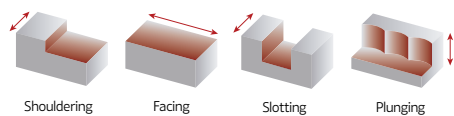
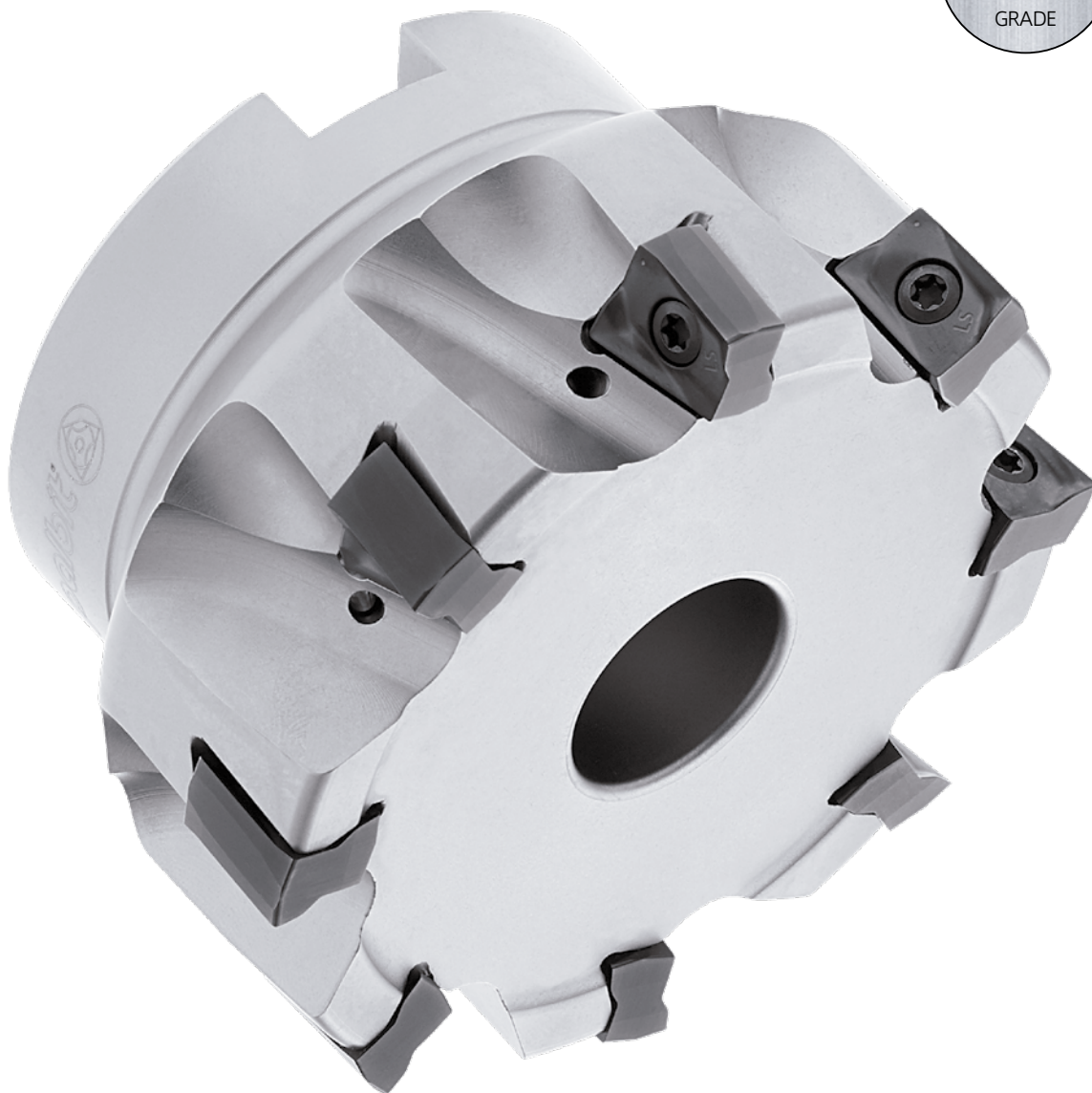
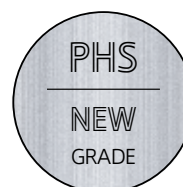


Range extension on 90° Shoulder milling solution



palbit
CUTTING TOOLS SOLUTIONS

PLUS
17190 | 17590 | 18190



INSERT SIZE
10 ANHX
1004



INSERT SIZE
12 ANHX
1206



INSERT SIZE
16 ANHX
1607

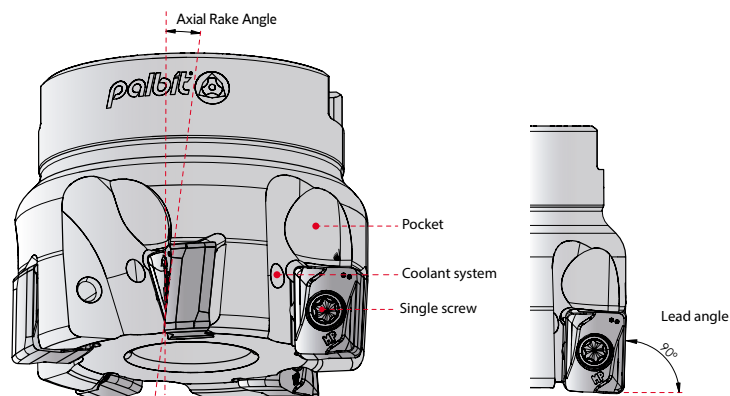


100
YEARS
SINCE 1916

PLUS 17190 | 17590 | 18190

MAIN FEATURES

Coarse and fine pitch cutters suitable for steel, stainless steel and cast iron, for roughing and semi-finishing application.



