

High productivity for
cylindrical surfaces



BAR PEELING
tools solutions



100
YEARS
SINCE 1916

BAR PEELING

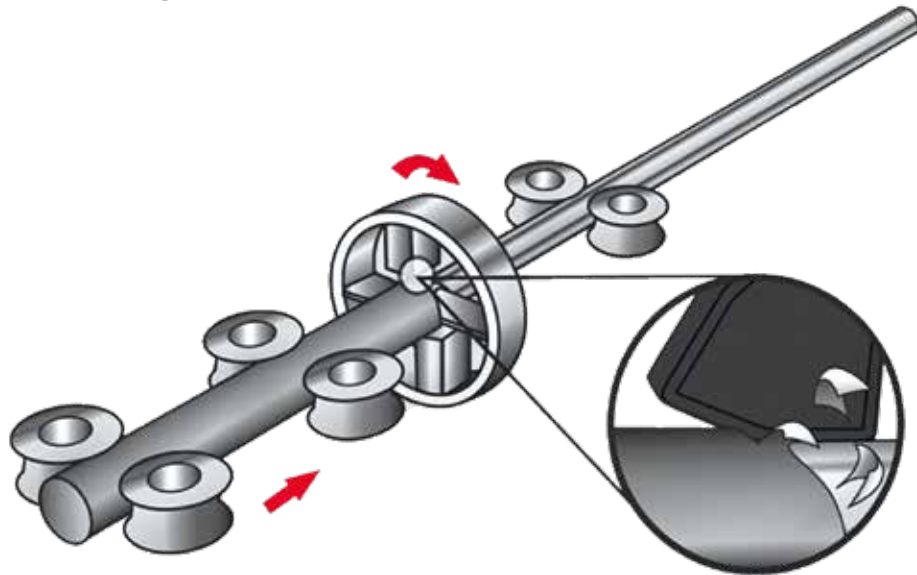


BAR PEELING

Bar Peeling is the machining process by which a raw forged blank is converted into a polished bar.

During this peeling process, surface cracks and oxide layers are removed giving a perfect roundness with good surface and dimensional accuracy to the bar.

The range of materials that can be machined with these tools is vast and goes from all kind of Steels to Cast Iron parts.

