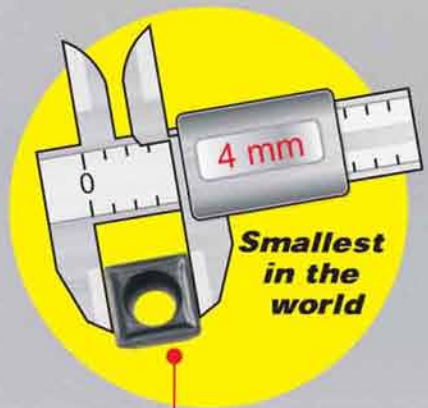
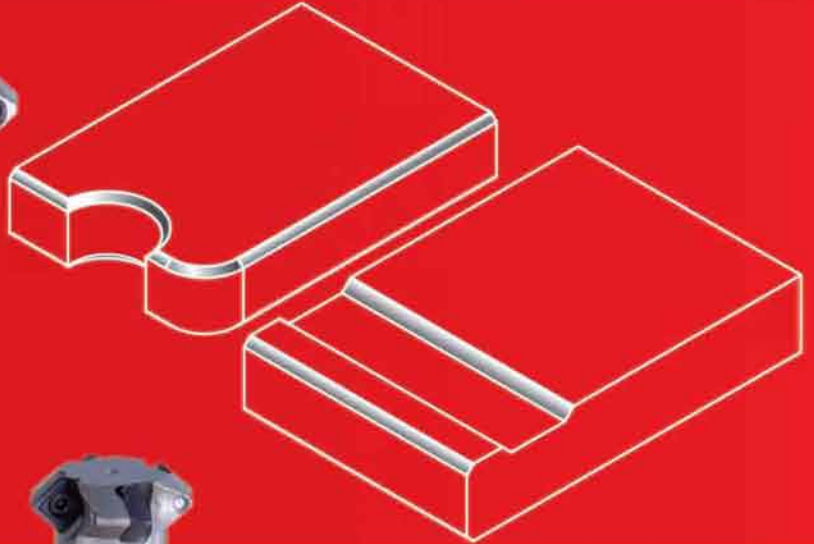
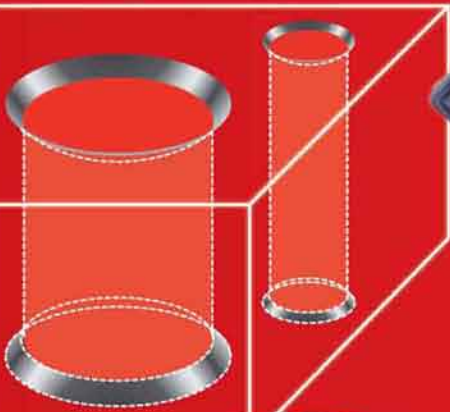


45° indexable chamfer mill



<http://www.jic-tools.com.tw>



Cat. No. 01



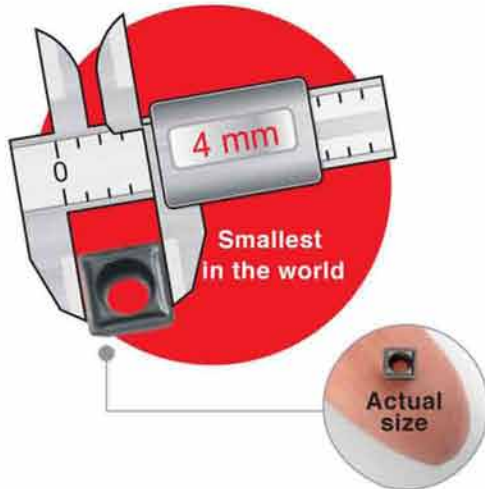
New Nine9 chamfer mill

is designed for chamfering and countersinking with an indexable insert. The insert is specifically designed for use in high speed machining. Multiple flutes provide for increased feed rates optimizing performance and reducing cycle times.



Features

- Smallest insert in the world for chamfering mill.
 - Smallest Indexable counter sink, diameter $\varnothing 0.276$ ".
 - The dual-relief angle inserts specially honed and coated for high cutting speeds.
 - Optimized number of teeth on the holder to achieve higher feed rates.
 - For front and back chamfering.
- Eliminates 2nd operation or de-burring time.