Axial Rake Angle

- For a smooth cutting;
- For low cutting forces;

Single screw

- Strong clamping system;

Pocket

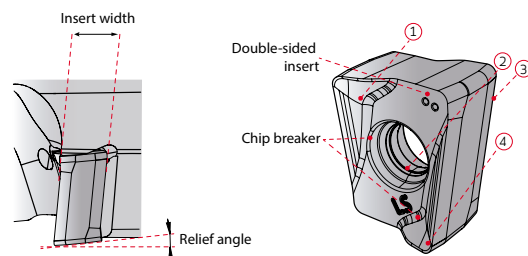
- Better chip evacuation due to a wide pocket;

Coolant system

- Improvement of chip control and evacuation;
- Tool life improvement due to reduced cutting temperature;

True 90° wall

- 90° allows multi applications;
- Excellent for shouldering;



Insert Width

- High thickness allows a stronger insert;

Relief angle

- Reduce the cutting load;
- Low cutting forces;

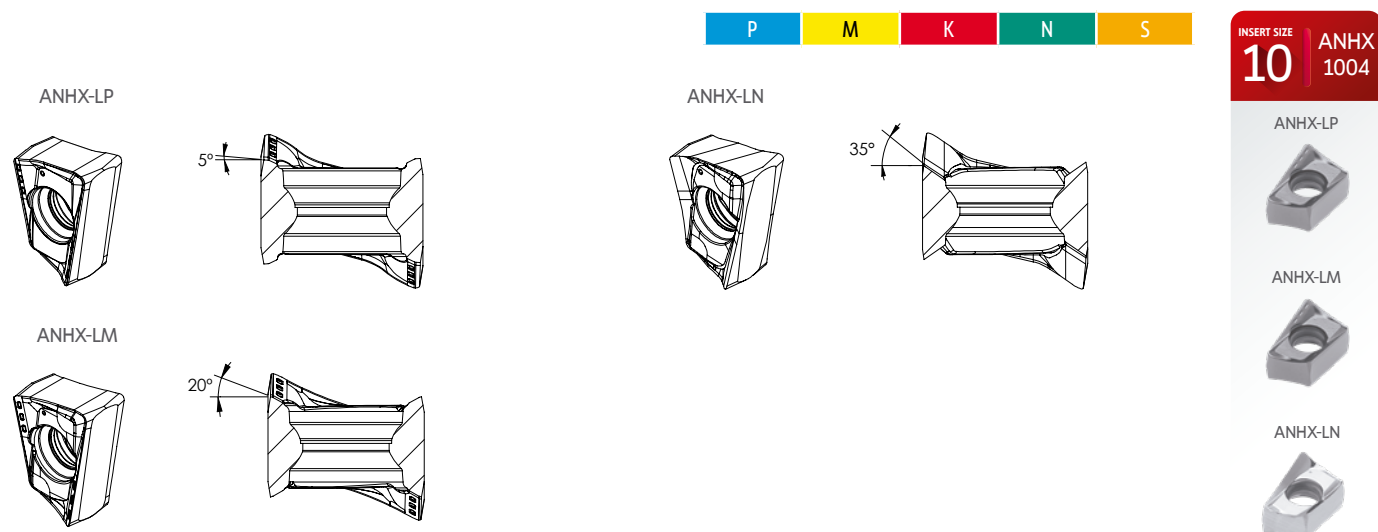
Double-sided insert

- 4 cutting edges;
- Negative insert has a strong edge;

Chip Breaker

- Cutting load reduction due to high rake angle;
- Improvement of chip flow and evacuation in multiple applications and materials;
- New LS chip breaker (on ANHX12) for M and S class materials;

PLUS 17190



CHIP-BREAKERS | Quebra aparas | Rompevirutas

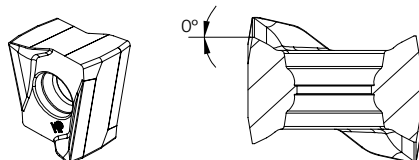
Chip Breaker	Features Características Características
Geometry LP Light machining	Positive top rake angle to promote a good chip flow and reduce power consumption on low alloy steels.
Geometry LM Light machining	High positive top rate to promote a good chip flow for machining stainless steels and HRSA.
Geometry LN Light machining	High positive chip-breaker, polished for applications of non ferrous materials (aluminium).

PLUS 17590

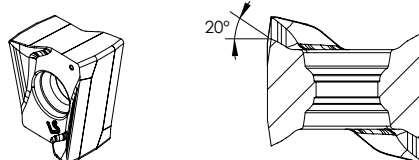
P M K S

INSERT SIZE
12 ANHX
1206

ANHX-MP



ANHX-LS



ANHX-MP



ANHX-LS



CHIP-BREAKERS | Quebra aparas | Rompevirutas

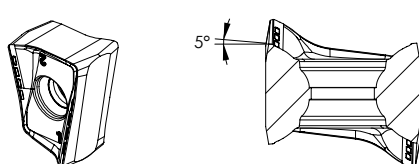
Chip Breaker	Features Características Características
Geometry LS Light Machining	Positive top rake angle to promote a good chip flow and reduce power consumption on stainless steel and HRSA.
Geometry MP General machining	Chip-breaker with a reinforced chanfer for general applications on steel and cast iron

PLUS 18190

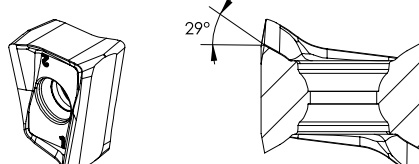
P K N

INSERT SIZE
16 ANHX
1607

ANHX-LP



ANHX-LN



ANHX-LP



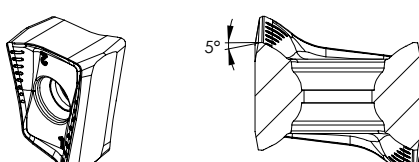
ANHX-MP



ANHX-LN



ANHX-MP



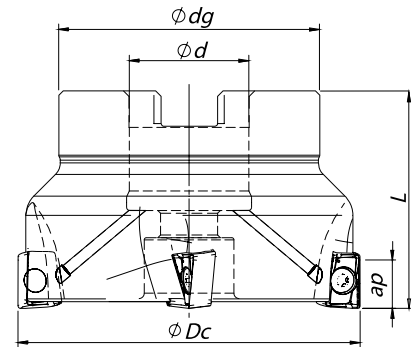
CHIP-BREAKERS | Quebra aparas | Rompevirutas

Chip Breaker	Features Características Características
Geometry LP Light machining	Positive top rake angle to promote a good chip flow and reduce power consumption on low alloy steels.
Geometry MP General machining	Chip-breaker with a reinforced chanfer for general applications on steel and cast iron.
Geometry LN Light machining	High positive chip-breaker, polished for applications of non ferrous materials (aluminium).



