.75	12.75	2.25	5.25	9.75	12.75	12.65	9.65	1
	00-99616-25-40R	14.75	17.75	2.25	5.25	14.75	17.75	12.65	9.65	4

N9MT11T308LA 45° Chamfering Tool

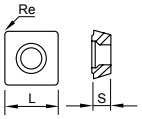


Inserts >>

NC40: • General purpose, universal grade for all unhardened steel.
• Each insert has 4 cutting edges.

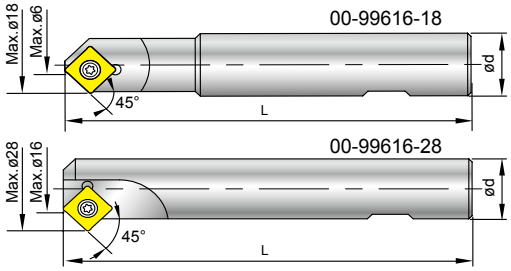
NC10: • High positive angle and fully ground cutting edge and relief angle.
• Universal grade for Al, Al-alloy, non-ferrous metal, cast iron and stainless steel.
• Each insert has 4 cutting edges.

NC60: • Cermet insert, for hardened steel up to HRC56 .
• Each insert has 4 cutting edges.

Code	Parts No.	Grade	Coating		Dimensions		
					L	S	Re
014409	N9MT11T308LA -NC40	P35	TiN		11.11	3.97	0.8
014410	N9MT11T308LA -NC10	K10F	TiAN				
014411	N9MT11T308LA -NC60	Cermet					

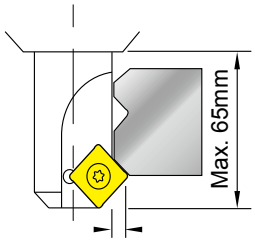
Holder >>

• 99616-28 can be applied for machining bottom chamfering and side grooving.

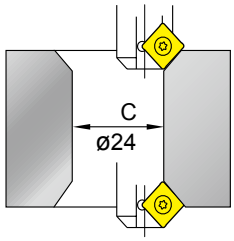


Code	Parts No.	Insert type	Chamfering	Ød	L	Z	Screw / Key
604017	00-99616-18	N9MT11T308LA	Ø6-Ø18	20	120	1	NS-35080 2.5 Nm
604018	00-99616-28		Ø16-Ø28	20	120	1	NK-T15

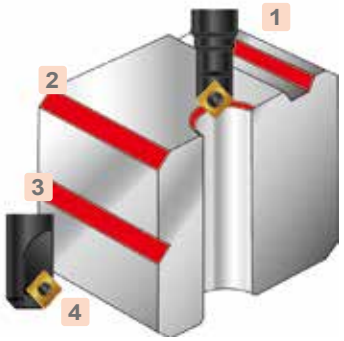
Example >>



For bottom chamfering
Max. 2mm
Cø16-ø28



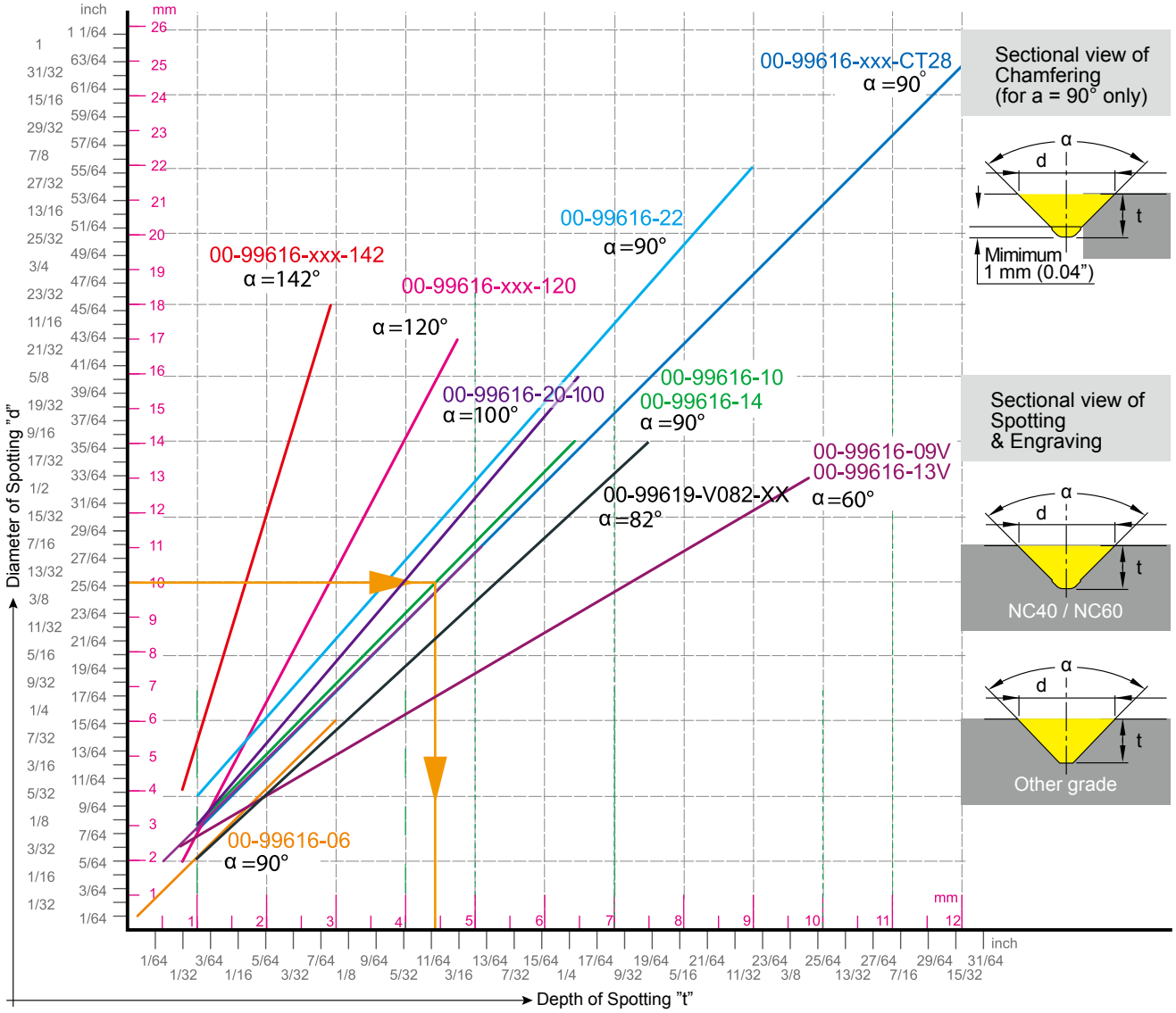
Min.diameter
for shift ø24mm.