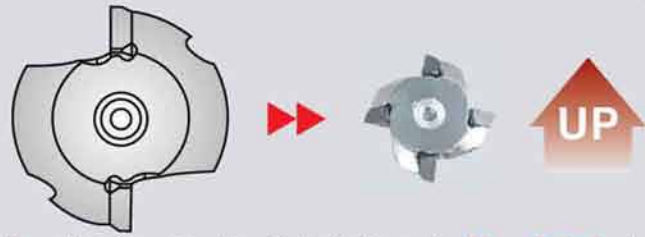
Applications

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



- Comparison with other manufacturers chamfer tool with larger insert(Sxxx1204) and Nine9 N9GX04 insert.

	Other makers with Large insert	Nine 9 Chamfer mills
Chamfering	0.039"	0.039"
Feed rate inch/rev.	0.004"	0.004"
Dia. of cutter	1.26"	0.433"
Teeth of cutter	2	4
Cutting speed (SFM)	660	990
Spindle speed (R.P.M)	2000	8700
Feed (IPM)	16	139



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

$$\text{UP Spindle Speed} = \frac{\text{Cutting Speed} \times 3.82}{\text{Cmin.}}$$

Cylindrical Shank Holders

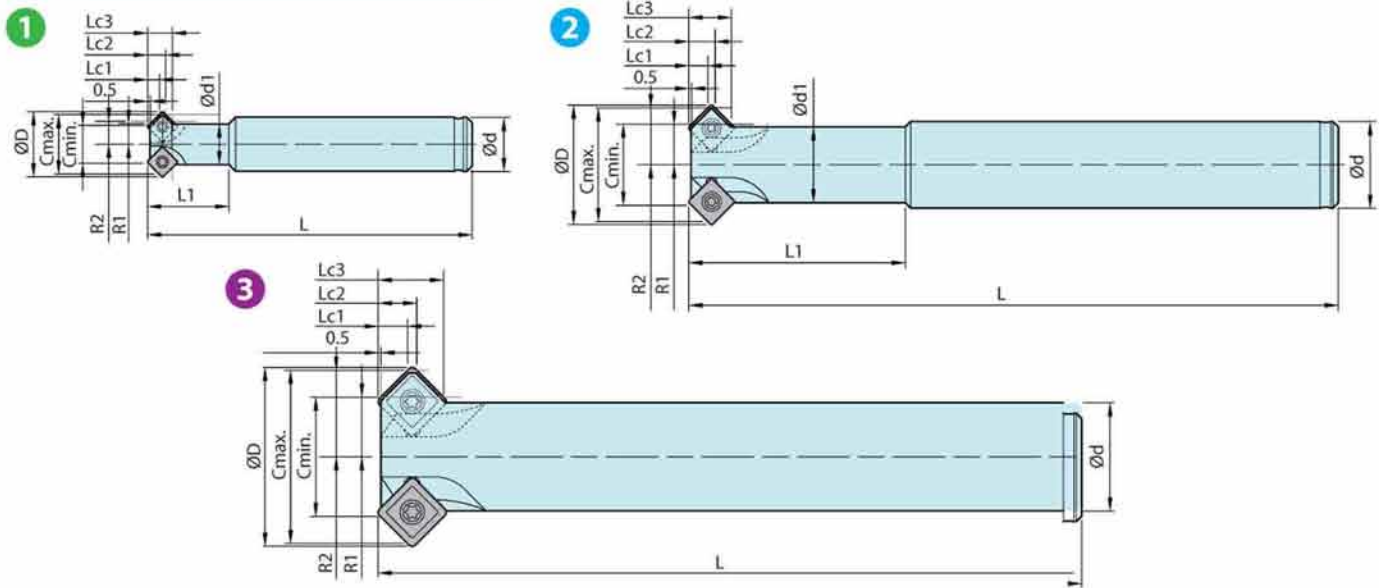


Fig.	Part No.	Type	Cmin. Ø	Cmax. Ø	Shank Ø	Ød1	ØD	R1	R2	L	L1	Lc1	Lc2	Lc3	⊕Z	Insert Screw / Key
1	99616-C10	BC10-C07-60	7 (.276")	11 (.433")	10 (.394")	7.5 (.295")	12 (.472")	3.8	4.3	60	15	2.2	3.3	4.6	2	N9GX04T002 NS-18037 / NK-T6
2	99616-C20	BC12-C11-100	11 (.433")	16 (.630")	12 (.472")	9.6 (.378")	16.2 (.638")	5.9	8	100	25	2.6	2.9	5.0	4	N9GX060204 NS-22055 / NK-T7
2	99616-C30	BC16-C15-120	15 (.590")	21 (.827")	16 (.630")	14 (.551")	22 (.866")	7.5	11.5	120	40	3.5	4.9	7.9	4	N9GX090308 NS-30072 / NK-T9
2	99616-C40	BC20-C19-130	19 (.748")	25 (.984")	20 (.787")	18 (.709")	26 (1.024")	9.5	12.5	130	50	3.5	4.9	7.9	4	N9GX090308 NS-30072 / NK-T9
3	99616-C50	BC20-C22-130	22 (.866")	32 (1.260")	20 (.787")	-	33 (1.299")	11	16	130	-	5.5	7.1	12.1	4	N9GX090308 NS-30072 / NK-T9
2	99616-C52	BC25-C22-180	22 (.866")	32 (1.260")	25 (.984")	20 (.787")	33 (1.299")	11	16	180	80	5.5	7.1	12.1	4	N9GX090308 NS-30072 / NK-T9

Kit

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



Nine⁹® 45° indexable chamfer mill

Insert

Features:

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

