

High performance face milling



Facing



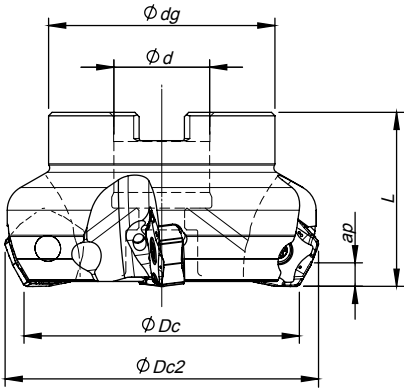
PLUS
PN60-11



INSERT SIZE
11 PN...
1105



100
YEARS
SINCE 1916



Arbor Mounting
 $\kappa_r=60^\circ$ | γ_p-7°

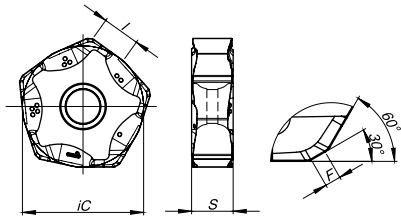
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (in)						Specifications		Insert Pastilha Inserto	Stock
			ØDc	ØDc2	Ød	Ødg	L		Arbor Type	Ap max (in)		
181055700	PN60 D2.00-A.750/1.75-05-11	5	2.000	2.356	0.750	1.772	1.750	0.97	A	0.200	PN... 1105...	
181063800	PN60 D2.50-A1.00/1.75-05-11	5	2.500	2.856	1.000	2.205	1.750	1.60	A	0.200	PN... 1105...	
181055800	PN60 D2.50-A1.00/1.75-06-11	6	2.500	2.856	1.000	2.205	1.750	1.52	A	0.200	PN... 1105...	
181063900	PN60 D3.00-A1.00/2.00-06-11	6	3.000	3.356	1.000	2.205	2.000	2.44	A	0.200	PN... 1105...	
181055900	PN60 D3.00-A1.00/2.00-08-11	8	3.000	3.356	1.000	2.205	2.000	2.27	A	0.200	PN... 1105...	
181064000	PN60 D4.00-A1.25/2.00-07-11	7	4.000	4.356	1.250	2.874	2.000	4.09	A	0.200	PN... 1105...	
181056000	PN60 D4.00-A1.25/2.00-10-11	10	4.000	4.356	1.250	2.874	2.000	4.07	A	0.200	PN... 1105...	
181064100	PN60 D5.00-A1.50/2.50-08-11	8	5.000	5.356	1.500	3.386	2.500	7.33	A	0.200	PN... 1105...	
181056100	PN60 D5.00-A1.50/2.50-12-11	12	5.000	5.356	1.500	3.386	2.500	7.29	A	0.200	PN... 1105...	
181064200	PN60 D6.00-A2.00/2.50U-10-11	10	6.000	6.356	2.000	4.882	2.500	9.35	B	0.200	PN... 1105...	
181056200	PN60 D6.00-A2.00/2.50U-14-11	14	6.000	6.356	2.000	4.882	2.500	9.46	B	0.200	PN... 1105...	
181056300	PN60 D8.00-A2.50/2.50U-16-11	16	8.000	8.356	2.500	5.512	2.500	14.54	C	0.200	PN... 1105...	
181056400	PN60 D10.0-A2.50/2.50U-18-11	18	10.000	10.356	2.500	7.087	2.500	26.29	C	0.200	PN... 1105...	

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

Inventory maintained. To be replaced by new item. | Iten em stock. Será substituído por novo item | Iten en stock. Será reemplazado por nuevo ítem.

PNH(K)X 1105 | Inserts | Pastilhas | Plaquitas



		P					M			K						N	S		H	Dimensions (in)						
		PVD					CVD	PVD		CVD			PVD			UNC	PCD	PVD	PVD					CBN		
		P7	G1	G4	P3	G6	R1	G4	G6	L5	L6	L9	G1	G4	P3	G6	10	D6	P3					G6	P7	D4
⁽¹⁾ Geometry code	ISO Reference	PH7603	PH7910	PH7920	PH7930	PH7740	PHM740	PH7920	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH7740	PH0910	PDP410	PH7930	PH7740	PH7603	PBH910	iC	S	I	F
1111374	PNHX 1105 ZNER-MK																						0.650	0.223	0.224	0.051
1111998	PNHX 1105 ZNER-HK																						0.650	0.223	0.224	0.051
1112294	PNKX 1105 ZNER-MK																						0.650	0.223	0.224	0.051

Stock item | Produto de stock | Itens de stock
First choice | Primeira opção | 1ª opción

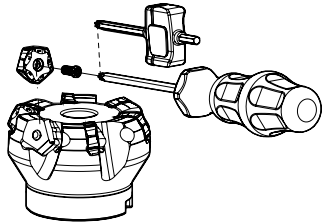
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponible bajo consulta

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

SPARE PARTS | Complementos | Complementos

Cutter ØDc	Insert Screw	Key (Torx)	Torque Value
PN60-A-11 - 2.00-3.00	P0401200	XT15	26.6
PN60-A-11 - 4.00-10.00	P0401200	PT15	26.6



GRADES SELECTION GUIDE

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

ISO	PSM	Material	HB (Brinell)	Vc (sfm)				Feed fz (in/t)
				← Wear Resistance	Toughness →			
				PH5705	PH7910	PH7920	PH5740	PNH(K)X 11...
P	1	Unalloyed Steel	125-220	-	624-919	591-820	-	0.006-0.012
	2	Low-Alloyed Steel	220-280	-	591-788	558-689	-	0.006-0.012
	3	High-Alloyed Steel	280-380	-	558-722	525-656	-	0.006-0.010
K	7	Malleable Cast Iron	130-230	624-1116	-	-	558-984	0.005-0.014
	8	Grey Cast Iron	180-245	591-984	-	-	492-853	0.005-0.014
	9	Nodular Cast iron	160-250	460-820	-	-	427-722	0.005-0.012

(Note 1) Cutting conditions $a_e/DC=70\%$.
(Note 2) Cutting conditions should be ajusted 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

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



PLUS
PN60-11

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100
YEARS
SINCE 1916

Cofinanciado por:

COMPETE
2020

PORTUGAL
2020

UNIÃO EUROPEIA
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