

JRF Milling Cutter

For Heat-Resistant Alloys | Ceramics



CERTainly (but not only) *CERamics*

Outstanding solutions for demanding applications

NTK's JRF Cutter, available in small diameters ($\phi 16-32\text{mm}/\phi.63- 1.26''$), features a unique negative geometry that not only enables high-efficiency machining but also offers superior cost performance compared to competitors. A new addition to this product line is the modular-type JRF Cutter with an interchangeable head, which has now been released.



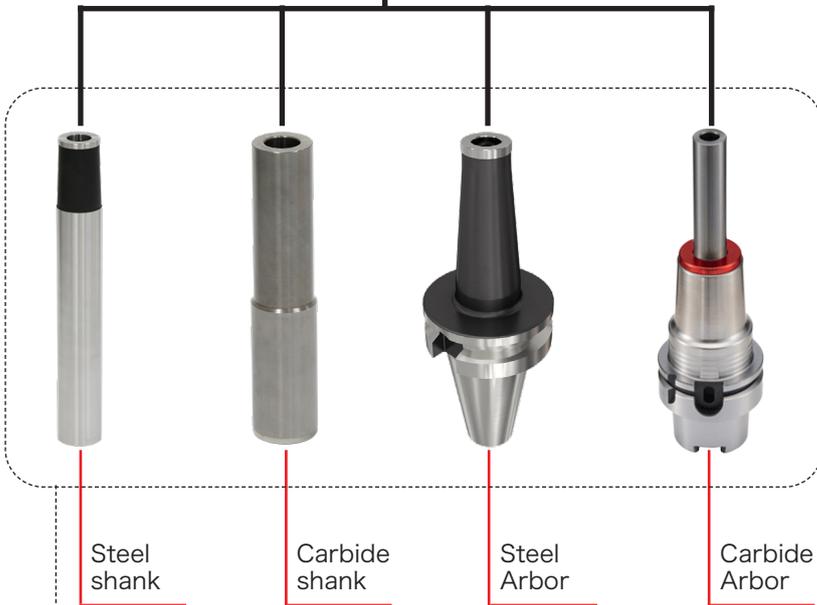
Introducing a New Era of High-Efficiency Machining: The Fusion of NTK's JRF Modular cutter and Tungaloy's TUNG-FLEX arbor and modular shank

Head Diameter: $\phi 16(.63")/\phi 20(.79")/\phi 25(.98")/\phi 32(1.26")$
Number of inserts per head: 3/4/5



Features

- Higher number of inserts for even higher efficiency
- Negative inserts with higher cutting edge strength for more stable machining
- Economical negative insert that can be used on both sides



Features

Various types of modular heads can be combined with different shanks and holders for multiple application needs.

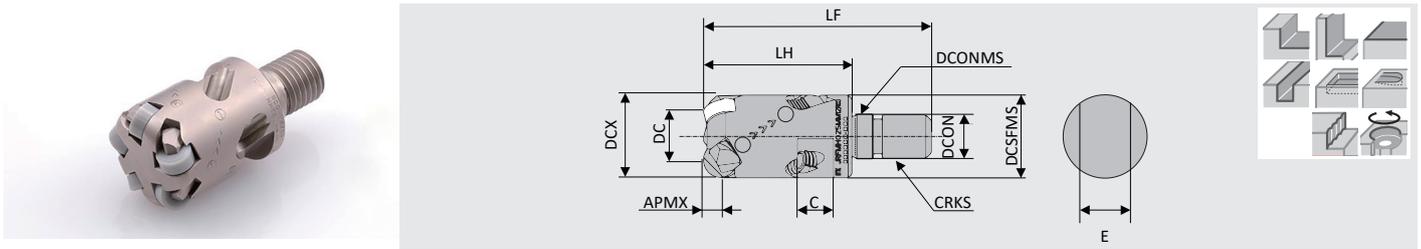
- Steel / Carbide shank series
- Arbors – BT, HSK type