Patented
Dual-relief
angle insert



- **Grade NC2032** : K20F grade, AlTiN coated. The 1st choice for high carbon, high alloy and hardened steels as well as cast iron.



NC2032

- **Grade NC9071**: K20F grade, TiN coated, high positive rake angle and honed sharp edge. The best choice for low carbon steel, low carbon alloy steel, stainless steel, Al, Al-alloy, Brass, Bronze and most of the non-ferrous metal.



NC9071

Ordering Code			Dimensions			
Code of insert	Grade		L	S	re	Screw / Key
N9GX04T002	NC2032		4.0	1.8	0.2	NS-18037 / NK-T6
N9GX060204	NC9071		6.35	2.38	0.4	NS-22055 / NK-T7
N9GX090308			9.52	3.18	0.8	NS-30072 / NK-T9

Cutting Data

Work piece material		Grade of insert	Cutting Speed SFM feet / min.	Feed rate inch / tooth		
Material Group	Sample Code (AISI)			N9GX04T002 Max. Chamfering 0.059 inch	N9GX060204 Max. Chamfering 0.098 inch	N9GX090308 Max. Chamfering 0.157 inch
Carbon steel C<0.3%	1015	NC9071	500-820-1150	0.002" ~ 0.005"	0.004" ~ 0.010"	0.004" ~ 0.010"
Carbon steel C>0.3%	1050	NC2032	660-1050-1310	0.002" ~ 0.004"	0.004" ~ 0.008"	0.004" ~ 0.010"
Low alloy steel C<0.3%	4130	NC9071	590-790-860	0.002" ~ 0.004"	0.004" ~ 0.008"	0.004" ~ 0.008"
High alloy steel C>0.3%	D2	NC2032	390-500-660	0.002" ~ 0.004"	0.004" ~ 0.006"	0.004" ~ 0.006"
Hardened steel <HRC50°	H13	NC2032	265-300-330	0.002" ~ 0.004"	0.002" ~ 0.005"	0.004" ~ 0.006"
Stainless steel	304	NC9071	390-500-590	0.002" ~ 0.004"	0.002" ~ 0.006"	0.004" ~ 0.008"
Casting iron	A48 35B / No 35B	NC2032	390-500-590	0.002" ~ 0.004"	0.004" ~ 0.006"	0.004" ~ 0.008"
Al, and non-ferrous metal	6061	NC9071	660-1310-1970	0.002" ~ 0.006"	0.004" ~ 0.010"	0.004" ~ 0.010"

* Not recommended for hand held power tools.



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