



### PROMO PACK: 2 INCH CUTTER

## HIGH PERFORMANCE CUTTER PROMO PACK

- Start cutting right away with cutter and inserts at a lower cost than a cutter alone
- 2 inch cutter with 3 cutting insert slots
- Includes ten (10) pcs of SX9 Ceramic Inserts

**APPLICATIONS:  
HEAT RESISTANT  
ALLOYS**

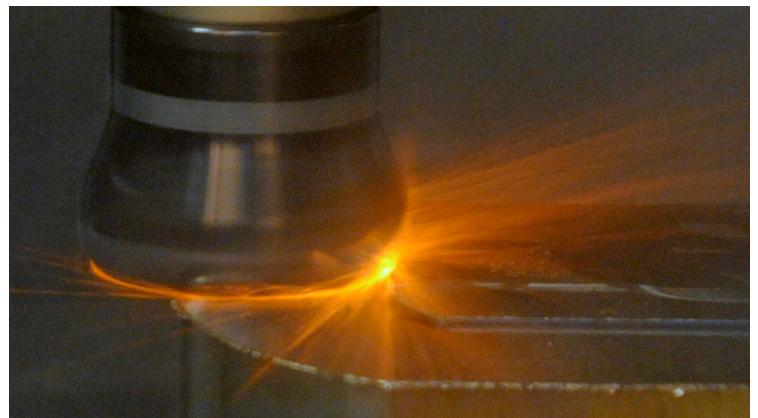


## THE PREMIER LINE OF ADVANCED CUTTING TOOLS

### NTK SX9 Ceramic

## A BALANCE OF STRENGTH AND WEAR RESISTANCE

- Excellent notch wear resistance
- Better flank resistance compared to competitor's silicon nitride ceramics
- Superior toughness compared to Whisker-reinforced Ceramics
- Best thermal shock resistance
- Best grade for roughing Inco 718 with scale

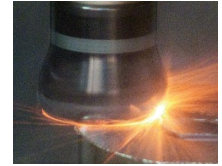


**SEE BACK FOR TOOLING  
INFORMATION AND  
CUTTING PARAMETERS**

Item	Included in Promo Pack	Price
RNIW200-RNG45 EDP #6001138	1pc -RNIW200S075R03 10pcs - RNG45T220 SX9	<b>\$399.00</b>



### High Performance Cutter **RNIW200-RNG45** Promo Pack: EDP# 6001138



**RNIW200S075R03** - EDP# 5660626

**RNG45T0220 SX9** - EDP# 5650106  
Recommend Torque wrench @ 35lbs. (4Nm)

- 2 Inch Cutter
- Heat Resistant Alloy Machining

Work Material	Grade	Dry	Wet	Cutting Speed (SFM)						Feed (IPT)						Depth of Cut (inch)	
				200	700	1200	1700	2200	2700	3200	3700	.002	.003	.004	.005		.006
S Heat Resistant Alloys	<b>SX9</b>	●															~.150

### Guidelines for Successful Milling by Material

#### ● Trouble shooting

Material	Insert Grade	NTK Grade	Problem	Solution					
				Speed	Feed	DOC	Edge Prep.	Insert Grade	Others
Heat Resistant Alloy	SiAlON	<b>SX9</b>	Notching	↗	↗	Vary / ↘	Wider	—	Pre-chamfer parts
			Flank Wear	↘	↗	—	—	Harder	—
			Chipping	—	—	—	Wider	Tougher	—
			Break	↘	—	↘	—	Tougher	—
			Tool Pressure	—	—	—	—	—	Use RPG insert

- Down or climb milling where the chip thins upon exit is the preferred method for HNBA materials
- Reduce feed rate 50% upon entrance and exit
- Do not re-cut side walls as this can cause work hardening
- Use balanced shell mill adapter or shrink fit for end mills
- As DOC gets thinner the feed must be increased to compensate for heat loss
- Use RPG geometries if tool pressure is a problem