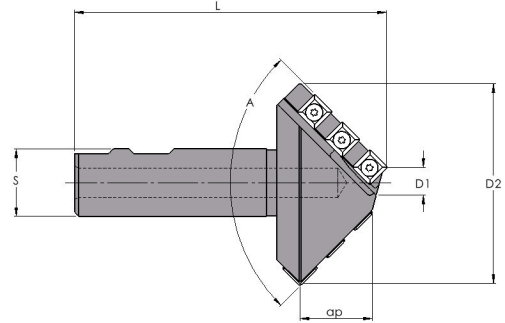


## NLC & PLC Series



- For countersinking a wide range of hole sizes
- Choice of positive or negative rake
- Coolant through
- Cutter bodies made in the USA



Included Angle A	Part Number	Effective Diameter		Dimensions (inches)			No. of Inserts	Insert	Standard Components
		D1	D2	L	S	ap			
NLC NEGATIVE RAKE									
60°	<b>6NLC-020</b>	0.50	2.84	4.63	1.000	2.01	8	SNMG-322	6H8S35
82°	<b>8NLC-020</b>	0.50	2.82	4.63	1.000	1.32	6		
90°	<b>9NLC-020</b>	0.50	2.98	4.63	1.000	1.23	6		
PLC POSITIVE RAKE									
60°	<b>6PLC-020</b>	0.50	2.82	4.63	1.000	2.01	8	SPEH-322	4-40 X 1/4
82°	<b>8PLC-020</b>	0.50	2.82	4.63	1.000	1.33	6		
90°	<b>9PLC-020</b>	0.50	2.96	4.63	1.000	1.23	6		

### Cutter Selection

First choose the angle required, then decide whether positive or negative style inserts would best suit the application.

Positive rake cutters offer freer cutting action and consume less horsepower but have weaker cutting edges. They generate lower cutting forces on the workpiece, reducing the tendency to chatter. Negative rake cutters require more horsepower and a more rigid setup. Double sided inserts provide economy and have the strength required for hard materials.

IC	Part Number	Thickness	Corner Radius	Clearance Angle	Coatings				Image
					None	TiCN	TiN	TiAlN	
0.375	SNMG-322	0.125	0.031	0°	•	○	•	○	
	SPEH-322			11°	•	○	•	○	

Negative rake vs. Positive rake:

#### Positive Rake

- Single sided inserts
- Low cutting forces
- Less chatter
- Weaker cutting edges
- Better for cutting soft or gummy materials

#### Negative rake

- Double sided inserts
- High edge strength
- Better for cutting harder materials
- Requires more horsepower
- Setup must be rigid