TUNG FLEX
TUNGALOY

JRF Modular type

TUNGFLEX shank x Modular type JRF cutter, with RNGF negative insert

GAMP = -10° ~ -15°, GAMF = -20° ~ -28°



Designation	APMX	DC	DCX	CICT	DCONMS	DCSFMS	LF	LH	C	E	CRKS	WT(kg)	Insert
JRFMH016MM08R03	1	9.65	16	3	8.5 (h7)	15	53	35	8	13	M8	0.04	RNGF0603..
JRFMH020MM10R03	1	13.65	20	3	10.5 (h7)	19	54	35	10	16	M10	0.07	RNGF0604..
JRFMH025MM12R03	1	15.475	25	3	12.5 (h7)	23	63	41	12	19	M12	0.11	RNGF0904..
JRFMH025MM12R04	1	18.65	25	4	12.5 (h7)	23	63	41	12	19	M12	0.13	RNGF0604..
JRFMH032MM16R03	1	19.3	32	3	17 (h7)	30	63	40.5	12	24	M16	0.2	RNGF1204..
JRFMH032MM16R04	1	22.475	32	4	17 (h7)	30	63	40.5	12	24	M16	0.19	RNGF0904..
JRFMH032MM16R05	1	22.475	32	5	17 (h7)	30	63	40.5	12	24	M16	0.21	RNGF0904..

Designation	APMX	DC	DCX	CICT	DCONMS	DCSFMS	LF	LH	C	E	CRKS	WT(lb)	Insert
JRFMH016MM08R03	1	0.38	0.63	3	0.335	0.591	2.087	1.378	0.315	0.512	M8	0.088	RNGF0603..
JRFMH020MM10R03	1	0.537	0.787	3	0.413	0.748	2.126	1.378	0.394	0.472	M10	0.154	RNGF0604..
JRFMH025MM12R03	1	0.609	0.984	3	0.492	0.906	2.48	1.614	0.472	0.512	M12	0.243	RNGF0904..
JRFMH025MM12R04	1	0.734	0.984	4	0.492	0.906	2.48	1.614	0.472	0.512	M12	0.265	RNGF0604..
JRFMH032MM16R03	1	0.76	1.26	3	0.669	1.181	2.48	1.594	0.472	0.945	M16	0.441	RNGF1204..
JRFMH032MM16R04	1	0.885	1.26	4	0.669	1.181	2.48	1.594	0.472	0.945	M16	0.419	RNGF0904..
JRFMH032MM16R05	1	0.885	1.26	5	0.669	1.181	2.48	1.594	0.472	0.945	M16	0.463	RNGF0904..

SPARE PARTS

Designation	Cap screw	Wedge screw	Wrench	Wrench (sold separately)
JRFMH016MM08R03	HCS3P050	HWS3P050	LW-2.5	(DL-025-08-JRF)
JRFMH020MM10R03	HCS3P050	HWS3P050	LW-2.5	(DL-025-08-JRF)
JRFMH025MM12R03	HCS5P080	HWS5P080	LW-4.0	(DL-040-20-JRF)
JRFMH025MM12R04	HCS3P050	HWS3P050	LW-2.5	(DL-025-20-JRF)
JRFMH032MM16R03	HCS5P080	HWS5P080	LW-4.0	(DL-040-20-JRF)
JRFMH032MM16R04	HCS5P080	HWS5P080	LW-4.0	(DL-040-20-JRF)
JRFMH032MM16R05	HCS3P050	HWS3P050	LW-2.5	(DL-025-20-JRF)

Recommended Clamping Torque: CRKS / M8 = 23 N·m, M10 = 46 N·m, M12 = 80 N·m, M16 = 90 N·m

INSERT

RNGF-HNF



P	Steel		
M	Stainless		
K	Cast iron		
N	Non-ferrous		
S	Superalloy	★	☆
H	Hard materials		