Arbor Mounting

$$K_r = 90^\circ \quad | \quad \gamma_p = -7^\circ$$



Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications		Insert Pastilha Inserto	Stock
			ϕDc	$\phi d/M$	ϕDg	L		Arbor Type	Ap max (mm)		
181075300	040A17190-04-07-016040	4	40	16	32	40	0,21	A	9,00	ANHX 1004...	
181075400	040A17190-05-07-016040	5	40	16	32	40	0,21	A	9,00	ANHX 1004...	
181075500	050A17190-05-07-022040	5	50	22	42	40	0,35	A	9,00	ANHX 1004...	
181075600	050A17190-07-07-022040	7	50	22	42	40	0,34	A	9,00	ANHX 1004...	
181075700	063A17190-07-07-022040	7	63	22	52	40	0,55	A	9,00	ANHX 1004...	
181075800	063A17190-09-07-022040	9	63	22	52	40	0,54	A	9,00	ANHX 1004...	
181075900	080A17190-08-07-027050	8	80	27	60	50	1,00	B	9,00	ANHX 1004...	
181076000	080A17190-10-07-027050	10	80	27	60	50	1,00	B	9,00	ANHX 1004...	
181076100	100A17190-09-07-032050	9	100	32	80	50	1,80	B	9,00	ANHX 1004...	
181076200	100A17190-12-07-032050	12	100	32	80	50	1,80	B	9,00	ANHX 1004...	

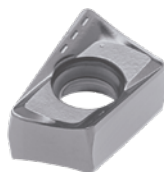
Stock item | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta

ANHX 1004.. || Inserts | Pastilhas | Plaquitass

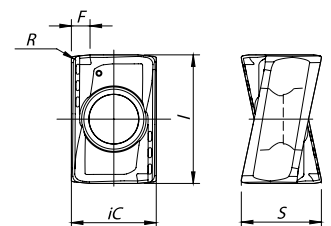
ANHX-LP

ANHX-LM

ANHX-LN



ANHX-LP | LM | LN



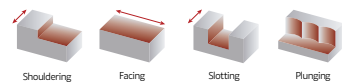
		P						M			K						N		S		H	Dimensions Dimensões Dimensiones (mm)					
		CVD		PVD				CVD	PVD		CVD		PVD				UNC	PCD	PVD	PVD							
		T9	P7	G1	G4	P3	G6	R1	P3	G6	L5	L6	L9	G1	G4	P3	G6	10	D6	P3	G6						P7
⁽¹⁾ Geometry code	ISO Reference	PH5740	PH7603	PH7910	PH7920	PH7930	PH7740	PHM740	PH7930	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH7740	PH0910	PDP410	PH7930	PH7740	PH7603	iC	S	I	R	F
1111652	ANHX 100405 PNR-LP																						6,60	6,20	10,00	0,50	0,85
1112106	ANHX 100408 PNR-LP																						6,60	6,20	10,00	0,80	0,60
1111908	ANHX 100412 PNR-LP																						6,60	6,20	10,00	1,20	0,30
1112005	ANHX 100405 PNER-LM																						6,60	6,20	10,00	0,50	0,85
1112162	ANHX 100408 PNER-LM																						6,60	6,20	10,00	0,80	0,60
1112103	ANHX 100412 PNER-LM																						6,60	6,20	10,00	1,20	0,30
1111997	ANHX 100405 PNFR-LN																						6,60	6,20	10,00	0,50	0,85
1112102	ANHX 100412 PNR-LN																						6,60	6,20	10,00	1,20	0,30

First choice | Primeira opção | 1ª opción

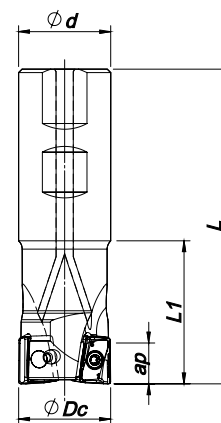
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponível bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code



Weldon Shank
 $K_r = 90^\circ$ | $\gamma_p = -7^\circ (-6^\circ \text{*)}$

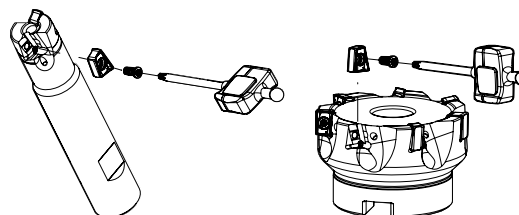


Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications	Insert Pastilha Inserto	Stock
			ØDc	Ød/M	L	L1		Ap max (mm)		
181075000	014W17190-01-06-016090*	1	14	16	90	23	0,188	9,00	ANHX 1004...	
181101400	016W17190-02-06-016090*	2	16	16	90	25	0,123	9,00	ANHX 1004...	
181096800	016W17190-02-06-016150*	2	16	16	150	25	0,190	9,00	ANHX 1004...	
181075200	018W17190-02-06-016090*	2	18	16	90	23	0,125	9,00	ANHX 1004...	
181071400	020W17190-02-06-020100*	2	20	20	100	30	0,210	9,00	ANHX 1004...	
181071500	020W17190-03-06-020100*	3	20	20	100	30	0,206	9,00	ANHX 1004...	
181074400	025W17190-02-06-025115*	2	25	25	115	35	0,391	9,00	ANHX 1004...	
181074500	025W17190-03-06-025115*	3	25	25	115	35	0,387	9,00	ANHX 1004...	
181074600	032W17190-03-06-032125*	3	32	32	125	40	0,701	9,00	ANHX 1004...	
181074700	032W17190-04-06-032125*	4	32	32	125	40	0,698	9,00	ANHX 1004...	
181074800	040W17190-04-07-032130	4	40	32	130	40	0,780	9,00	ANHX 1004...	
181074900	040W17190-05-07-032130	5	40	32	130	40	0,777	9,00	ANHX 1004...	

Stock item | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta

SPARE PARTS | Complementos | Repuestos

Cutter ØDc	Order separately				Order separately	
	Insert Screw	Key (Torx)	Key (Torx - Nm)	Torque Value	Screw	DIN 6368 Wrench
W17190 - 14 - 40	P0300800	XT09	DT0914	1,4	-	-
A17190 - 40 - 63	P0300800	XT09	DT0914	1,4	-	-
A17190 - 80	P0300800	XT09	DT0914	1,4	J0123510	SD6368-12
A17190 - 100	P0300800	XT09	DT0914	1,4	J0164110	SD6368-16



GRADES SELECTION GUIDE | Guia para selecção de graus | Tabla para selección de calidades

ISO	PSM	Material	HB (Brinell)	Grades				
				← Wear Resistance		Toughness →		
				PH0910	PH7910	PH7920	PH7930	PH7740
								
P	1	Unalloyed Steel	125-220		✓	✓	✓	✓
	2	Low-Alloyed Steel	220-280		✓	✓	✓	✓
	3	High-Alloyed Steel	280-380		✓	✓	✓	✓
M	4	SS - Ferritic / Martensitic	200-330				✓	✓
	5	SS - Austenitic	200-330				✓	✓
	6	SS - Austenitic-ferritic (Duplex)	230-260				✓	✓
K	7	Malleable Cast Iron	130-230			✓		✓
	8	Grey Cast Iron	180-245			✓		✓
	9	Nodular Cast iron	160-250		✓	✓		✓
N	10	Aluminium and Non Ferrous	30-130	✓				
S	11	Heat Resistant Super Alloys	200-320		✓		✓	✓