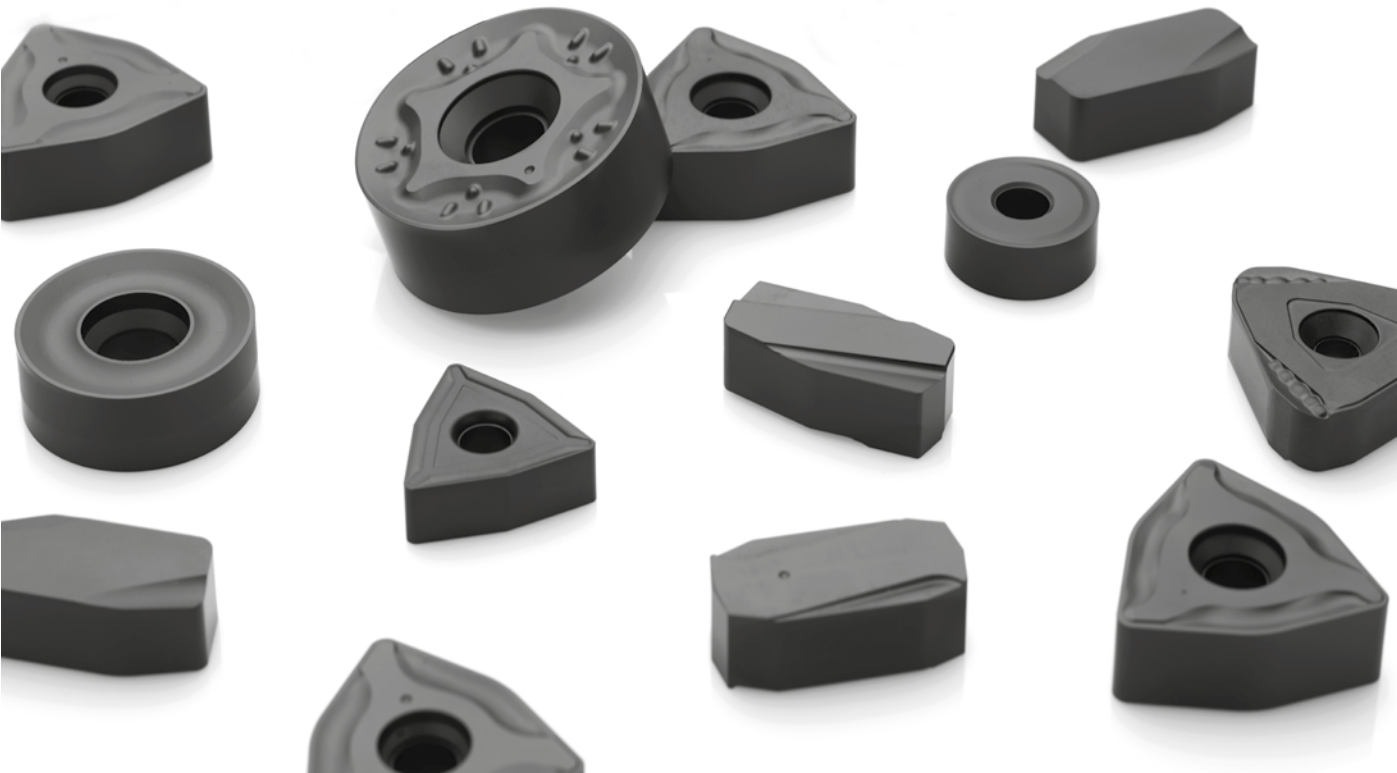


The size of blank bar can go from 4 mm (157 inch) to over 400 mm (15.75 inch) in diameter.

The surface quality and dimensional tolerances are also high, which leads to less machining at later stages.

Our aim is at the same time improving your productivity (by removing maximal chips volume) and at the same time attending or surpassing your surface quality requirements. This is why our Bar Peeling program is vast comprising both standard tools and also special custom-made solutions to every customer needs.

This flyer has only a small portion of our possible range of production. Please don't hesitate to contact us regarding other possible geometries that we may have although not presented in this brochure.



CODE KEY

L	N	G	F	20	10	35	-	MP
1	2	3	4	5	6	7		8

1 - Insert Shape				
I	J	L	R	S
T	U	W	X	

2 - Clearance Angle

5 - Length of Cutting Edge (In)	
The length of the secondary cutting edge is indicated in mm	
13 mm	25 mm
14 mm	27 mm
15 mm	28 mm
17 mm	38 mm
20 mm	44 mm
22 mm	50 mm

3 - Tolerances			
symbol	m (mm)	d (mm)	s (mm)
A	±0.005	±0.025	±0.025
F	±0.005	±0.013	±0.025
C	±0.013	±0.025	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
J	±0.005	±0.05~±0.13	±0.025
K*	±0.013	±0.05~±0.13	±0.025
L*	±0.025	±0.05~±0.13	±0.025
M*	±0.08~±0.20	±0.05~±0.13	±0.13
N*	±0.08~±0.20	±0.05~±0.13	±0.025
U*	±0.13~±0.38	±0.08~0.25	±0.13

4 - Insert type				
symbol	Type	Type of hole	Chipbreaker	Shape
W	with hole	Round hole / one countersink (40°~60°)	Without chipbreaker	
T	with hole		Chipbreaker on one side	
Q	with hole	Round hole / double countersink (40°~60°)	Without chipbreaker	
U	with hole		Chipbreaker on both sides	
B	with hole	Round hole / double countersink (70°~90°)	Without chipbreaker	
H	with hole		Chipbreaker on one side	
C	with hole		Without chipbreaker	
J	with hole		Chipbreaker on both sides	
A	with hole	Round hole	Without chipbreaker	
M	with hole		Chipbreaker on one side	
G	with hole		Chipbreaker on both sides	
N	without hole	—	Without chipbreaker	
R	without hole	—	Chipbreaker on one side	
F	without hole	—	Chipbreaker on both sides	
X	-	-	—	On request

* As a rule, the sides of these inserts are as sintered. Tolerance differs with insert size, for the accuracy of Class M, refer to the table on the right.