★ : First choice
☆ : Second choice

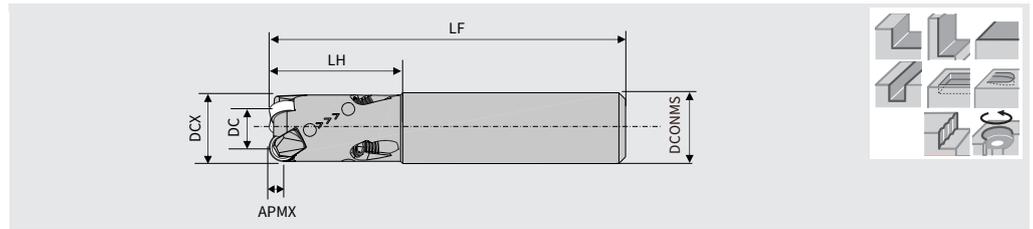
Designation		SiAlON		IC		S	
Metric	Inch	SX3	SX9	Metric	Inch	Metric	Inch
RNGF 060300 E -HNF	RNGF 220 E02 -HNF	●	●	6.35	1/4	3.18	1/8
RNGF 060400 E -HNF	RNGF 230 E02 -HNF	●	●	6.35	1/4	4.76	3/16
RNGF 090400 E -HNF	RNGF 330 E02 -HNF	●	●	9.525	3/8	4.76	3/16
RNGF 120400 E -HNF	RNGF 430 E02 -HNF	●	●	12.7	1/2	4.76	3/16

●: Line up

JRF Shank type - Metric size

For HRSA material with RNGF negative insert

GAMP = -10° ~ -15°, GAMF = -20° ~ -28°



Designation	APMX	DC	DCX	CICT	DCONMS	LF	LH	WT(kg)	Insert
JRFMH016E160R03	1	9.65	16	3	16	80	30	0.11	RNGF0603..
JRFMH020E200R03	1	13.65	20	3	20	100	40	0.22	RNGF0604..
JRFMH025E250R03	1	15.475	25	3	25	100	40	0.33	RNGF0904..
JRFMH025E250R04	1	18.65	25	4	25	100	40	0.34	RNGF0604..
JRFMH032E320R03	1	19.3	32	3	32	120	50	0.67	RNGF1204..
JRFMH032E320R04	1	22.475	32	4	32	120	50	0.67	RNGF0904..
JRFMH032E320R05	1	22.475	32	5	32	120	50	0.68	RNGF0904..

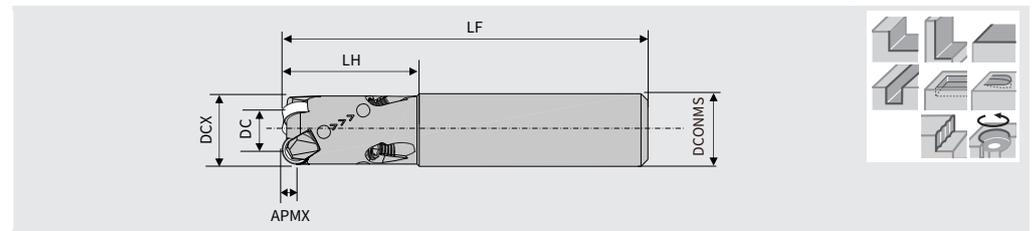
SPARE PARTS

Designation	Cap screw	Wedge screw	Wrench	Wrench (sold separately)
JRFMH016E160R03	HCS3P050	HWS3P050	LW-2.5S	(DL-025-08-JRF)
JRFMH020E200R03	HCS3P050	HWS3P050	LW-2.5S	(DL-025-08-JRF)
JRFMH025E250R03	HCS5P080	HWS5P080	LW-4.0	(DL-040-20-JRF)
JRFMH025E250R04	HCS3P050	HWS3P050	LW-2.5	(DL-025-20-JRF)
JRFMH032E320R03	HCS5P080	HWS5P080	LW-4.0	(DL-040-20-JRF)
JRFMH032E320R04	HCS5P080	HWS5P080	LW-4.0	(DL-040-20-JRF)
JRFMH032E320R05	HCS3P050	HWS3P050	LW-2.5	(DL-025-20-JRF)

JRF Shank type - Inch size

For HRSA material with RNGF negative insert

GAMP = -10° ~ -15°, GAMF = -20° ~ -28°



Designation	APMX	DC	DCX	CICT	DCONMS	LF	LH	WT(lbs)	Insert
JRFIH0625E0625R03	0.039	0.375	0.625	3	0.625	3.16	1.191	0.243	RNGF22..
JRFIH075E075R03	0.039	0.5	0.75	3	0.75	4	1.638	0.485	RNGF23..
JRFIH100E100R03	0.039	0.625	1	3	1	4	1.638	0.728	RNGF33..
JRFIH100E100R04	0.039	0.75	1	4	1	4	1.638	0.750	RNGF23..
JRFIH125E125R03	0.039	0.75	1.25	3	1.25	4.725	1.969	1.477	RNGF43..
JRFIH125E125R04	0.039	0.875	1.25	4	1.25	4.725	1.969	1.477	RNGF33..
JRFIH125E125R05	0.039	0.875	1.25	5	1.25	4.725	1.969	1.499	RNGF33..