 Good Conditions
 Average Conditions
 Difficult Conditions

RECOMMENDED CUTTING CONDITIONS | Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min)					Feed fz (mm/t)		
				← Wear Resistance		Toughness →			ANH... LP	ANH... LM	ANH... LN
				PH0910	PH7910	PH7920	PH7930	PH7740			
P	1	Unalloyed Steel	125-220	-	190-280	180-250	160-220	140-170	0,10-0,20	0,08-0,20	-
	2	Low-Alloyed Steel	220-280	-	180-240	170-210	150-180	130-160	0,10-0,20	0,08-0,15	-
	3	High-Alloyed Steel	280-380	-	170-220	160-200	130-160	110-140	0,10-0,15	0,08-0,15	-
M	4	SS - Ferritic / Martensitic	200-330	-	-	-	120-200	90-140	-	0,08-0,20	-
	5	SS - Austenitic	200-330	-	-	-	100-190	80-120	-	0,08-0,15	-
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	-	90-120	70-100	-	0,08-0,15	-
K	7	Malleable Cast Iron	130-230	-	180-320	170-300	160-280	130-250	0,10-0,25	0,08-0,20	-
	8	Grey Cast Iron	180-245	-	170-280	150-250	140-240	110-220	0,10-0,25	0,08-0,20	-
	9	Nodular Cast iron	160-250	-	100-240	90-210	90-200	80-170	0,10-0,20	0,08-0,15	-
N	10	Aluminium and Non Ferrous	30-130	350-1200	-	-	-	-	-	-	0,10-0,20
S	11	Heat Resistant Super Alloys	200-320	-	-	-	35-70	30-60	-	0,08-0,10	-

(Note 1) Cutting conditions $a_e/D_c=70\%$.

(Note 2)

Operation	a_e	Vc & fz	a_p (mm)
Slotting	100%	<20%	2,0-3,5
Shouldering	<50%	>8%	3,0-6,0
	≤25%	>12%	6,0-8,5

(Note 3)

It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:

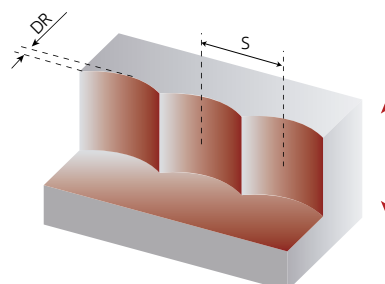
- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

CHIP-BREAKER SELECTION GUIDE | Guia de selecção do quebra-aparas | Guía de selección del rompevirutas

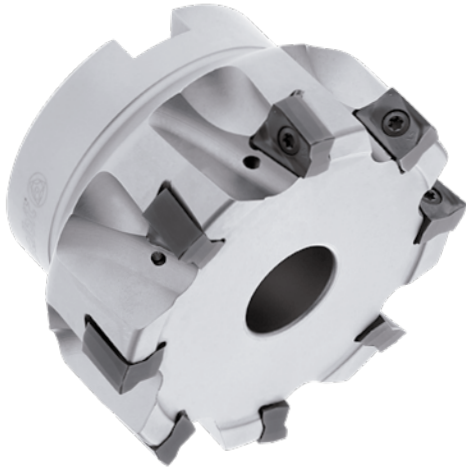
ISO	PSM	Material	HB (Brinell)	Chip Breaker Application	
				1 st choice	Difficult Operations
P	1	Unalloyed Steel	125-220	ANHx 10... LM	ANHx 10... LP
	2	Low-Alloyed Steel	220-280	ANHx 10... LM	ANHx 10... LP
	3	High-Alloyed Steel	280-380	ANHx 10... LM	ANHx 10... LP
M	4	SS - Ferritic / Martensitic	200-330	ANHx 10... LM	-
	5	SS - Austenitic	200-330	ANHx 10... LM	-
	6	SS - Austenitic-ferritic (Duplex)	220-260	ANHx 10... LM	-
K	7	Malleable Cast Iron	130-230	ANHx 10... LM	ANHx 10... LP
	8	Grey Cast Iron	180-245	ANHx 10... LM	ANHx 10... LP
	9	Nodular Cast iron	160-250	ANHx 10... LP	-
N	10	Aluminium and Non Ferrous	30-130	ANHx 10... LN	-
S	11	Heat Resistant Super Alloys	200-320	ANHx 10... LM	-

PLUNGING | Mergulho | Plunge

L≤3Dc	L>3Dc	S max.
f _z (mm/t)		
0,10-0,20	0,10-0,14	$S_{max} = \sqrt{D_C \cdot D_r - D_r^2}$

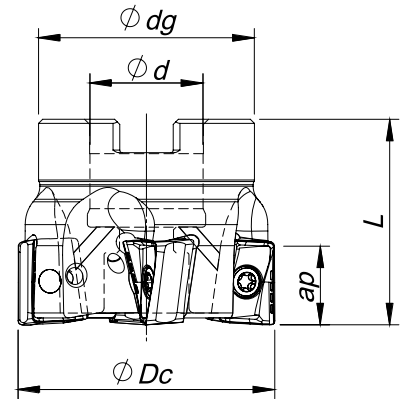


S max and DR corresponding cutting diameter Dc (mm)											
DR (mm)	Dc (mm)										
	14	16	18	20	25	32	40	50	63	80	100
1,0	3,6	3,9	4,1	4,4	4,9	5,6	6,2	7,0	7,9	8,9	9,9
2,0	4,9	5,3	5,7	6,0	6,8	7,7	8,7	9,8	11,0	12,5	14,0
3,0	5,7	6,2	6,7	7,1	8,1	9,3	10,5	11,9	13,4	15,2	17,1



Arbor Mounting

$K_r = 90^\circ$ | $\gamma_p = -6^\circ$



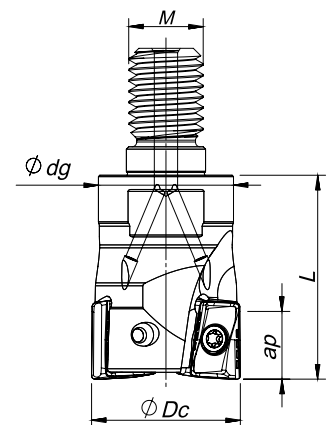
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications		Insert Pastilha Inserto	Stock
			ϕDc	$\phi d/M$	ϕdg	L		Arbor Type	Ap max		
181116400	040A17590-04-06-016040	4	40	16	32	40	0,17	A	11,00	ANHX 1206...	
181114500	050A17590-05-06-022040	5	50	22	42	40	0,30	A	11,00	ANHX 1206...	
181115900	050A17590-06-06-022040	6	50	22	42	40	0,30	A	11,00	ANHX 1206...	
181116500	063A17590-05-06-022040	5	63	22	52	40	0,55	A	11,00	ANHX 1206...	
181116600	063A17590-07-06-022040	7	63	22	52	40	0,52	A	11,00	ANHX 1206...	
181116700	080A17590-08-06-027050	8	80	27	60	50	1,10	A	11,00	ANHX 1206...	
181116800	080A17590-10-06-027050	10	80	27	60	50	1,10	A	11,00	ANHX 1206...	
181116900	100A17590-12-06-032050	12	100	32	80	50	1,65	B	11,00	ANHX 1206...	
181117000	125A17590-14-06-040063	14	125	40	90	63	3,16	B	11,00	ANHX 1206...	