Action	
1	External and internal chamfering
2	Side chamfering
3	Side grooving
4	Bottom chamfering

Cutting Data

Diameter / Depth Chart and Speed / Feed Rate Calculation of NC Spot Drill



Instruction of Use >>

1. From Spot diameter "d" to get drill depth " t ".
2. Point angle "α" is determined by which tool holder you use.
3. From "d" draw a horizontal line to get intersection of the line by point angle "α".
4. From the intersection draw a vertical line to the bottom to have depth of spotting " t ". " t " is the drill depth of the NC program.
5. The sectional view of spotting will depend on the shape of insert, NC40 and other grade of inserts have different sectional view.
6. For chamfering, do not use tip of insert, 1mm(0.04") minimum clearance is required for a smooth surface finish.

Calculate spindle speed and feed rate >>

1. Using your "d" value and cutting speed Vc from the data sheet, calculate spindle speed "S"(RPM).
2. " F" feed rate per minute F = f x S = RPM x IPR

Metric

$$S = \frac{Vc \times 1000}{\pi \times d}$$

$$F = S \times f$$

d =	diameter -mm
S =	Spindle Speed -r.p.m.
Vc =	Cutting Speed -m/min.
f =	mm/rev.
F =	mm/min.

Inch

$$S = \frac{(3.82 \times SFM)}{d}$$

$$F = f \times S$$

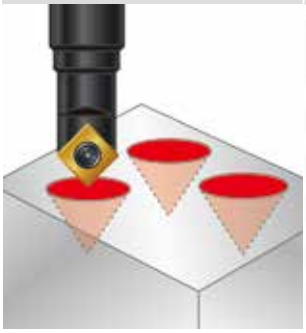
d =	diameter-inch
S =	Spindle Speed-r.p.m.
SFM =	Surface Speed-ft./min. Vc (m/min.) x 3.28
f = IPR =	inch/rev.
F =	inch/min.

Cutting Data

N9MT-CT >> Insert Multi-function

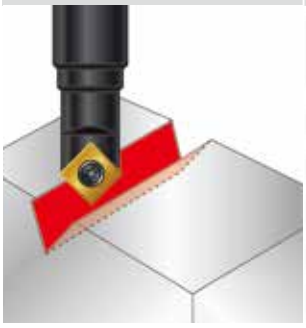
Determine spindle speed and feed rate:

- Choose spotting depth to decide spotting diameter according to the Diameter/Depth chart of page 37.
- The spindle speed should be calculated by the maximum diameter of spotting, chamfering and grooving.

Spotting	Work Material	Vc (m/min)	f (mm/rev.)	Grade of Insert
	Carbon Steel	150~250	0.05~0.10	NC40, NC2071
	Alloy Steel	100~200	0.04~0.08	NC40, NC2071
	Stainless Steel	65~125	0.03~0.06	NC10, NC60, NC40, NC2071
	Cast iron	80-150	0.05~0.10	NC40, NC10, NC2071
	Non-Ferrous Metal (Al, Cu)	150~300	0.05~0.10	NC10, NC9076, NC2071
	Ti, Ti-alloy	60~80	0.03~0.06	NC9076
	Hardened steel HRC 40°~56°	30~60	0.03~0.08	NC60

* For technical construction reasons, the insert is not located on the center of the holder.
* Inserts with supporting edges can increase feed rate 50%.

Chamfering	Work Material	Vc (m/min)	f (mm/rev.)	Grade of Insert
	Carbon Steel	150~320	0.15~0.24	NC40, NC2071
	Alloy Steel	100~250	0.12~0.20	NC40, NC2071
	Stainless Steel	65~125	0.1~0.20	NC10, NC60, NC40, NC2071
	Cast iron	150-250	0.15~0.25	NC40, NC10, NC2071
	Non-Ferrous Metal (Al, Cu)	150~320	0.15~0.25	NC10, NC9076, NC2071
	Ti, Ti-alloy	60~80	0.03~0.06	NC9076
	Hardened steel HRC 40°~56°	30~60	0.03~0.08	NC60

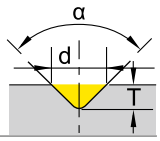
Grooving	Work Material	Vc (m/min)	f (mm/rev.)	Grade of Insert
	Carbon Steel	150~250	0.05~0.10	NC40, NC2071
	Alloy Steel	100~200	0.04~0.08	NC40, NC2071
	Stainless Steel	65~125	0.03~0.06	NC10, NC60, NC40, NC2071
	Cast iron	80~150	0.05~0.08	NC40, NC10, NC2071
	Non-Ferrous Metal (Al, Cu)	150~320	0.05~0.08	NC10, NC9076, NC2071
	Ti, Ti-alloy	60~80	0.03~0.06	NC9076
	Hardened steel HRC 40°~56°	30~60	0.03~0.08	NC60

N9MT-W Insert / Engraving Insert

Engraving : Width of engraving=diameter of cutting="d"
Depth of engraving=depth of cutting="T"

Engraving

- For α = 90° insert, d=2xT
- For α = 60° insert, d=1.73xT



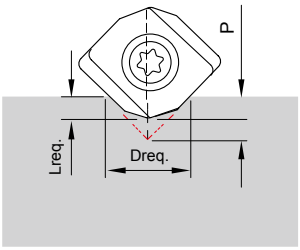
Mini spotting	Work Material	Vc (m/min)	f (mm/rev.)	Grade of Insert
	All Kind of Steel, unhardened, Cast iron	20~80	0.01~0.02	NC40
	Non-Ferrous Metal (Al, Cu)	20~100	0.01~0.02	NC10

Attention:The calculated result "d" is only for calculation of spindle speed.