8 - Chip Breaker	
Chip breaker according to Palbit geometries	
FP	MH
ST	RP
MP	LH

6 - Thickness (S)
The length of the secondary cutting edge is indicated in mm
08 = 8,00 mm
09 = 9,52 mm
10 = 10,00 mm
12 = 12,00 mm
12 = 12,70 mm
13 = 13,00 mm
14 = 14,00 mm
18 = 18,00 mm

7 - Deph of Cut (ap)
Maximum depth of cut
20 = 2,00 mm
25 = 2,50 mm
35 = 3,50 mm
40 = 4,00 mm
80 = 8,00 mm

INGR
 Rectangular 90° negative |
 Rectangular 90° negativa |
 Rectangular 90° negativa

Insert order code = (1) Geometry Code + (2) Grade Code				P		M		K	Dimensions Dimensões Dimensions (mm)						Cutting conditions Condições de corte Conditions de coupe					
		(2) Grade code		L7	L8	L8	P1	L6												
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	L	In	B	S	ap	K°	^{ap} (mm)	Min	Max	^{fn} (mm/r)	Min	Max
	1123828	INGR 221240-MP	INGR 221240-MP						38,25	22,00	17,50	12,00	4,00	20	2,00	0,40	4,00	3,50	1,00	8,00

JNGF
 Rectangular 90° negative |
 Rectangular 90° negativa |
 Rectangular 90° negativa

Insert order code = (1) Geometry Code + (2) Grade Code				P		M		K		Dimensions Dimensões Dimensions (mm)						Cutting conditions Condições de corte Conditions de coupe					
		(2)Grade code		L7	L8	L8	P1	L6													
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320													
										L	In	B	S	ap	K°	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	1123830	JNGF 201220-MP	JNGF 201220-MP	○	⊗	⊗	○	○	36,90	20,00	18,00	12,35	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00	
	1123996	JNGF 201220-MP SP1	JNGF 201220-MP SP1	○	○	○	○	○	36,30	20,00	18,00	12,45	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00	
	1123997	JNGF 201220-MP SP2	JNGF 201220-MP SP2	⊗	⊗	⊗	○	○	36,50	20,00	18,00	12,45	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00	
	1124043	JNGF 271220-MP	JNGF 271220-MP	○	○	⊗	○	○	36,90	27,00	18,00	12,45	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00	

LNGF
 Rectangular 90° negative |
 Rectangular 90° negativa |
 Rectangular 90° negativa

Insert order code = (1) Geometry Code + (2) Grade Code				P		M		K		Dimensions Dimensões Dimensions (mm)						Cutting conditions Condições de corte Conditions de coupe					
		(2) Grade code		L7	L8	L8	P1	L6													
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	L	In	B	S	ap	K°	ap (mm)	Min	Max	fn (mm/r)	Min	Max	
																					
	1123826	LNGF 201035-MP	LNGF 201035-MP	⊗	○	○	○	○	40,00	20,00	20,00	10,00	3,50	25	2,00	0,80	3,50	2,50	1,00	6,50	
	1123827	LNGF 201235-MP	LNGF 201235-MP	⊗	○	○	○	○	40,00	20,00	20,00	12,00	3,50	25	2,00	0,80	3,50	2,50	1,00	6,50	

⊗ Stock item - First choice | Produto de stock - Primeira opção | Itens de stock - 1ª opción
 ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

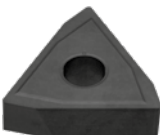
UNGF
 Rectangular 90° negative |
 Rectangular 90° negativa |
 Rectangular 90° negativa

Insert order code = (1) Geometry Code + (2) Grade Code				P		M		K	Dimensions Dimensões Dimensions (mm)						Cutting conditions Condições de corte Conditions de coupe					
		(2) Grade code		L7	L8	L8	P1	L6												
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	L	In	B	S	ap	K°	ap (mm)	Min	Max	f _n (mm/r)	Min	Max
																				
	1123829	UNGF 171240-MP	UNGF 171240-MP	○	⊗	⊗	○	○	36,50	17,00	18,00	12,00	4,00	15	1,50	0,35	4,00	2,00	1,00	5,00

TNMJ
 Triangular 60° negative |
 Triangular 60° negativa |
 Triangular 60° negativa