SPARE PARTS

Designation	Cap screw	Wedge screw	Wrench	Wrench (sold separately)
JRFIH0625E0625R03	HCS3P050	HWS3P050	LW-2.5S	(DL-025-08-JRF)
JRFIH075E075R03	HCS3P050	HWS3P050	LW-2.5S	(DL-025-08-JRF)
JRFIH100E100R03	HCS5P080	HWS5P080	LW-4.0	(DL-040-20-JRF)
JRFIH100E100R04	HCS3P050	HWS3P050	LW-2.5	(DL-025-20-JRF)
JRFIH125E125R03	HCS5P080	HWS5P080	LW-4.0	(DL-040-20-JRF)
JRFIH125E125R04	HCS5P080	HWS5P080	LW-4.0	(DL-040-20-JRF)
JRFIH125E125R05	HCS3P050	HWS3P050	LW-2.5	(DL-025-20-JRF)

INSERT

RNGF-HNF



P	Steel		
M	Stainless		
K	Cast iron		
N	Non-ferrous		
S	Superalloy	★	☆
H	Hard materials		

★ : First choice
☆ : Second choice

Designation		SiAlON		IC		S	
Metric	Inch	SX3	SX9	Metric	Inch	Metric	Inch
RNGF 060300 E -HNF	RNGF 220 E02 -HNF	●	●	6.35	1/4	3.18	1/8
RNGF 060400 E -HNF	RNGF 230 E02 -HNF	●	●	6.35	1/4	4.76	3/16
RNGF 090400 E -HNF	RNGF 330 E02 -HNF	●	●	9.525	3/8	4.76	3/16
RNGF 120400 E -HNF	RNGF 430 E02 -HNF	●	●	12.7	1/2	4.76	3/16

● : Line up

Line up introduction



Steel shank

Steel shank series

- Modular – ER collet
- Modular – TungFit
- Modular – Straight shank



Carbide shank

Carbide shank series

- Increased cutting parameters can be applied to carbide modular shank over steel modular shank
- Enhanced chatter control for long tool overhang
- Coolant-through design suited for ramping for cavity and pockets



Steel Arbor

Arbor type series

- Modular – BT taper
- Modular – HSK

- Cutter heads can be directly connected to holders, increasing rigidity
- Reduces tool changing time
- DIN 69871 or CAT tapers are available



Carbide Arbor



BT type



HSK type

Recommended Machining Parameters

Grade	Workpiece Material	Machining process	Cutting conditions				D.O.C. (mm) (inch)	DRY	WET
			Cutting Speed (m/min) ※ (sfm)	Feed (mm/rev) (ipt)					
SX3 SX9	HRSA	Milling	400 - 700 - 1000 (1300 - 2300 - 3280)	0.08 - 0.10 - 0.12 (.0032 - .0039 - .0047)			- 1.0 (- 0.394)	●	×

※Value calculated with the outermost diameter of the cutter

Exceeding the recommended cutting conditions may damage the insert. Please machine within the recommended cutting conditions

Insert grade characteristics



SX3

The First Recommended Grade for Machining Heat-Resistant Alloys with Ceramics: Balancing Wear Resistance and Fracture Resistance.