Cutting Data

W Spotting >>

W spotting	Formula



Lreq. = Dreq. x 0.5 - P

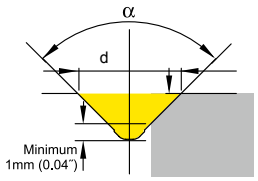
P = distance of theoretical intersection point to tip of insert.
0.5 = fixed factor for calculation
Lreq. = required drilling depth
Dreq. = required diameter

	M4	M5	M6	M8	M10	M12	M14	M16	1/4-20 UNC	5/16-18 UNC	3/8-16 UNC
P =	1.17	1.48	1.76	2.39	2.97	3.59	4.19	4.88	1.80	2.30	2.78

W spotting	Work Material	Vc (m/min)	f (mm/rev.)
	Carbon Steel	150 ~ 300	0.05 ~ 0.15
	Alloy Steel	120 ~ 250	0.05 ~ 0.10
	Stainless Steel	80 ~ 150	0.04 ~ 0.08
	Cast iron	100 ~ 200	0.05 ~ 0.10

LA Insert >> 45° Chamfering

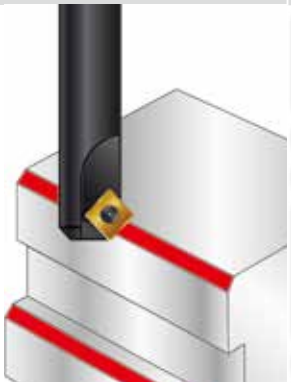
45° Chamfering	Formula



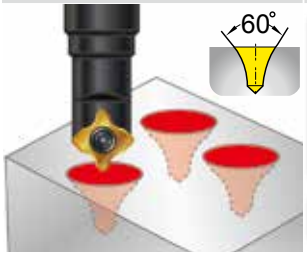
$$S = \frac{Vc \times 1000}{d \times \pi} \text{ r.p.m.}$$

F = S x f mm/min.

α = point angle 90°
d = effective diameter
Vc = cutting speed m/min.or ft./min.
S = Spindle speed
f = feed per rev. mm/rev.

45° Chamfering	Work Material	Vc (m/min)	f (mm/rev.)	Grade of Insert
	Carbon Steel	150-320	0.05~0.10	NC40
	Alloy Steel	100-250	0.04~0.08	NC40
	High alloy steel	60-80	0.03~0.06	NC40
	Stainless Steel	65-125	0.03~0.06	NC10
	Cast iron	150-250	0.05~0.10	NC10, NC40
	Aluminum, Al-alloy Si < 12%	150-320	0.05~0.10	NC10
	Al-alloy Si >12%	100-300	0.05~0.10	NC10
	Cu	200-250	0.05~0.10	NC10
	Brass and Bronze	150-250	0.05~0.10	NC10
	Hardened steel HRC 40~°56°	60-80	0.05~0.10	NC60

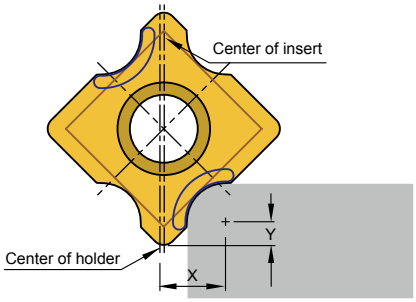
PR Insert >> Radius Center Drilling

Center Drilling	Work Material	Vc (m/min)	f (mm/rev.)	Grade of Insert
	Carbon Steel	80-150	0.05-0.20	NC40
	Alloy steel	80-150	0.05-0.20	
	High alloy steel	80-150	0.05-0.20	
	Cast iron	80-150	0.05-0.20	

Cutting Data

N9MT-RC Insert >> Corner Rounding

Determine spindle speed and feed:
To decide running speed of the tools and feed rate, please calculate spindle speed and feed rate according to the following formula and cutting data:

Corner Rounding	Calculate spindle speed	
	$d = 2 \times X$ mm	d = diameter of the tool for calculation purpose
		X = tool radius offset (ref. page 31~33 for RC inserts)
	$S = \frac{Vc \times 1000}{d \times \pi}$ r.p.m.	Vc = Cutting Speed -m/min.
		S = Spindle Speed -r.p.m.
	$F = S \times f$ mm/min.	F = mm/min.
		f = mm/rev.

Calculate tool length offest on machining center	
	X = tool radius offset (ref. page 31~33 for RC inserts)
TL = TL'-Y, H = X	Y = distance to the center of radius. (ref. page 31~33 for RC inserts)
	TL' = tool length
	TL = tool length offset.
	H = tool radius offset

RC Insert	Work Material	Vc (m/min)	f (mm/rev.)	Grade of Insert
	Carbon Steel	150~320	0.05~0.10	NC40, NC2071
	Alloy steel	100~250	0.05~0.10	NC40, NC2071
	High alloy steel	80~150	0.04~0.08	NC40, NC2071
	Stainless Steel	65~125	0.05~0.10	NC9036
	Cast iron	150~250	0.05~0.10	NC40, NC2071
	Aluminum, Al-alloy Si < 12%	150~320	0.05~0.10	NC9036
	Al-alloy Si >12%	100~300	0.05~0.10	NC9036
	Cu	200~250	0.05~0.10	NC9036
	Brass and Bronze	150~250	0.05~0.10	NC9036

N9MT-R Insert >> Corner Rounding (4 cutting edges)

R Insert	Work Material	Vc (m/min)	f (mm/rev.)	Grade of Insert
	Carbon Steel	150~320	0.05~0.10	NC2071
	Alloy steel	100~250	0.04~0.08	NC2071
	High alloy steel	60~80	0.03~0.06	NC2071
	Cast iron	150~250	0.05~0.10	NC2071

Chamfer Mill 45° >>

Nine9 chamfer mill
is designed for chamfering and countersinking with an indexable insert.
The insert is a specifically designed for use in high speed machining ; the multiple flutes provide for increased feed rate, optimizing performance and reducing cutting time.

Features

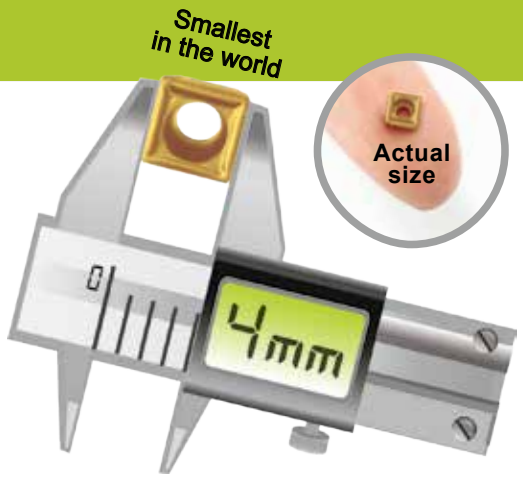
Ultra high speed and feed rate is the biggest advantage of Nine9 Chamfer Mills.
It is not a traditional chamfer tool, it runs 4 times faster in cutting speed and 10 times higher in feed rate. It is the most efficient tool you ever met.

