



THE FUTURE OF PRECISION MACHINING

NiTiCo LINE

The New Generation Of Trochoidal Milling



NiTiCo 30 DH



01

5 Flutes Design

- The 5 flute design offers increased feed rates up to 25% over 4 flute tools and can be used in slotting, profiling and semi-finishing applications.

02

Small Corner Radius

- For less chipping of the cutting edges and longer tool life.

03

Variable Helix (DH)

- For chatter free machining and excellent surface finishes.

04

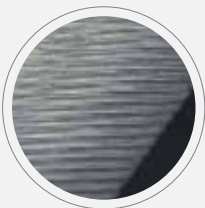
The Perfect Edge Design

- Provides a stable cutting edge with much reduced possibility of chipping while prolonging the tool life.

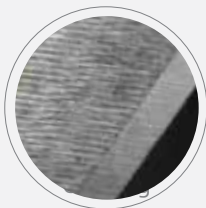
05

Oil Hole for High Performance Milling

- Improves welding resistance
- Enables a wide range of machining processes
- Especially beneficial for Difficult to Cut Materials, offering stable machining



Eccentric Grinding



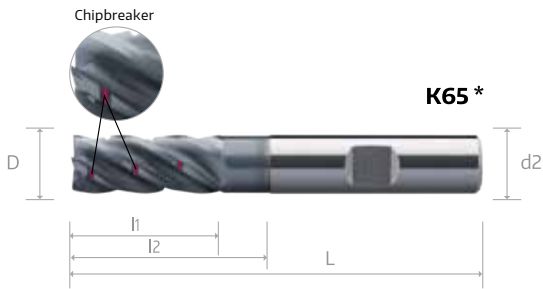
Perfect Edge Grinding



06

Optimized Geometry with Chipbreakers

- Efficiently shears work materials and shortens chips for improved chips removal.



EDP No. / EDV-Nr / CODE usine / Codice EDP	Dimension (mm)						K65 *
	D	l1	l2	L	d2 (h6)	R	Coolant Hole
							G6110
0400 057 06	4	10	15	57	6	0.1	•
0600 057	6	15	20	57	6	0.1	•
0800 064	8	20	25	64	8	0.2	•
1000 072	10	25	30	72	10	0.2	•
1200 083	12	30	40	83	12	0.3	•
1600 092	16	40	50	92	16	0.3	•
2000 104	20	50	60	104	20	0.3	•

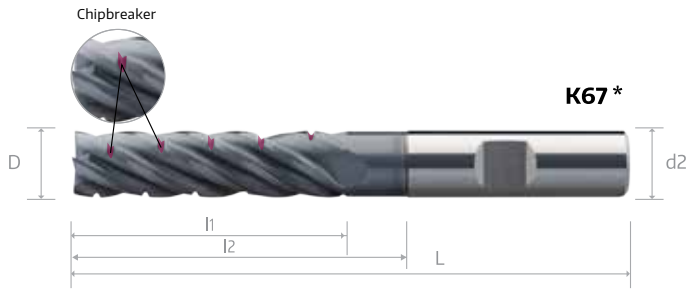
Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类



CNC Repeatability
Ø1-Ø3 within 10µm
Ø4-Ø8 within 15µm
≥ Ø10 within 20µm

Cutting Parameter

4



EDP No. / EDV-Nr / CODE usine / Codice EDP	Dimension (mm)						K67 *
	D	l1	l2	L	d2 (h6)	R	Coolant Hole
							G6110
= * + Ø data							
0600	6	26	32	75	6	0.1	•
0800	8	32	38	75	8	0.2	•
1000	10	42	52	100	10	0.2	•
1200	12	48	60	100	12	0.3	•
1600	16	60	68	125	16	0.3	•
2000	20	70	78	125	20	0.3	•

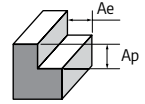
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CNC Repeatability
Ø1-Ø3 within 10µm
Ø4-Ø8 within 15µm
≥ Ø10 within 20µm

Cutting Parameter

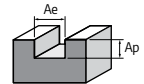
6



Standard Endmill, 5 Flute

	P01		P02		P03		M01		M02		K01		K02		S01	
			520 < Rm < 1200		35 ≤ HRC < 45											
	0.80 × D		0.80 × D		0.75 × D		0.70 × D		0.65 × D		0.80 × D		0.65 × D		0.65 × D	
	0.45 × D		0.45 × D		0.45 × D		0.45 × D		0.45 × D		0.45 × D		0.45 × D		0.45 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	140	0.026	130	0.031	120	0.026	95	0.027	50	0.034	140	0.026	100	0.018	60	0.034
5		0.034		0.040		0.034		0.037		0.048		0.034		0.026		0.047
6		0.042		0.050		0.043		0.047		0.064		0.042		0.034		0.062
8		0.059		0.070		0.061		0.067		0.095		0.059		0.049		0.090
10		0.076		0.091		0.080		0.089		0.129		0.076		0.067		0.121
12		0.095		0.113		0.100		0.113		0.168		0.095		0.087		0.156
16		0.137		0.161		0.146		0.168		0.258		0.137		0.133		0.236
20		0.184		0.215		0.198		0.231		0.365		0.184		0.188		0.331

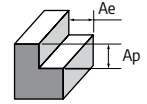
Standard Endmill, 5 Flute



Trochoidal Milling	P01		P02		P03		M01		M02		K01		K02		S01	
Working Material	Carbon Steel		Alloy steel		Prehardened Steel		Stainless Steel				Grey Cast Iron		Ductile Cast Iron		Titanium	
Properties			520 < Rm < 1200		35 ≤ HRC < 45		High Machinability		Low Machinability							
Maximum Slot Width	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting Depth, Ap (mm)	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, Ae (mm)	0.12 × D		0.12 × D		0.12 × D		0.12 × D		0.12 × D		0.12 × D		0.12 × D		0.12 × D	
D	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	250	0.032	220	0.028	200	0.020	100	0.016	90	0.016	200	0.028	140	0.020	90	0.016
5		0.040		0.035		0.025		0.020		0.020		0.035		0.025		0.020
6		0.048		0.042		0.030		0.024		0.024		0.042		0.030		0.024
8		0.064		0.056		0.040		0.032		0.032		0.056		0.040		0.032
10		0.080		0.070		0.050		0.040		0.040		0.070		0.050		0.040
12		0.096		0.084		0.060		0.048		0.048		0.084		0.060		0.048
16		0.128		0.112		0.080		0.064		0.064		0.112		0.080		0.064
20		0.160		0.140		0.100		0.080		0.080		0.140		0.100		0.080



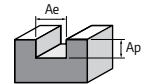
Recommended Cutting Data
 Note: These recommended cutting conditions indicate just references. It should be adjusted due to different cutting conditions.



Lang Endmill, 5 Flute

Side Milling	P01		P02		P03		M01		M02		K01		K02		S01	
Working Material	Carbon Steel		Alloy steel		Prehardened Steel		Stainless Steel				Grey Cast Iron		Ductile Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		35 ≤ HRC < 45		High Machinability		Low Machinability		-		-		-	
Cutting Depth, Ap (mm)	0.80 × D		0.80 × D		0.75 × D		0.70 × D		0.65 × D		0.80 × D		0.65 × D		0.65 × D	
Cutting Width, Ae (mm)	0.45 × D		0.45 × D		0.45 × D		0.45 × D		0.45 × D		0.45 × D		0.45 × D		0.45 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	140	0.020	130	0.025	120	0.020	95	0.022	50	0.027	140	0.020	100	0.015	60	0.027
5		0.027		0.032		0.027		0.029		0.039		0.027		0.020		0.038
6		0.034		0.040		0.034		0.038		0.052		0.034		0.027		0.049
8		0.047		0.056		0.048		0.054		0.076		0.047		0.040		0.072
10		0.061		0.073		0.064		0.071		0.103		0.061		0.054		0.097
12		0.076		0.090		0.080		0.091		0.134		0.076		0.070		0.125
16		0.110		0.129		0.117		0.134		0.206		0.110		0.107		0.189
20		0.147		0.172		0.158		0.185		0.292		0.147		0.150		0.265

Fräser - Lang, 5 Flute



Trochoidal Milling	P01		P02		P03		M01		M02		K01		K02		S01	
Working Material	Carbon Steel		Alloy steel		Prehardened Steel		Stainless Steel				Grey Cast Iron		Ductile Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		35 ≤ HRC < 45		High Machinability		Low Machinability		-		-		-	
Maximum Slot Width	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting Depth, Ap (mm)	2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D	
Cutting Width, Ae (mm)	0.10 × D		0.10 × D		0.10 × D		0.10 × D		0.10 × D		0.10 × D		0.10 × D		0.10 × D	
D	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	200	0.032	180	0.028	150	0.020	80	0.016	70	0.016	160	0.028	100	0.020	70	0.016
5		0.040		0.035		0.025		0.020		0.035		0.025		0.020		
6		0.048		0.042		0.030		0.024		0.042		0.030		0.024		0.024
8		0.064		0.056		0.040		0.032		0.056		0.040		0.032		0.032
10		0.080		0.070		0.050		0.040		0.070		0.040		0.040		0.040
12		0.096		0.084		0.060		0.048		0.084		0.048		0.048		0.048
16		0.128		0.112		0.080		0.064		0.112		0.064		0.064		0.064
20		0.160		0.140		0.100		0.080		0.140		0.080		0.080		0.080



Recommended Cutting Data

Note: These recommended cutting conditions indicate just references. It should be adjusted due to different cutting conditions.

Certificate

Standard **ISO 9001:2015**

Certificate Registr. No. **01 100 053515**

Certificate Holder:



HPMT Industries Sdn. Bhd.
No. 5, Jalan Sungai Kayu Ara 32/39, Taman Berjaya,
Seksyen 32, Shah Alam, Selangor Darul Ehsan, Malaysia

Scope:

Manufacturing of Standard and Custom-made Metal Removing
Cutting Tools

Proof has been furnished by means of an audit that the
requirements of ISO 9001:2015 are met.

Validity:

The certificate is valid from 2018-09-04 until 2021-08-14.

2018-09-14

A handwritten signature in blue ink, appearing to read 'K. Jeger', written over a horizontal line.

TÜV Rheinland Cert GmbH
Am Grauen Stein · 51105 Köln



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THE FUTURE OF PRECISION MACHINING

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