SX9

Grade with emphasis on fracture resistance

Wear resistance ↑ High

First recommendation

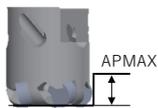
SX3

SX9

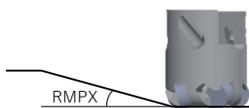
Fracture resistance → High

Processing form

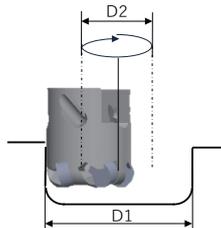
Shoulder/Slotting



Ramping



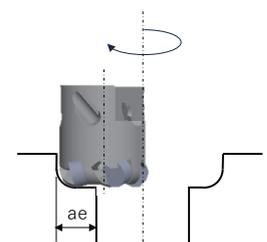
Drilling (Helical feed)



Plunging



Enlarged hole



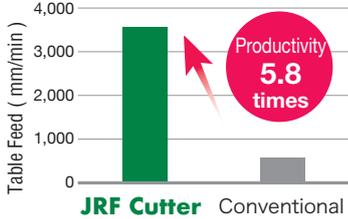
Machinable range (mm)

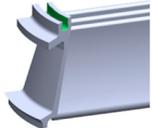
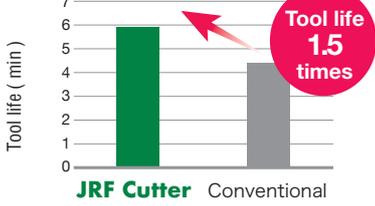
Modular type	Shank	φDc	Max. Depth of cut APMAX	Max. ramping angle RMPX (°)	Min. machinable hole dia. φD1	Max. machinable hole dia. φD1	Min. machinable hole dia. φD2	Max. machinable hole dia. φD2	Max. Cutting width in plunging W	Max. cutting width in enlarged hole ae	MAX RPM (min ⁻¹)
JRFMH016MM08R03	JRFMH016E160R03	16	1.0	1.0	25.7	30.0	9.7	14.0	3.1	12.9	20,000
JRFMH020MM10R03	JRFMH020E200R03	20	1.0	0.9	33.7	38.0	13.7	18.0	3.2	16.8	17,500
JRFMH025MM12R03	JRFMH025E250R03	25	1.0	1.0	40.7	48.0	15.7	23.0	4.7	20.3	15,000
JRFMH025MM12R04	JRFMH025E250R04	25	1.0	0.5	43.8	48.0	18.8	23.0	3.1	21.9	15,000
JRFMH032MM16R03	JRFMH032E320R03	32	1.0	0.9	51.6	62.0	19.6	30.0	6.2	25.8	12,500
JRFMH032MM16R04	JRFMH032E320R04	32	1.0	0.9	54.5	62.0	22.5	30.0	4.7	27.3	12,500
JRFMH032MM16R05	JRFMH032E320R05	32	1.0	1.1	54.4	62.0	22.4	30.0	4.8	27.2	12,500

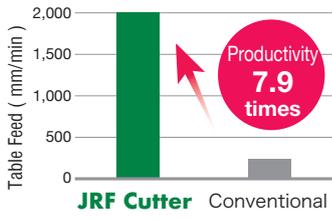
Machinable range (in)

Shank type	φDc	Max. Depth of cut APMAX	Max. ramping angle RMPX (°)	Min. machinable hole dia. φD1	Max. machinable hole dia. φD1	Min. machinable hole dia. φD2	Max. machinable hole dia. φD2	Max. Cutting width in plunging W	Max. cutting width in enlarged hole ae	MAX RPM (min ⁻¹)
JRFIH0625E0625R03	0.625	0.039	1.0	1.003	1.171	0.378	0.546	0.124	0.501	20,000
JRFIH075E075R03	0.75	0.039	0.9	1.252	1.421	0.502	0.671	0.124	0.626	17,500
JRFIH100E100R03	1.00	0.039	1.0	1.633	1.921	0.633	0.921	0.184	0.816	15,000
JRFIH100E100R04	1.00	0.039	0.5	1.758	1.921	0.758	0.921	0.121	0.879	15,000
JRFIH125E125R03	1.25	0.039	1.1	2.012	2.421	0.762	1.171	0.244	1.006	12,500
JRFIH125E125R04	1.25	0.039	1.0	2.127	2.421	0.877	1.171	0.186	1.064	12,500
JRFIH125E125R05	1.25	0.039	1.2	2.121	2.421	0.871	1.171	0.189	1.061	12,500