Stock item | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta



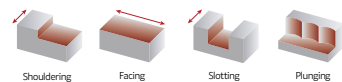
Threaded Coupling

$K_r = 90^\circ$ | $\gamma_p = -6^\circ$



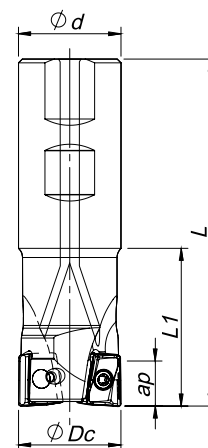
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications		Insert Pastilha Inserto	Stock
			ϕDc	$\phi d/M$	ϕdg	L		Ap max			
181117100	025R17590-02-06-M12035	2	25	M12	21	35	0,09	11,00		ANHX 1206...	
181117200	032R17590-03-06-M16043	3	32	M16	29	43	0,20	11,00		ANHX 1206...	
181117300	042R17590-04-06-M16043	4	42	M16	29	43	0,26	11,00		ANHX 1206...	

Stock item | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta



Weldon Shank

$K_r = 90^\circ$ | $\gamma_p = -6^\circ$



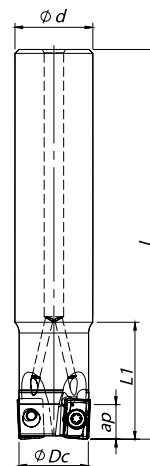
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications	Insert Pastilha Inserto	Stock
			ϕD_c	$\phi d/M$	L	L1		Ap max		
181116000	025W17590-02-06-025110	2	25	25	110	35	0,37	11,00	ANHX 1206...	
181120600	032W17590-03-06-032150	3	32	32	150	35	0,84	11,00	ANHX 1206...	
181116100	040W17590-04-06-032150	4	40	32	150	40	0,88	11,00	ANHX 1206...	

Stock item | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta



Cylindrical Shank

$K_r = 90^\circ$ | $\gamma_p = -6^\circ$

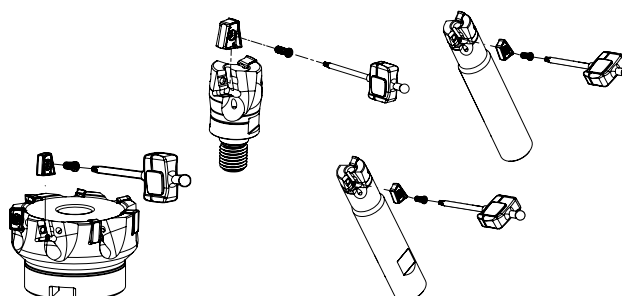


Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications	Insert Pastilha Inserto	Stock
			ϕD_c	$\phi d/M$	L	L1		Ap max		
181116300	026E17590-02-06-025200	2	26	25	200	40	0,66	11,00	ANHX 1206...	
181116200	033E17590-03-06-032250	3	33	32	250	40	1,40	11,00	ANHX 1206...	

Stock item | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta

SPARE PARTS | Complementos | Repuestos

Cutter ϕD_c	Order separately			
	Insert Screw 	Key (Torx) 	Key (Torx - Nm) 	Torque Value
E17590 - 26 - 33	P0350904	XT10	DT1020	2,0
A17590 - 40 - 100	P0350904	XT10	DT1020	2,0
A17590 - 125	P0350904	PT10	DT1020	2,0
R17590 - 25 - 42	P0350904	XT10	DT1020	2,0
W17590 - 25-40	P0350904	XT10	DT1020	2,0



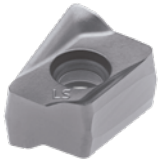
PLUS 17590

ANHX 1206.. | Inserts | Pastilhas | Plaquitas

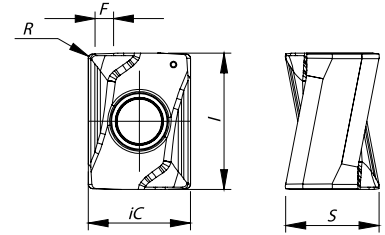
ANHX-LS

ANHX-MP
(PHS grade)

NEW



ANHX-LS | MP



		P						M			K						N		S		H	Dimensions Dimensões Dimensiones (mm)						
		CVD	PVD					CVD	PVD		CVD			PVD			UNC	PCD	PVD		PVD							
		T9	P7	G1	G4	P3	G6	R1	P3	G6	L5	L6	L9	G1	G4	P3	G6	10	D6	P3	G6						P7	
(1) Geometry code	ISO Reference	PH5740	PH7603	PH7910	PH7920	PH7930	PH7740	PHM740	PH7930	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH7740	PH0910	PDP410	PH7930	PH7740	PH7603	iC	S	I	R	F	
1112474	ANHX 120604 PNER-LS				⊗	⊗	⊗		⊗	⊗						⊗	⊗				⊗	⊗		9,0	8,3	12,0	0,4	1,6
1112237	ANHX 120608 PNER-LS				⊗	⊗	⊗		⊗	⊗						⊗	⊗				⊗	⊗		9,0	8,3	12,0	0,8	1,2
1112429	ANHX 120616 PNER-LS				⊗	⊗	⊗		⊗	⊗						⊗	⊗				⊗	⊗		9,0	8,3	12,0	1,6	0,4
1112473	ANHX 120604 PNSR-MP				⊗		⊗					⊗				⊗	⊗							9,0	8,3	12,0	0,4	1,6
NEW 1112238	ANHX 120608 PNSR-MP	⊗			⊗		⊗					⊗				⊗	⊗							9,0	8,3	12,0	0,8	1,2
1112430	ANHX 120616 PNSR-MP				⊗		⊗					⊗				⊗	⊗							9,0	8,3	12,0	1,6	0,4