Excellent Repeatability >>

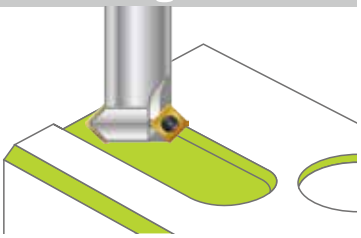
- Smallest insert in the world for chamfering mill.
- Smallest Indexable counter sink, diameter ø7 mm.
- The insert is dual-relief angle, specially edge honning and optimized coated for high cutting speed.
- Optimized the number of teeth on the holder to achieve higher feed rate.

Applications >>

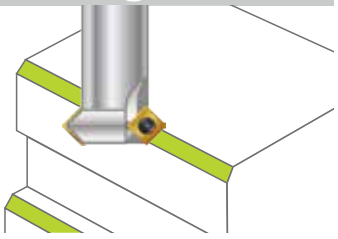
- 90° counter sink and 45° chamfering.
- For counter sink, circular chamfering, contour chamfering and face milling.



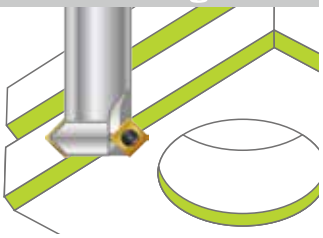
Face Milling



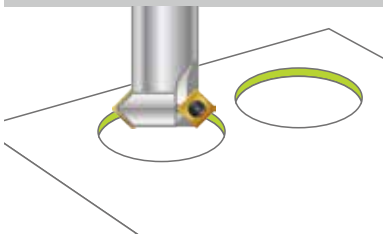
Chamfering



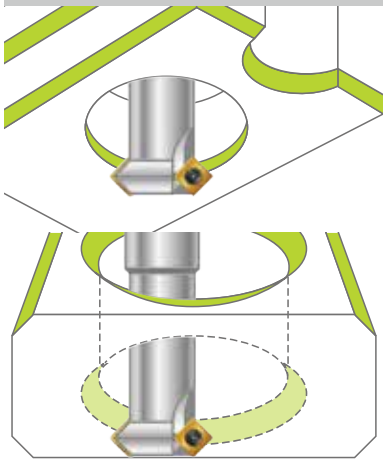
Back Chamfering



Countersink



Backward Circular Chamfering



▲ For front and back chamfering.
Eliminates 2nd operation or de-burring time.

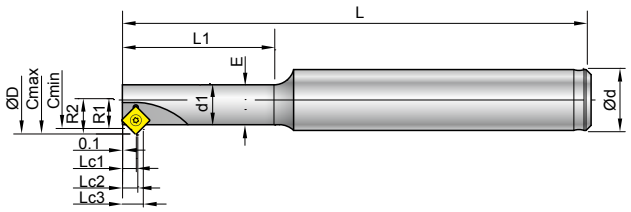
Indexable Chamfer Mill

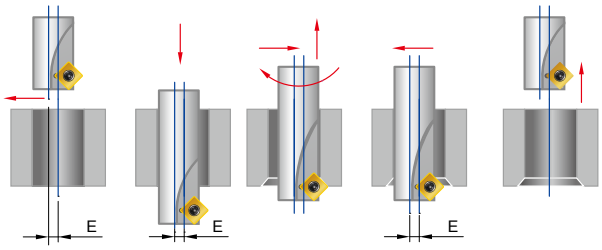
Features >>

- Thanks to the 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 edge honning cutting edge, good chip breaking condition and long tool life.

99616-C02, C04, C06 >>

- Made of hot working steel and hardened.
- Elliptical necked bar to optimize the tool strength.

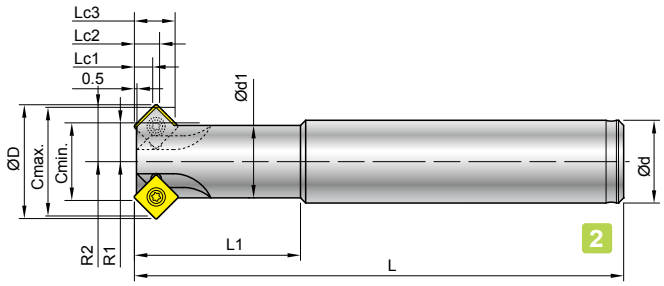




Parts No.	Type	Cmin ø	Cmax ø	ød	ød1	øD	R1	R2	L	L1	Lc1	Lc2	Lc3	E	z	insert Screw / Key
00-99616-C02	BC10-C02-80	6.8	8.8	10	5.25	9	3.4	4.4	80	20	2.56	2.93	3.93	1.25	1	N9GX04T002 NS-18037 0.6Nm NK-T6
00-99616-C04	BC12-C04-100	8.5	10.8	12	6.45	11.1	4.25	5.4	100	25	2.51	2.98	4.13	1.55	1	
00-99616-C06	BC12-C06-100	10.26	13.2	12	7.88	13.5	5.13	6.4	100	30	2.51	2.98	4.45	1.88	1	

99616-C10~99616-C52 >>

- Made of tool steel.