Machining Examples

	NTK	Conventional			
Component	Combustion case				
Toolholder	JRFIH0625E0625R03	Solid Endmill			
Grade	SX3	Coated Carbide			
	Waspaloy				
Workpiece					
Cutting conditions	Cutting speed (m/min) (SFM)	600	1,968 SFM	120	394 SFM
	Feed per tooth (mm/t) (inch/t)	0.1	.0039	0.03	.0012
	Table feed (mm/min) (IPM)	3,609	142.1 IPM	610	24.0 IPM
	a_p (mm) (inch)	1	.0394	6.35	.25
	a_e (mm) (inch)	5.1	.201	1.6	.063
	Coolant	DRY		WET	
Results	 <p>Table Feed (mm/min)</p> <p>Productivity 5.8 times</p> <p>JRF Cutter Conventional</p>				
	<p>By using JRF, cutting edge chipping was improved, and productivity increased by 5.8 times.</p>				

	NTK	Conventional			
Component	Gas Turbine Component				
Toolholder	JRFMH032E320R05	$\phi 32$			
Grade	SX3	Ceramic			
	Inconel 718				
Workpiece					
Cutting conditions	Cutting speed (m/min) (SFM)	1200	3,937 SFM	1000	3,281 SFM
	Feed per tooth (mm/t) (inch/t)	0.1	.0039	0.15	.0059
	Table feed (mm/min) (IPM)	5,968	235 IPM	4,476	176.3 IPM
	a_p (mm) (inch)	0.8	.0315	0.8	.0315
	a_e (mm) (inch)	5	.197	5	.197
	Coolant	DRY		DRY	
Results	 <p>Tool life (min)</p> <p>Tool life 1.5 times</p> <p>JRF Cutter Conventional</p>				
	<p>Leading to a 1.5 times increase in tool life and a 1.3 times boost in productivity compared to competitors, resulting in improved overall efficiency.</p>				

	NTK	Conventional			
Component	Fan Blade				
Toolholder	JRFMH020E200R03	Solid Endmill			
Grade	SX3	Coated Carbide			
	Inconel 718				
Workpiece					
Cutting conditions	Cutting speed (m/min) (SFM)	600	1,968 SFM	20	66 SFM
	Feed per tooth (mm/t) (inch/t)	0.07	.0028	0.4	.0157
	Table feed (mm/min) (IPM)	2,005	78.94 IPM	255	10.04 IPM
	a_p (mm) (inch)	0.5	.0197	0.6	.0236
	Coolant	DRY		WET	
	Results	 <p>Table Feed (mm/min)</p> <p>Productivity 7.9 times</p> <p>JRF Cutter Conventional</p>			
<p>Cutting speed increased by about 30 times and table feed by 7.9 times compared to conventional tools. This resulted in a significant boost in productivity and machining efficiency.</p>					

	NTK	Conventional			
Component	Aerospace Component				
Toolholder	JRFIH075E075R03	Solid Endmill			
Grade	SX9	Coated Carbide			
	Stellite 6B				
Workpiece					
Cutting conditions	Cutting speed (m/min) (SFM)	627	2,058 SFM	61	200 SFM
	Feed per tooth (mm/t) (inch/t)	0.08	.00315	0.025	.00098
	Table feed (mm/min) (IPM)	2,514	99 IPM	191	7.52 IPM
	a_p (mm) (inch)	0.5	.0197	1	.0394
	a_e (mm) (inch)	9.525	.375	0.38	.015
	Coolant	DRY		WET	
Results	 <p>Tool life (components)</p> <p>Tool life 3 times</p> <p>JRF Cutter Conventional</p>				
	<p>SX9 is toughest ceramic grade. Excellent thermal shock and fracture resistance. As a result, SX9 achieved 3 times tool life and 13 times productivity.</p>				

I Trouble shooting ~ How to eliminate chattering

Please try in the order from ① to ⑤.

① Speed V_c : 20~30%



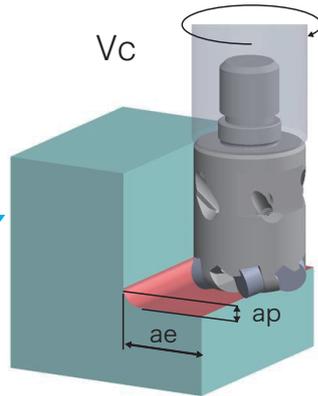
② Depth of cut a_p : 20~50%

DOWN



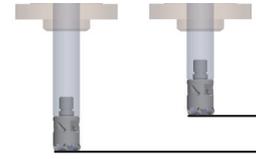
③ a_e : 20~50%

DOWN



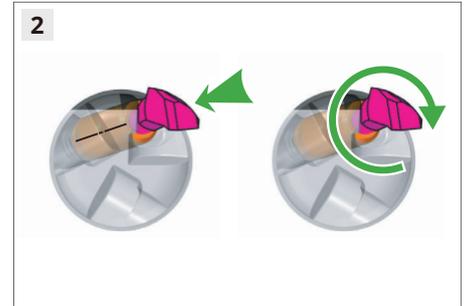
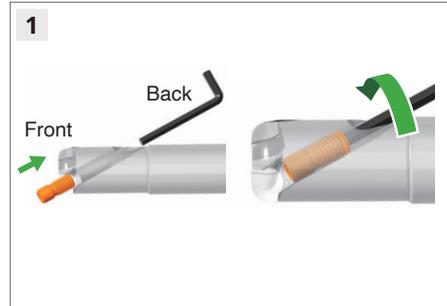
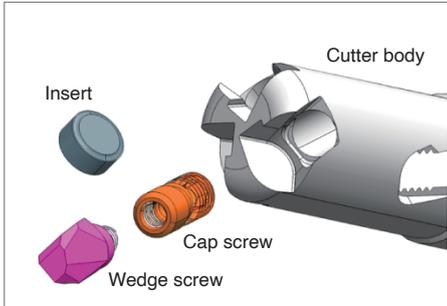
④ Overhang amount: 1D~2D

DOWN



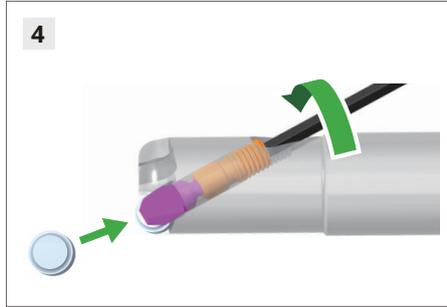
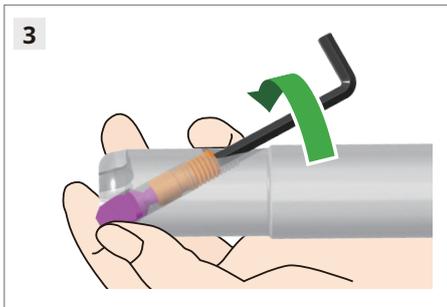
⑤ Modular shank changed to carbide shank

JRF cutter parts installation manual



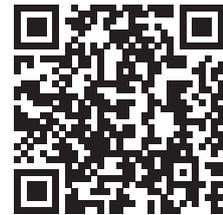
1 Insert the cap screw from the front, insert a hex wrench from the back side, and rotate it **360 degrees (1 turn)**.

2 Insert the wedge screw into the cap screw and rotate it **360 degrees (1 turn)** by hand.



3 Hold the wedge screw and tighten the cap screw with the hex wrench **until it stops, then loosen it 360 degrees (1 turn) ***.
*Loosen 360° for insert space

4 First, insert the insert. Then, insert the torque wrench from the back side and **tighten to the specified torque value**.



Video explanation

Shank type Designation	Modular type Designation	Recommended tightening torque*	Cap screw	Wedge screw
JRFMH016E160R03	JRFMH016MM08R03	2N·m	HCS3P050	HWS3P050
JRFIH0625E0625R03				
JRFMH020E200R03	JRFMH020MM10R03			
JRFIH075E075R03				
JRFMH025E250R04	JRFMH025MM12R04			
JRFIH100E100R04				
JRFMH032E320R05	JRFMH032MM16R05	4N·m	HCS5P080	HWS5P080
JRFIH125E125R05				
JRFMH025E250R03	JRFMH025MM12R03			
JRFIH100E100R03				
JRFMH032E320R03	JRFMH032MM16R03			
JRFIH125E125R03				
JRFMH032E320R04	JRFMH032MM16R04			
JRFIH125E125R04				

※If the recommended cutting conditions or tightening torque are exceeded, the insert, cutter body, cap screw, or wedge screw may be damaged. Please ensure machining is performed within the specified recommended range.

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