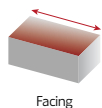


Optimized performance face milling of cast irons and forged steels



palbit
CUTTING TOOLS SOLUTIONS

PLUS
90260



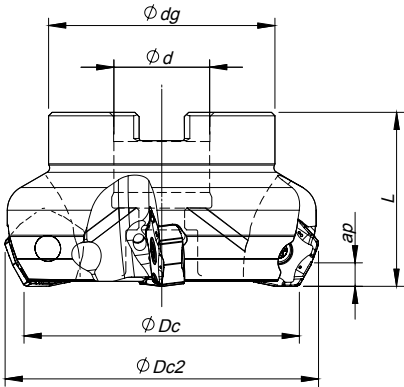
INSERT SIZE
11 PN...
1105



100
YEARS
SINCE 1916



Arbor Mounting
K_r=60° | γ_p -7°



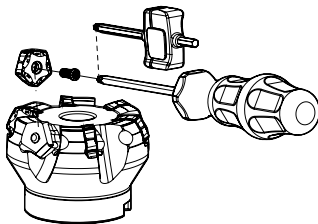
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)					Kg	Specifications		Insert Pastilha Inserto	Stock
			ØDc	ØDc2	Ød	Ødg	L		Arbor Type	Ap max (mm)		
181050200	050A90260-05-07-022040	5	50	59,05	22	48	40	0,388	A	5,0	PN... 1105...	
181050300	063A90260-06-07-022040	6	63	72,05	22	52	40	0,597	A	5,0	PN... 1105...	
181050400	080A90260-08-07-027050	8	80	89,05	27	60	50	1,072	B	5,0	PN... 1105...	
181045900	100A90260-10-07-032050	10	100	109,05	32	80	50	1,745	B	5,0	PN... 1105...	
181050500	125A90260-12-07-040063	12	125	134,05	40	90	63	3,047	B	5,0	PN... 1105...	
181050600	160A90260-14-07-U040063	14	160	169,05	40	110	63	4,397	C	5,0	PN... 1105...	

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

SPARE PARTS | Complementos | Repuestos

Cutter ØDc	Insert Screw	Key (Torx)	Order separately		Order separately	
			Key (Torx - Nm)	Torque Value	Screw	DIN 6368 Wrench
A90260 – 50 - 63	P0401200	XT15	DT1530	3,0	-	-
A90260 – 80	P0401200	XT15	DT1530	3,0	J0123510	SD6368-12
A90260 – 100	P0401200	PT15	DT1530	3,0	J0164110	SD6368-16
A90260 – 125	P0401200	PT15	DT1530	3,0	J0204610	SD6368-20
A90260 – 160	P0401200	PT15	DT1530	3,0	-	-



PLUS 90260
PNHX | PNKX



PNH(K)X 1105 | 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	G4	G6	L5	L6	L9	G1	G4	P3	G6	10						D6	P3	G6
⁽¹⁾ Geometry code	ISO Reference	PH5740	PH7603	PH7910	PH7920	PH7930	PH7740	PHM740	PH7920	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH7740	PH0910	PDP410	PH7930	PH7740	PH7603	iC	S	I	R	F
1111374	PNHX 1105 ZNER-MK																						16,50	5,66	5,70	-	1,30
1111998	PNHX 1105 ZNER-HK																						16,50	5,66	5,70	-	1,30
1112294	PNKX 1105 ZNER-MK																						16,50	5,66	5,70	-	1,30

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

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

ISO	PSM	Material	HB (brinell)	Grades				
				← Wear Resistance			Toughness →	
				PH5705	PH7910	PH7920	PH5740	PH7740
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	✓			✓	

- 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 →		
				PH5705	PH7910	PH7920	PH5740	PNH(K)X 1105...
P	1	Unalloyed Steel	125-220	-	190-280	180-250	-	0,15-0,30
	2	Low-Alloyed Steel	220-280	-	180-240	170-210	-	0,15-0,30
	3	High-Alloyed Steel	280-380	-	170-220	160-200	-	0,15-0,25
K	7	Malleable Cast Iron	130-230	190-340	-	-	170-300	0,12-0,35
	8	Grey Cast Iron	180-245	180-300	-	-	150-260	0,12-0,35
	9	Nodular Cast iron	160-250	140-250	-	-	130-220	0,12-0,30

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

(Note 2) Cutting conditions should be adjusted according to the machine and work rigidity.

(Note 3) If chattering occurs, reduce a_p and V_c by 30% and keep the same f_z per tooth.

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

ISO	PSM	Material	HB (Brinell)	Chip-Breaker Application	
				1st choice	Difficult Operations
P	1	Unalloyed Steel	125-220	PNH(K)X 11... MK	-
	2	Low-Alloyed Steel	220-280	PNH(K)X 11... MK	-
	3	High-Alloyed Steel	280-380	PNH(K)X 11... MK	-
K	7	Malleable Cast Iron	130-230	PNH(K)X 11... MK	PNH(K)X 11... HK
	8	Grey Cast Iron	180-245	PNH(K)X 11... MK	PNH(K)X 11... HK
	9	Nodular Cast iron	160-250	PNH(K)X 11... MK	PNH(K)X 11... HK

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