First choice | Primeira opção | 1ª opción
 Stock item | Produto de stock | Itens de stock
 Available under request | Disponível sobre consulta | Disponible bajo consulta
 Insert order code = (1) Geometry Code + (2) Grade Code

RECOMMENDED CUTTING CONDITIONS | Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min)					Feed fz (mm/t)	
				← Wear Resistance			Toughness →			
				PH5320	PH7920	PH7930	PHS740	PH7740	ANHX 12... LS	ANHX 12... MP
P	1	Unalloyed Steel	125-220	-	150-230	150-180	130-160	130-160	0,10-0,20	0,10-0,30
	2	Low-Alloyed Steel	220-280	-	140-220	140-170	120-150	120-150	0,10-0,20	0,10-0,25
	3	High-Alloyed Steel	280-380	-	130-180	120-150	100-130	100-130	0,10-0,15	0,10-0,20
M	4	SS - Ferritic / Martensitic	200-330	-	-	90-150	-	100-120	0,10-0,20	-
	5	SS - Austenitic	200-330	-	-	80-130	-	80-110	0,10-0,15	-
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	70-100	-	70-100	0,10-0,15	-
K	7	Malleable Cast Iron	130-230	170-300	150-280	-	-	130-250	0,10-0,25	0,10-0,30
	8	Grey Cast Iron	180-245	150-250	130-230	-	-	100-200	0,10-0,25	0,10-0,30
	9	Nodular Cast iron	160-250	90-210	80-190	-	-	50-150	0,10-0,20	0,10-0,25
S	11	Heat Resistant Super Alloys	200-320	-	-	25-100	-	20-80	0,07-0,10	-

(Note 1)
Cutting conditions $a_e/D_c=70\%$.

(Note 2)

Operation	a_e	Vc & fz	a_p (mm)
Slotting	100%	<20%	2,5-4,0
Shouldering	<50%	>8%	4,0-7,0
	≤25%	>12%	7,0-10,0

(Note 3)
It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:
 - When using long shank;
 - When using long tool overhang with arbor type;
 - When application has poor clamping rigidity or when using a low rigidity machine.

GRADES SELECTION GUIDE | Guia para selecção de graus | Tabla para selección de calidades

ISO	PSM	Material	HB (Brinell)	Grades				
				← Wear Resistance		Toughness →		
				PH5320	PH7920	PH7930	PH5740	PH7740
P	1	Unalloyed Steel	125-220	●	✓	✓	✓	✓
	2	Low-Alloyed Steel	220-280		✓	✓	✓	✓
	3	High-Alloyed Steel	280-380		✓	✓	✓	✓
M	4	SS - Ferritic / Martensitic	200-330			✓		✓
	5	SS - Austenitic	200-330			✓		✓
	6	SS - Austenitic-ferritic (Duplex)	230-260			✓		✓
K	7	Malleable Cast Iron	130-230	✓	✓			✓
	8	Grey Cast Iron	180-245	✓	✓			✓
	9	Nodular Cast iron	160-250	✓	✓			✓
S	11	Heat Resistant Super Alloys	200-320			✓		✓

● Good Conditions

● Average Conditions

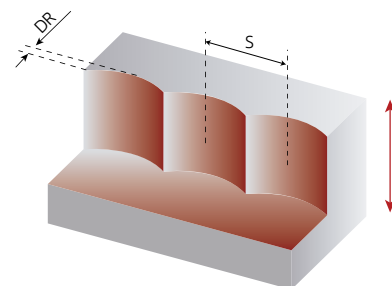
● Difficult Conditions

CHIP-BREAKER SELECTION GUIDE | Guia de selecção do quebra-apanas | Guía de selección del rompevirutas

ISO	PSM	Material	HB (Brinell)	Chip Breaker Application	
				1 st choice	Difficult Operations
P	1	Unalloyed Steel	125-220	ANHx 12... LS	ANHx 12... MP
	2	Low-Alloyed Steel	220-280	ANHx 12... MP	-
	3	High-Alloyed Steel	280-380	ANHx 12... MP	-
M	4	SS - Ferritic / Martensitic	200-330	ANHx 12... LS	-
	5	SS - Austenitic	200-330	ANHx 12... LS	-
	6	SS - Austenitic-ferritic (Duplex)	220-260	ANHx 12... LS	-
K	7	Malleable Cast Iron	130-230	ANHx 12... LS	ANHx 12... MP
	8	Grey Cast Iron	180-245	ANHx 12... MP	-
	9	Nodular Cast iron	160-250	ANHx 12... MP	-
S	11	Heat Resistant Super Alloys	200-320	ANHx 12... LS	-

PLUNGING | Mergulho | Plunge

L≤3Dc	L>3Dc	S max.
f _z (mm/t)		
0,10-0,20	0,10-0,14	$S_{max} = \sqrt{D_C \cdot D_r - D_r^2}$

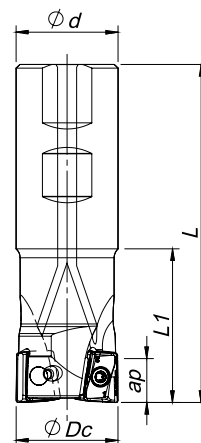


S max and DR corresponding cutting diameter Dc (mm)							
DR (mm)	Dc (mm)						
	32	40	50	63	80	100	125
1,0	5,6	6,2	7,0	7,9	8,9	9,9	11,1
2,0	7,7	8,7	9,8	11,0	12,5	14,0	15,7
3,0	9,3	10,5	11,9	13,4	15,2	17,1	19,1



Weldon Shank

$K_r = 90^\circ$ | $\gamma_p = -4^\circ$



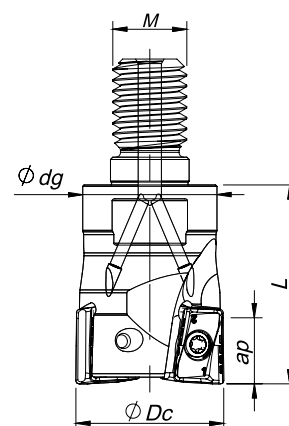
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications	Insert Pastilha Inserto	Stock
			ϕD_c	$\phi d/M$	L	L1		Ap max		
181051600	032W18190-02-04-032110	2	32	32	110	50	0,66	15,0	ANHX 1607...	
181067500	040W18190-03-04-032115	3	40	32	115	40	0,66	15,0	ANHX 1607...	