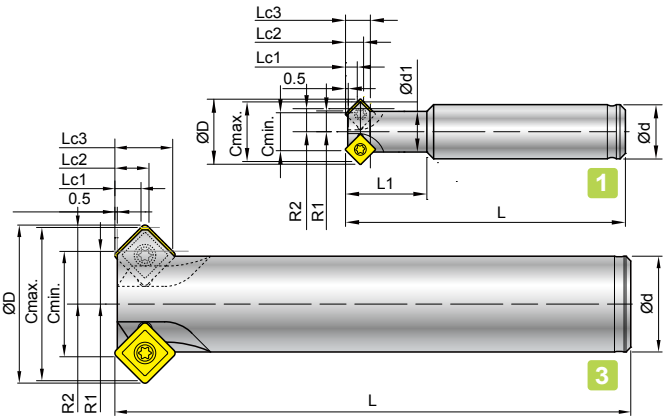


Fig	Parts No.	Type	Cmin ø	Cmax ø	ød	ød1	øD	R1	R2	L	L1	Lc1	Lc2	Lc3	z	insert Screw / Key
1	00-99616-C10	BC10-C07-60	7	11	10	7.5	12	3.8	4.3	60	15	2.6	2.9	5.0	2	N9GX04T002 NS-18037 0.6Nm NK-T6
	00-99616-C20	BC12-C11-100	11	16	12	9.6	16.2	5.9	8	100	25	2.6	2.9	5.0	4	
2	00-99616-C30	BC16-C15-120	15	21	16	14	22	7.5	11.5	120	40	3.5	4.9	7.9	4	N9GX060204 NS-22055 0.9Nm NK-T7
	00-99616-C40	BC20-C19-130	19	25	20	18	26	9.5	12.5	130	50	3.5	4.9	7.9	4	
3	00-99616-C50	BC20-C22-130	22	32	20	--	33	11	16	130	--	5.5	7.1	12.1	4	N9GX090308 NS-30072 2.0Nm NK-T9
2	00-99616-C52	BC25-C22-180	22	32	25	20	33	11	16	180	80	5.5	7.1	12.1	4	

Starter Kit >>

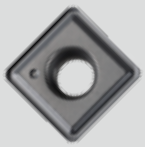
Fig	Part No.	Insert included	Holder included	Content
1	00-99616-C1020-32	N9GX04T002-NC2032	00-99616-C10 + 00-99616-C20	2 x holders + 10 inserts + 1 key
	00-99616-C1020-71	N9GX04T002-NC9072		
2	00-99616-C3040-32	N9GX060204-NC2032	00-99616-C30 + 00-99616-C40	
	00-99616-C3040-71	N9GX060204-NC9071		
3	00-99616-C5052-32	N9GX090308-NC2032	00-99616-C50 + 00-99616-C52	
	00-99616-C5052-71	N9GX090308-NC9071		

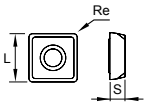
Inserts >>

NC2032: • AlTiN coating, very long tool life.
• For carbon steel, alloy steel, cast iron and hardened steel up to 56HRC
• Each insert has 4 cutting edges.

NC9071: • TiN coating, very shape cutting edge produces excellent surface finish
• For non ferrous metal, aluminum, aluminum-alloy, brass, copper and stainless steel.
• Each insert has 4 cutting edges.

NC9071


NC2032

Parts No.			Coating		Dimensions				
Code of insert		Grade			L	S	Re	Screw	Key
N9GX04T002	NC2032	K20F	AlTiN		4.0	1.8	0.2	NS-18037 0.6Nm	NK-T6
	NC9071		TiN						
N9GX060204	NC2032		AlTiN		6.35	2.38	0.4	NS-22055 0.9Nm	NK-T7
	NC9071		TiN						
N9GX090308	NC2032		AlTiN		9.52	3.18	0.8	NS-30072 2.0Nm	NK-T9
	NC9071		TiN						

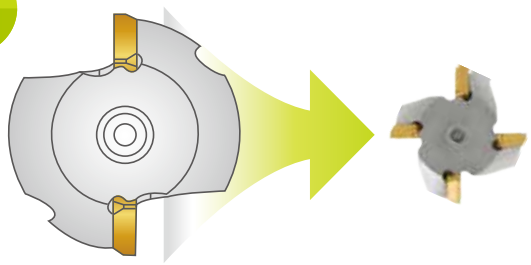
99616-C02, C04, C06 Cutting Data >>

Work Piece Material		Grade of insert	Cutting Speed VC m/min.	Feed Rate mm / tooth
Material Group	Sample Code (JIS)			N9GX04T002 Max. Chamfering 1.5mm
Carbon steel C<0.3%	SS400	NC9071	60-80-120	0.02 ~ 0.07
Carbon steel C>0.3%	S50C, P5	NC2032	60-80-120	0.02 ~ 0.07
Low alloy steel C<0.3%	SCM420	NC9071	60-80-120	0.01 ~ 0.04
High alloy steel C<0.3%	SKD11	NC2032	60-80-120	0.02 ~ 0.07
Stainless Steel	SUS304	NC9071	30-60-100	0.01 ~ 0.04
Cast iron	FC25	NC2032	60-80-120	0.02 ~ 0.06
Al, and non-ferrous metal	A6061	NC9071	80-100-150	0.03 ~ 0.10

99616-C10~C52 Cutting Data >>

Work piece material		Grade of insert	Cutting Speed Vc m/min.	Feed rate mm / tooth		
				N9GX04T002	N9GX060204	N9GX090308
Material Group	Sample Code (JIS)			Max. Chamfering 1.5mm	Max. Chamering 2.5mm	Max. Chamfering 4mm
Carbon steel C<0.3%	SS400	NC9071	150-250-350	0.06~0.12	0.10~0.25	0.10~0.25
Carbon steel C>0.3%	S50C,P5	NC2032	200-300-400	0.06~0.10	0.10~0.20	0.10~0.25
Low alloy steel C<0.3%	SCM420	NC9071	180-240-260	0.06~0.10	0.10~0.20	0.10~0.20
High alloy steel C<0.3%	SKD11	NC2032	120-150-200	0.06~0.10	0.10~0.15	0.10~0.15
Stainless Steel	SUS304	NC9071	120-150-180	0.06~0.10	0.06~0.15	0.10~0.20
Casting iron	FC25	NC2032	120-150-180	0.06~0.10	0.10~0.15	0.10~0.20
Al, and non-ferrous metal	A6061	NC9071	200-400-600	0.06~0.15	0.10~0.25	0.10~0.25
Hardened steel<HRC50°	SKD61	NC2032	80-90-100	0.06~0.10	0.06~0.12	0.10~0.15

Performance



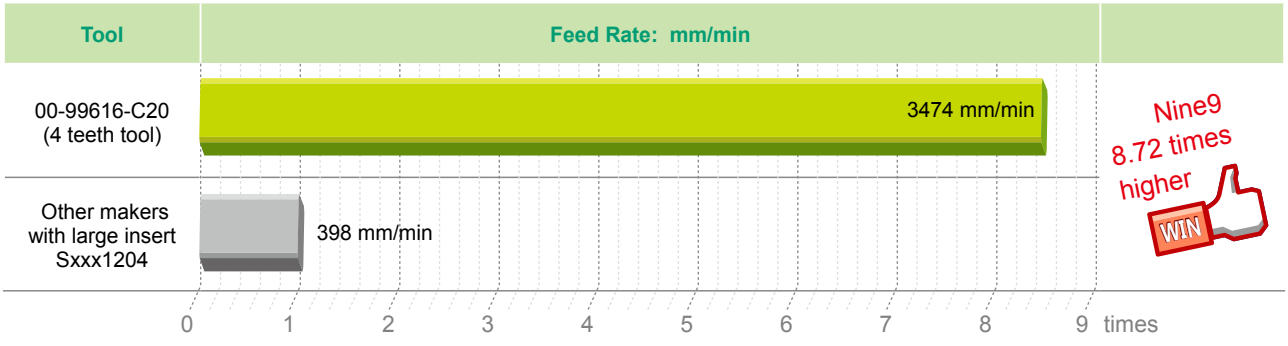
Feed Rate =
Feed per Tooth x Spindle Speed x **No. of Flute** mm/min.