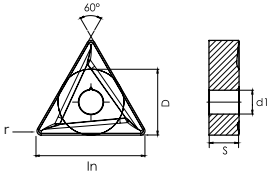
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		(2) Grade code		L7	L8	L8	P1	L6													
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	D	In	S	d1	ap	K°	ap (mm)	Min	Max	fn (mm/r)	Min	Max	
																					
	1123838	TNMJ 201025-MP	TNMJ 201025-MP	○	⊗	⊗	○	○	28,60	20,00	10,00	7,00	2,50	20	1,00	0,70	2,50	3,00	1,00	5,50	
	1123843	TNMJ 201425-MP	TNMJ 201425-MP	○	⊗	⊗	○	○	28,60	20,00	14,00	7,00	2,50	20	1,00	0,70	2,50	3,00	1,00	5,50	

TNGM
 Triangular 60° negative |
 Triangular 60° negativa |
 Triangular 60° negativa

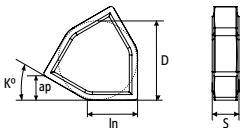
Insert order code = (1) Geometry Code + (2) Grade Code				P		M		K	Dimensions Dimensões Dimensions (mm)						Cutting conditions Condições de corte Conditions de coupe					
		⁽²⁾ Grade code		L7	L8	L8	N2	L6												
	⁽¹⁾ Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5135	PH5320	D	In	S	d1	ap	K°	ap (mm)	Min	Max	f _n (mm/r)	Min	Max
																				
	1124104	TNGM 220812-MP	TNGM 220812-MP	○	⊗	⊗	○	○	19,05	22,00	8,00	7,96	1,20	15	0,70	0,20	1,30	14,00	5,00	18,00

⊗ Stock item - First choice | Produto de stock - Primeira opção | Itens de stock - 1ª opción
 ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

TNMM
 Triangular 60° negative | Triangular 60° negativa | Triangular 60° negativa

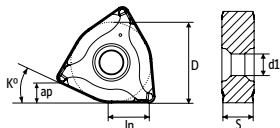


Insert order code = (1) Geometry Code + (2) Grade Code				P	M	K	Dimensions Dimensões Dimensions (mm)							Cutting conditions Condições de corte Conditions de coupe						
		(2)Grade code		L7	N2	N2														P1
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5135	PH5135	PH5228	PH5320	D	In	S	d1	r	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
																				
	1124102	TNMM 441116-LH	TNMM 441116-LH	○	⊗	⊗	○	○	25,40	44,00	11,35	9,20	1,60	-	12,00	2,00	25,00	0,80	0,50	1,60



XNGF
 Special 85° negative | Especial 85° negativa | Especial 85° negativa

Insert order code = (1) Geometry Code + (2) Grade Code				P		M		K		Dimensions Dimensões Dimensions (mm)						Cutting conditions Condições de corte Conditions de coupe					
		(2)Grade code		L7	L8	L8	P1	L6													
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	D	In	S	d1	ap	K°	ap (mm)	Min	Max	fn (mm/r)	Min	Max	
																					
	1123837	XNGF 150980-FP	XNGF 150980-FP	○	○	○	⊗	○	28,58	15,00	8,88	-	8,00	30	3,00	1,00	4,50	6,00	4,00	12,00	

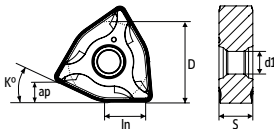


XNMJ
 Special 85° negative | Especial 85° negativa | Especial 85° negativa

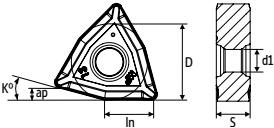
Insert order code = (1) Geometry Code + (2) Grade Code				P	M	K	Dimensions Dimensões Dimensions (mm)						Cutting conditions Condições de corte Conditions de coupe							
		(2)Grade code		L7	L8	L8													P1	L6
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	D	In	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
	1123835	XNMJ 151380-MP	XNMJ 151380-MP	○	⊗	⊗	⊗	○	31,75	15,00	13,00	9,00	8,00	25	3,00	1,00	6,50	6,00	4,00	12,00
	1123836	XNMJ 151380-MH	XNMJ 151380-MH	○	⊗	⊗	⊗	○	31,75	15,00	13,00	9,00	8,00	25	3,00	1,00	6,50	6,00	4,00	12,00