Stock item | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta



Threaded Coupling

$K_r = 90^\circ$ | $\gamma_p = -4^\circ$

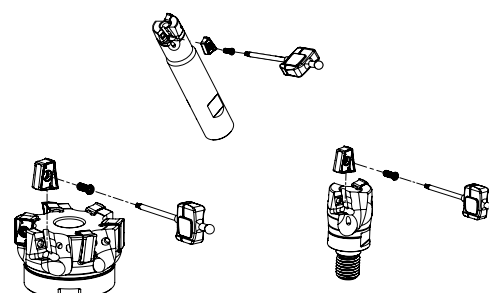


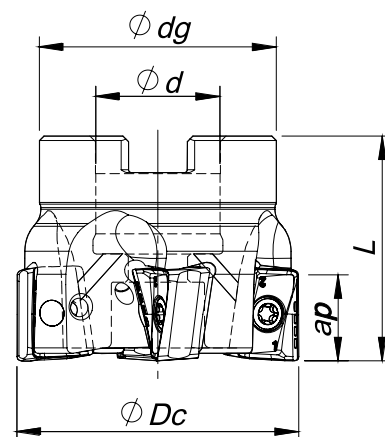
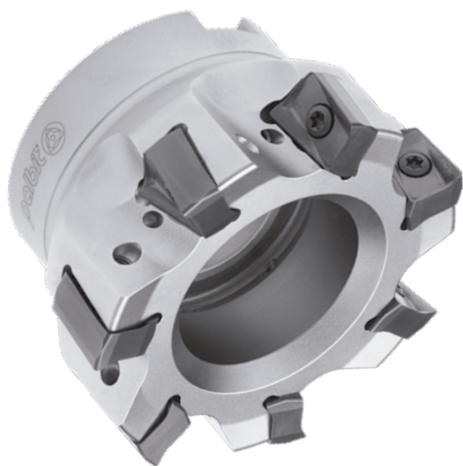
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications	Insert Pastilha Inserto	Stock
			ϕD_c	$\phi d/M$	ϕdg	L		Ap max		
181082800	032R18190-02-04-M16043	2	32	M16	29	43	0,20	15,0	ANHX 1607...	
181082900	040R18190-03-04-M16043	3	40	M16	29	43	0,24	15,0	ANHX 1607...	

Stock item | Itens de stock Available under request | Disponível sobre consulta | Disponible bajo consulta

SPARE PARTS | Complementos | Repuestos

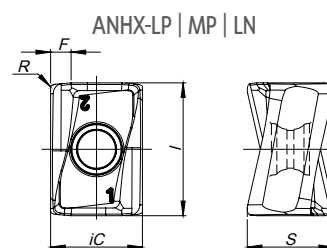
Cutter ϕD_c	Insert Screw	Key (Torx)	Order separately		Order separately	
			Key (Torx - Nm)	Torque Value	Screw	DIN 6368 Wrench
W18190 - 32 - 40	P0401200	XT15	DT1530	3,0	-	-
R18190 - 32 - 40	P0401200	XT15	DT1530	3,0	-	-
A18190 - 50 - 63	P0401200	XT15	DT1530	3,0	-	-
A18190 - 80	P0401200	XT15	DT1530	3,0	J0123510	SD6368-12
A18190 - 100	P0401200	XT15	DT1530	3,0	J0164110	SD6368-16
A18190 - 125	P0401200	PT15	DT1530	3,0	J0204610	SD6368-20
A18190 - 160	P0401200	PT15	DT1530	3,0	-	-




$$K_r = 90^\circ \quad | \quad \gamma_p = -4^\circ$$

Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications		Insert Pastilha Inserto	Stock
			ØDc	Ød/M	ØDg	L		Arbor Type	Ap max		
181067600	050A18190-03-04-022040	3	50	22	42	40	0,28	A	15,0	ANHx 1607...	
181067700	050A18190-04-04-022040	4	50	22	42	40	0,27	A	15,0	ANHx 1607...	
181067800	063A18190-04-04-022040	4	63	22	52	40	0,51	A	15,0	ANHx 1607...	
181067900	063A18190-06-04-022040	6	63	22	52	40	0,48	A	15,0	ANHx 1607...	
181068000	080A18190-05-04-027050	5	80	27	60	50	0,88	B	15,0	ANHx 1607...	
181051800	080A18190-07-04-027050	7	80	27	60	50	0,36	B	15,0	ANHx 1607...	
181068100	100A18190-05-04-032050	5	100	32	80	50	1,60	B	15,0	ANHx 1607...	
181068200	100A18190-08-04-032050	8	100	32	80	50	1,59	B	15,0	ANHx 1607...	
181068300	125A18190-07-04-040063	7	125	40	90	63	2,93	B	15,0	ANHx 1607...	
181068400	125A18190-10-04-040063	10	125	40	90	63	2,89	B	15,0	ANHx 1607...	
181068500	160A18190-08-04-U040063	8	160	40	110	63	4,29	C	15,0	ANHx 1607...	
181068600	160A18190-12-04-U040063	12	160	40	110	63	4,29	C	15,0	ANHx 1607...	

ANHX 1607... || Inserts | Pastilhas | Plaquetas



		P						M			K						N		S		H	Dimensions Dimensões Dimensiones (mm)					
		CVD	PVD					CVD	PVD		CVD			PVD			UNC	PCD	PVD		PVD						
		⁽²⁾ Grade code	T9	P7	G1	G4	P3	G6	R1	P3	G6	L5	L6	L9	G1	G4	P3	G6	10	D6	P3						G6
⁽¹⁾ Geometry code	ISO Reference	PH5740	PH7603	PH7910	PH7920	PH7930	PH7740	PHM740	PH7930	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH7740	PH0910	PDP410	PH7930	PH7740	PH7603	iC	S	I	R	F
	1111519 ANHX 160708 PNR-LP			⊗	⊗	⊗								⊗	⊗	⊗							11,20	10,80	16	0,8	1,4
	1111596 ANHX 160712 PNR-LP			○	⊗	⊗								○	⊗	⊗							11,20	10,50	16	1,2	1,2
NEW	1111595 ANHX 160708 PNER-MP	⊗		⊗	⊗	⊗								⊗	⊗	⊗							11,20	10,80	16	0,8	1,4
	1111598 ANHX 160712 PNER-MP			⊗	⊗	⊗								⊗	⊗	⊗							11,20	10,50	16	1,2	1,2
NEW	1112383 ANHX 160716 PNER-MP			○	○	○								○	○	○							11,20	10,80	16	1,6	0,9
	1111659 ANHX 160708 PNFR-LN																	⊗					11,20	10,80	16	0,8	1,4
	1111597 ANHX 160712 PNFR-LN																	⊗					11,20	10,50	16	1,2	1,2

Insert order code = (1) Geometry Code + (2) Grade Code

RECOMMENDED CUTTING CONDITIONS || Condições de corte recomendadas | Condiciones de corte recomendadas

ISO	PSM	Material	HB (Brinell)	Vc (m/min)					Feed fz (mm/t)		
				← Wear Resistance		Toughness →					
				PH0910	PH7910	PH7920	PH7930	PHS740	ANHX 16... LP	ANHX 16... MP	ANHX 16... LN
P	1	Unalloyed Steel	125-220	-	190-280	180-250	160-220	140-200	0,10-0,22	0,08-0,25	-
	2	Low-Alloyed Steel	220-280	-	180-240	170-210	150-180	130-160	0,10-0,22	0,08-0,25	-
	3	High-Alloyed Steel	280-380	-	170-220	160-200	130-160	110-140	0,10-0,20	0,08-0,22	-
K	7	Malleable Cast Iron	130-230	-	180-320	170-300	160-280	-	0,10-0,25	0,08-0,25	-
	8	Grey Cast Iron	180-245	-	170-280	150-250	140-240	-	0,10-0,25	0,08-0,25	-
	9	Nodular Cast iron	160-250	-	100-240	90-210	90-200	-	0,10-0,20	0,08-0,22	-
N	10	Aluminium and Non Ferrous	30-130	300-1200	-	-	-	-	-	-	0,10-0,40

(Note 1)
Cutting conditions $a_e/D_c=70\%$.

(Note 2)

Operation	a_e	Vc & fz	a_p (mm)
Slotting	100%	<20%	2,0-4,5
Shouldering	<50%	>8%	6,0-8,0
	≤25%	>12%	8,0-15,0

(Note 3)

It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:

- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

GRADES SELECTION GUIDE || Guia para selecção de graus | Guía para selección de calidades

ISO	PSM	Material	HB (Brinell)	Grades				
				← Wear Resistance		Toughness →		
				PH0910	PH7910	PH7920	PH7930	PHS740
								
P	1	Unalloyed Steel	125-220		✓	✓	✓	✓
	2	Low-Alloyed Steel	220-280		✓	✓	✓	✓
	3	High-Alloyed Steel	280-380		✓	✓	✓	✓
K	7	Malleable Cast Iron	130-230		✓	✓	✓	
	8	Grey Cast Iron	180-245		✓	✓	✓	
	9	Nodular Cast iron	160-250		✓	✓	✓	
N	10	Aluminium and Non Ferrous	30-130	✓				

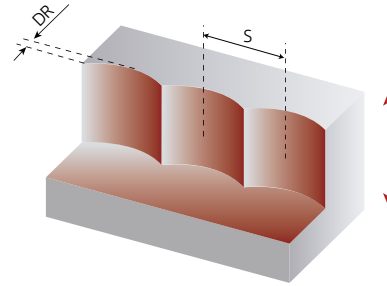
-  Good Conditions
-  Average Conditions
-  Difficult Conditions

CHIP-BREAKER SELECTION GUIDE || Guia para aplicações do quebra- aparas | Guía para aplicación del rompevirutas

ISO	PSM	Material	HB (Brinell)	Chip Breaker Application	
				1 st choice	Difficult Operations
P	1	Unalloyed Steel	125-220	ANHX 16... LP	ANHX 16... MP
	2	Low-Alloyed Steel	220-280	ANHX 16... LP	ANHX 16... MP
	3	High-Alloyed Steel	280-380	ANHX 16... LP	ANHX 16... MP
K	7	Malleable Cast Iron	130-230	ANHX 16... LP	ANHX 16... MP
	8	Grey Cast Iron	180-245	ANHX 16... LP	ANHX 16... MP
	9	Nodular Cast iron	160-250	ANHX 16... LP	ANHX 16... MP
N	10	Aluminium and Non Ferrous	30-130	ANHX 16... LN	-

PLUNGING | Mergulho | Plunge

L≤3Dc	L>3Dc	S max.
f _z (mm/t)		
0,10-0,20	0,10-0,14	S _{max} = √D _C ·DR - DR ²



S max and DR corresponding cutting diameter Dc (mm)								
DR (mm)	Dc (mm)							
	32	40	50	63	80	100	125	160
1,0	5,6	6,2	7,0	7,9	8,9	9,9	11,1	12,6
2,0	7,7	8,7	9,8	11,0	12,5	14,0	15,7	17,8
3,0	9,3	10,5	11,9	13,4	15,2	17,1	19,1	21,7
4,0	10,6	12,0	13,6	15,4	17,4	19,6	22,0	25,0
5,0	11,6	13,2	15,0	17,0	19,4	21,8	24,5	27,8

18190 TEST REPORT

Milling cutter
063A18190-06-04-022040

Insert
ANHX 160708-PNER-LP

Grade
PH7920

**22%
productivity
improvement**

Machining time
55 (min/per edge)

palbit
CUTTING TOOLS SOLUTIONS

Milling cutter
Competitor Equivalent product

Insert
Competitor Equivalent product

Grade
Competitor Equivalent product

Machining time
40 (min/per edge)

COMPETITOR

Work material: EN-JL 1040 (0.6025)

Cutting speed: Vc (m/min)	220
Feed per tooth: fz (mm/t)	0,18
Depth of cut: ap (mm)	8
Width of cut: ae (mm)	20
Method of machining	Shoulder milling
Coolant	Dry

17190 TEST REPORT

Milling cutter
020W17190-02-06-020100

Insert
ANHX 100405-PNER-LM

Grade
PH7920

39% productivity improvement

Machining time
90 (min/per edge)



Milling cutter
Competitor Equivalent product

Insert
Competitor Equivalent product

Grade
Competitor Equivalent product

Machining time
65 (min/per edge)




Work material: 40CrMnNiMo8 (1.2738) - (34-38 HRC)

Cutting speed: Vc (m/min)	180
Feed per tooth: fz (mm/t)	0,2
Depth of cut: ap (mm)	3
Width of cut: ae (mm)	12
Method of machining	Shoulder milling
Coolant	Dry

17590 TEST REPORT



Milling cutter
040W17590-04-06-032150

Insert
ANHX 120608-PNSR-MP

Grade
PHS740

100% productivity improvement

Machining time
100 (min/per edge)



Milling cutter
Competitor Equivalent product

Insert
Competitor Equivalent product

Grade
Competitor Equivalent product

Machining time
50 (min/per edge)




Work material: 40CrMnNiMo8 (1.2738) - (34-38 HRC)

Cutting speed: Vc (m/min)	210
Feed per tooth: fz (mm/t)	0,20
Depth of cut: ap (mm)	4,50
Width of cut: ae (mm)	30
Method of machining	Shoulder milling
Coolant	Dry

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