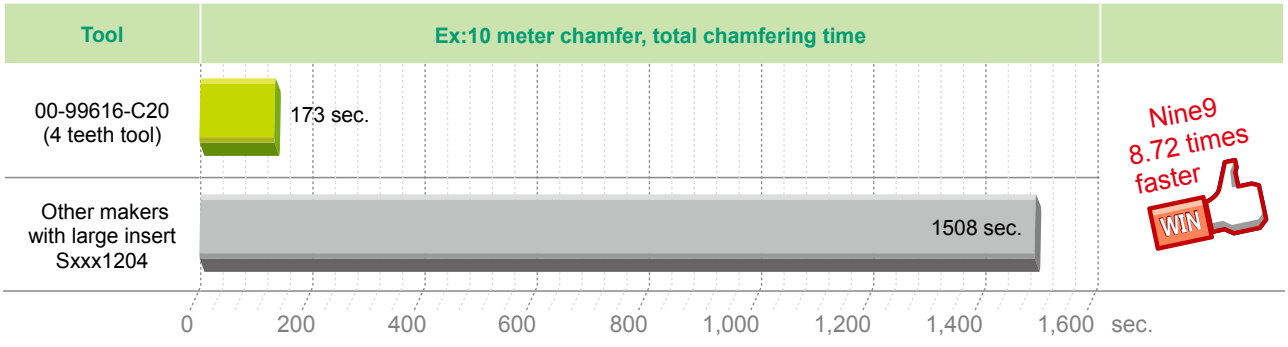
UP **Spindle Speed** = $\frac{\text{Cutting Speed x 1000}}{\pi \text{ x Cmin.}}$

Test Result >> Example 1

• Chamfer tool with larger insert(Sxxx1204) and Nine9 N9GX04 insert.

Tool			
Cutting data		**Nine 9 Chamfer mills**	**Other makers with Large insert**
Chamfering		1 mm	1 mm
Feed rate	**mm/rev.**	0.1	0.1
Dia. of cutter	**mm**	11	32
Teeth of cutter		4	2
Cutting Speed Vc	**m/min.**	300	200
Spindle Speed	**r.p.m.**	8685	1990
Feed rate	**mm/min**	3474	398





Other Tools
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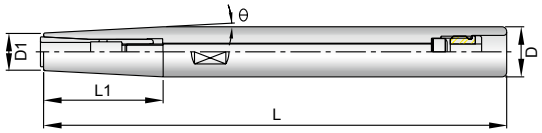
DC Slim Chuck

Extension Adaptor >>

* Stop Nut

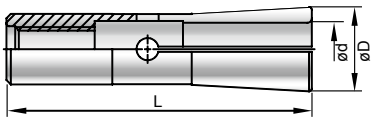


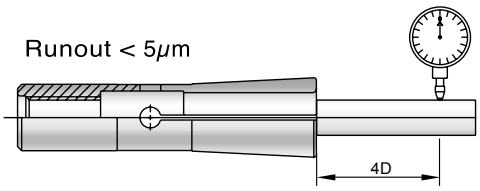
Parts No.	Type of Holder	d	L	L1	øD	D1	θ	Collet	Back Screw	Stop Screw	Hexagon Key	Stop Nut
0-329090-102	ST12-DC4-90	2~4	90	14	10	9	--	DC4	M4 * L60	--	0-301940~632	TP-M8
-112	ST12-DC4-120	2~4	120	38	12	9	3°		M4 * L85	OP-M8		--
0-329090-212	ST12-DC6-120	2~6	120	40	12	14	--	DC6	M5 * L95	--		TP-M12
-222	ST16-DC6-150	2~6	150	38	16	14	3°		M5 * L100	OP-M10	0-301940~642	--
-232	ST20-DC6-200	2~6	200	70	20	14	3°		M5 * L100	OP-M10		--
-242	ST25-DC6-250	2~6	250	115	25	14	3°		M5 * L100	OP-M10	0-301940~643	--
0-329090-322	ST20-DC8-200	3~8	200	28	20	19	2°	DC8	M6 * L120	OP-M12	0-301940~652	--
0-329090-432	ST25-DC10-250	4~10	250	28	25	24	2°	DC10	M8 * L150	OP-M16	0-301940~662	--

* Stop nut is applied when clamping and unclamping tools.

DC-E Collet >>

• The design of DC-E collets is emphasized on increasing the clamping force of end mills.





Type	DC-4E	DC-6E	DC-8E	DC-10E
D	7	9.6	15	19.1
L	31	36	45	52

DC4-E		DC6-E		DC8-E		DC10-E	
Parts No.	Size(mm)	Parts No.	Size(mm)	Parts No.	Size(mm)	Parts No.	Size(mm)
0-300090-102	2.0	0-300090-203	3.0	0-300090-303	3.0	-	-
0-300090-103	3.0	0-300090-204	4.0	0-300090-304	4.0	0-300090-404	4.0
0-300090-104	4.0	0-300090-206	6.0	0-300090-306	6.0	0-300090-406	6.0
				0-300090-308	8.0	0-300090-408	8.0
						0-300090-410	10.0

DC Collet >>

• DC6 collets for drills, reamers and taps below Ø6mm are also available. (Please contact us)

Set of DC Slim Chuck

DC4 >>

Parts No.	Type of Holder	Contains			
		Collet Chuck	Collet	Spanner	Hex Key
0-329090-0123	SST10-DC4-90	SST10-DC4-90	DC4-2E x 1pc DC4-3E x 1pc DC4-4E x 1pc	0-301940~002	0-301940~632
-1123	SST12-DC4-120	SST12-DC4-120			

DC6 >>

Parts No.	Type of Holder	Contains			
		Collet Chuck	Collet	Spanner	Hex Key
0-329090-0223	SST12-DC6-120	ST12-DC6-120	DC6-3E x 1pc DC6-4E x 1pc DC6-6E x 1pc	0-301940~002	0-301940~642
-1223	SST16-DC6-150	ST16-DC6-150			0-301940~642
-2223	SST20-DC6-200	ST20-DC6-200			0-301940~642
-3223	SST25-DC6-250	ST25-DC6-250			0-301940~643

DC8 >>

Parts No.	Type of Holder	Contains			
		Collet Chuck	Collet	Spanner	Hex Key
0-329090-2323	SST20-DC8-200	ST20-DC8-200	DC8-3E x 1pc DC8-4E x 1pc DC8-6E x 1pc DC8-8E x 1pc	0-301940~002	0-301940~652

DC10 >>

Parts No.	Type of Holder	Contains			
		Collet Chuck	Collet	Spanner	Hex Key
0-329090-3423	SST25-DC10-250	ST25-DC10-250	DC10-3E x 1pc DC10-4E x 1pc DC10-6E x 1pc DC10-8E x 1pc DC10-10E x 1pc	0-301940~002	0-301940~662

Extension Bar For NC Spot-Drill

Solid Carbide Extension Bar >>

• TiN coated to indentify the efficient length.

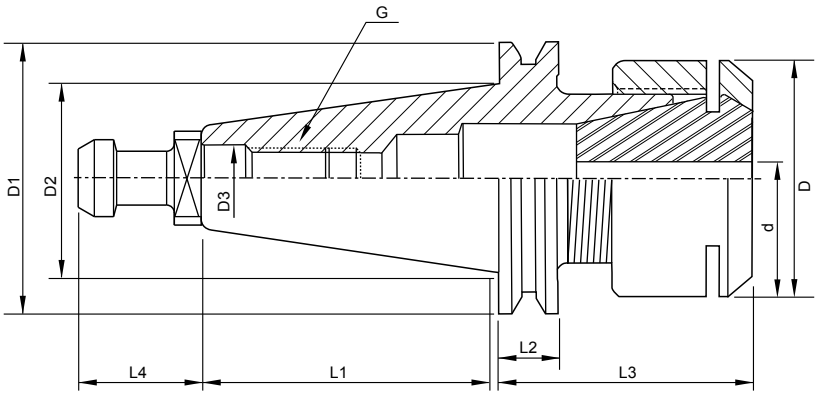
• NC Spot Drill
99616-10-M6 (P.17)
99616-14-M8 (P.19)

Order No.	Part No.	ØD	T	L	M
00-99801-12W	BC12-100M06W	12	60	100	M6xP1.0
00-99801-14W	BC14-120M08W	14	70	120	M8xP1.25
00-99801-16W	BC16-150M08W	16	80	150	M8xP1.25

ISO 20/25 Tool Holder for Engraving Machine

Tool Holder >>

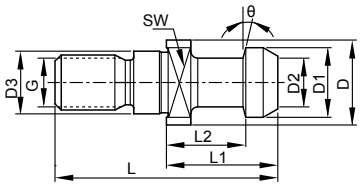
- Runout: 0.01mm (4xD).
- Max. speed: 50,000 r.p.m.
- Applied with pull stud and nut.



Taper Shank	Parts No.	Type	D1	D2	D3	D	L1	L2	L3	L4	G	Collet	Pull Stud	Clamping Nut
ISO20	225100-325	ISO20 ER16-R	33	22.2	8.5	22	33	8	30	12	M8	ER16	ISO20-D	CN-ER16R
ISO25	235100-425	ISO25 ER20-R	37	25.4	9	30	39.7	8	33	16	M8	ER20	ISO25-L	CN-ER20R

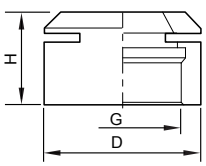
Pull Stud >>

Parts No.	Type	L	L1	L2	D	D1	D2	D3	θ	G	SW
220000-150	ISO20-D	26	12	9	12	9	6	8.5	15°	M8	10
220000-250	ISO20-L	28	14	10	11	8.5	6	8.5	15°	M8	9
230000-150	ISO25-D	28	12	9	13	11	7	9	15°	M8	11
230000-250	ISO25-L	32	16	11.5	12	10	7	9	15°	M8	10



Clamping Nut >>

Parts No.	Type	D	H	G
205100-302	CN-ER16R	22	19	M19X1.0P
205200-402	CN-ER20R	30	25	M25X1.5P



Spring Collet >>

- Concentricity (0.01mm)

Parts No: 300100-3XX	
Size	Range
ER16-3*	3-2
ER16-4	4-3
ER16-5	5-4
ER16-6	6-5
ER16-7	7-6
ER16-8	8-7
ER16-9	9-8
ER16-10	10-9

* Ordering example
ER16-3:300100-3**03**-AA

Parts No: 300100-4XX	
Size	Range
ER20-3	3-2
ER20-4	4-3
ER20-5	5-4
ER20-6	6-5
ER20-7	7-6
ER20-8	8-7
ER20-9	9-8
ER20-10*	10-9
ER20-11	11-10
ER20-12	12-11
ER20-13	13-12

* Ordering example
ER20-10:300100-4**10**-AA

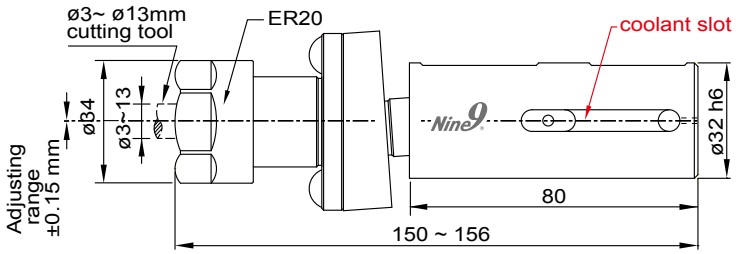
Center Height Adjusting Sleeve

Principle >>

- Designed for adjusting Center Height of center drills, NC spot drills, reamers and taps on the CNC lathes.
- The main body is made from two sleeves. The inner sleeve is to hold and lock the cutting tool.
- Its center is inclined to the outer sleeve. When the inner sleeve is pushed or pulled, the cutting tool's center height is adjusted to lower or higher position.

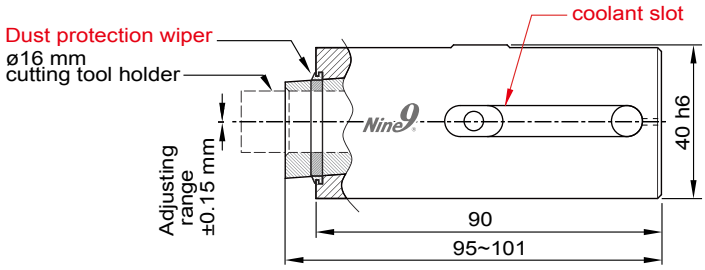
Parts No.:00-99600-320H >>

Type : SB32-IDER20



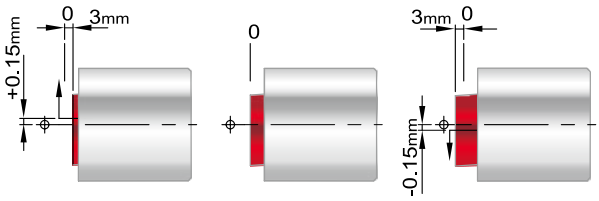
Parts No.:00-99600-400H >>

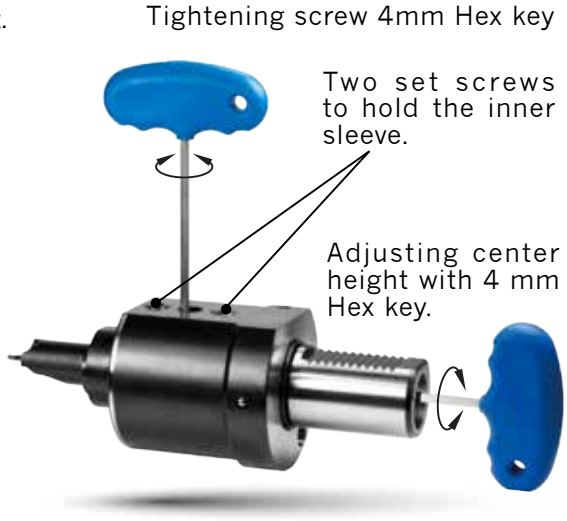
Type : SB32-ID16



Applications >>

- Used when the CNC lathes need to adjust the center height.
- This sleeve can be clamped by VDI 40, VDI 50 E2 tool holders,and other type of internal turning tool holders.
- Center height adjusting range: ±0.15 mm(.006").
- Total axial movement is 6mm(.236").





Torque Screwdriver

Patented >> Torque adapter is patented in multi-country!

- Thanks to the patented adapter driving screw easily.
- Fitting with a universal handle, the most compact size of torque screw driver in the world is built.
- Light and precise! Different torque value preset adapter is available on request.

Accuracy >> No over-tighten!

- When the demand torque is reached, there is a click sound. For continued tightening on the screw, it is no longer increase the torque on the screw.
- The limit of loosening torque is larger than the tightening torque to protect both tool and the screw from the breaking or damage

Replaceable >> Economic!

- Not only the bit, the torque adaptor is also replaceable.
- This results in plenty cost saving compared with other brands in the market.

Color Identity >> No mistake!

- The color indication is visible on both adaptors and bits.
- It is to enhance the convenience of using and delivery proper tightening torque.

Smart Kit >>

Parts No. 0-TPK01-99-06K	Nm	kgfcm	In-lb	Nine9 Inserts	Content
TX6	0.6	6.1	5.3	N9GX0402	1 x handle 1 x case 6 x torque adapters 6 x bits (25mm) Weight : 290g
TX7	0.9	9.2	8.0	N9MT05T1 V06006T1 V04506T1	
TX8	2.0	20.4	17.7	N9MT0802 V0820802	
TX9	2.0	20.4	17.7	N9GX0903 V1420803 I9MT12	
TX15	3.0	30.6	26.6	N9MT11 V9MT12 I9MT16	
TX20	5.5	56.1	48.7	N9MT17 V1421604 I9MT20/25	

Single Set >>

Parts No .	Nm	kgfcm	In-lb	25mm + 50mm	Content
0-TPK01-TX06-0.6	0.6	6.1	5.3	2 pcs + 2 pcs	1 x handle 1 x case 2 x bits (25mm) 2 x bits (50mm) Weight : 124g
0-TPK01-TX07-0.9	0.9	9.2	8.0	2 pcs + 2 pcs	
0-TPK01-TX08-1.2	1.2	12.0	10.6	2 pcs + 2 pcs	
0-TPK01-TX08-2.0	2.0	20.4	17.7	2 pcs + 2 pcs	
0-TPK01-TX09-1.4	1.4	14.0	12.4	2 pcs + 2 pcs	
0-TPK01-TX09-2.0	2.0	20.4	17.7	2 pcs + 2 pcs	
0-TPK01-TX10-2.0	2.0	20.0	17.7	2 pcs + 2 pcs	
0-TPK01-TX15-3.0	3.0	31.0	26.6	2 pcs + 2 pcs	
0-TPK01-TX20-5.0	5.0	51.0	44.3	2 pcs + 2 pcs	
0-TPK01-TX20-5.5	5.5	56.1	48.7	2 pcs + 2 pcs	

Spare Sets >> 25mm bit

- Hardness : HRC 59°~60°
- Made of high alloy steel and chrome plated.

Parts No.		25 mm
0-TPK-B01-TX06-25	TX6	6 pcs
0-TPK-B01-TX07-25	TX7	6 pcs
0-TPK-B01-TX08-25	TX8	6 pcs
0-TPK-B01-TX09-25	TX9	6 pcs
0-TPK-B01-TX10-25	TX10	6 pcs
0-TPK-B01-TX15-25	TX15	6 pcs
0-TPK-B01-TX20-25	TX20	6 pcs

Spare Sets >> 50mm bit

- Hardness : HRC 59°~60°
- Made of high alloy steel and chrome plated.

Parts No.		50 mm
0-TPK-B01-TX06-50	TX6	6 pcs
0-TPK-B01-TX07-50	TX7	6 pcs
0-TPK-B01-TX08-50	TX8	6 pcs
0-TPK-B01-TX09-50	TX9	6 pcs
0-TPK-B01-TX10-50	TX10	6 pcs
0-TPK-B01-TX15-50	TX15	6 pcs
0-TPK-B01-TX20-50	TX20	6 pcs

Notes

JIMMORE International Corp.

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