⊗ Stock item - First choice | Produto de stock - Primeira opção | Itens de stock - 1ª opción
 ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

XNGJ
 Special 85° negative | Especial 85° negativa | Especial 85° negativa

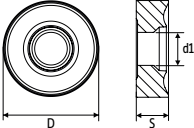


Insert order code = (1) Geometry Code + (2) Grade Code				P	M	K	Dimensions Dimensões Dimensions (mm)							Cutting conditions Condições de corte Conditions de coupe						
		(2) Grade code		L7	L8	L8														P1
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	D	In	S	d1	ap	K°	ap (mm)	Min	Max	fn (mm/r)	Min	Max
																				
	1123834	XNGJ 151380-RP	XNGJ 151380-RP	○	○	○	⊗	○	31,75	15,00	13,00	9,00	8,00	25	3,00	1,00	6,50	6,00	4,00	12,00



WNGJ
 Special 75° negative | Especial 75° negativa | Spéciale 75° negativa

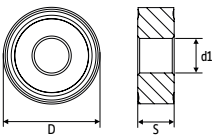
Insert order code = (1) Geometry Code + (2) Grade Code				P	M	K	Dimensions Dimensões Dimensions (mm)							Cutting conditions Condições de corte Conditions de coupe						
		(2) Grade code		L7	L8	L8														P1
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	D	In	S	d1	ap	K°	ap (mm)	Min	Max	fn (mm/r)	Min	Max
																				
	1124041	WNGJ 130950-MP	WNGJ 130950-MP	○	⊗	⊗	⊗	⊗	22,23	13,00	9,56	7,93	5,00	15	3,00	0,50	5,00	6,00	3,00	11,00



RNMX
 Round R° negative | Redonda R° negativa | Redonda R° negativa

Insert order code = (1) Geometry Code + (2) Grade Code				P	M	K	Dimensions Dimensões Dimensions (mm)							Cutting conditions Condições de corte Conditions de coupe						
		(2) Grade code		L7	L8	L8														P1
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	D	In	S	d1	ap	Kº	ap (mm)	Min	Max	fn (mm/r)	Min	Max
																				
	1123831	RNMX 381200-MP	RNMX 381200-MP	○	○	○	⊗	○	38,10	-	12,70	13,00	-	-	4,00	2,00	8,00	2,00	1,00	4,00
	1123832	RNMX 5018M0-MP	RNMX 5018M0-MP	○	○	○	⊗	○	50,00	-	18,00	12,70	-	-	6,00	2,00	12,00	3,50	2,50	6,50
																				
	1123833	RNMX 5018M0-RP	RNMX 5018M0-RP	○	○	○	⊗	○	50,00	-	18,00	12,70	-	-	6,00	2,00	12,00	6,00	4,00	10,50

⊗ Stock item - First choice | Produto de stock - Primeira opção | Itens de stock - 1ª opción
 ○ Available under request | Disponível sobre consulta | Disponible bajo consulta



RNMG
 Round R° negative |
 Redonda R° negativa |
 Redonda R° negativa

Insert order code = (1) Geometry Code + (2) Grade Code				P	M	K	Dimensions Dimensões Dimensions (mm)							Cutting conditions Condições de corte Conditions de coupe						
		(2) Grade code		L7	L8	L8														P1
	(1) Geometry code	ISO Reference	ANSI Reference	PH5115	PH5125	PH5125	PH5228	PH5320	D	ln	S	d1	ap	K°	ap (mm)	Min	Max	fn (mm/r)	Min	Max
																				
	1120443	RNMG 250900-ST	RNMG 860-ST	○	○	○	○	⊗	25,40	-	9,52	9,12	-	-	5,00	2,50	10,00	1,00	0,25	2,50

⊗ Stock item - First choice |
 Produto de stock - Primeira opção |
 Itens de stock - 1ª opção
 ⊗ Stock item |
 Produto de stock |
 Itens de stock
 ○ Available under request |
 Disponível sobre consulta |
 Disponible bajo consulta



* **RNMX-RP** | Product in real size
 Produto em tamanho real
 Producto en tamaño real



Cofinanciado por:

