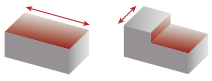
High performance face milling



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PLUS
SN88-12

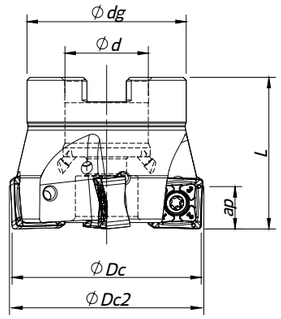
PDF

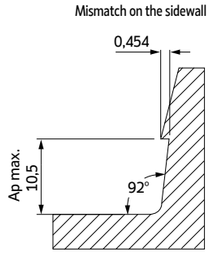
INSERT SIZE 12 SN... 1206

100 YEARS SINCE 1916

PLUS SN88-12

Proprietary milling line





Arbor Mounting

K_r=88° | γ_p=-6°

Order code Código	Reference Referência Referencia		Dimensions | Dimensões | Dimensiones (in)					lbs	Specifications		Insert Pastilha Inserto	Stock
			ØDc	ØDc2	Ød	Ødg	L		Arbor Type	Ap max (in)		
181103400	SN88 D2.00-A.750/1.75-04-12	4	2.000	2.035	0.750	1.772	1.750	0.92	A	0.413	SN... 1206...	◉
181103500	SN88 D2.00-A.750/1.75-05-12	5	2.000	2.035	0.750	1.772	1.750	0.88	A	0.413	SN... 1206...	○
181103600	SN88 D2.50-A1.00/1.75-05-12	5	2.500	2.535	1.000	2.205	1.750	1.14	A	0.413	SN... 1206...	◉
181103700	SN88 D2.50-A1.00/1.75-06-12	6	2.500	2.535	1.000	2.205	1.750	1.10	A	0.413	SN... 1206...	◉
181103800	SN88 D3.00-A1.00/2.00-07-12	7	3.000	3.035	1.000	2.205	2.000	2.20	A	0.413	SN... 1206...	◉
181103900	SN88 D3.00-A1.00/2.00-09-12	9	3.000	3.035	1.000	2.205	2.000	2.12	A	0.413	SN... 1206...	○
NEW 181139100	SN88 D4.00-A1.50/2.50-08-12	8	4.000	4.035	1.500	2.874	2.500	3.52	A	0.413	SN... 1206...	○
NEW 181139200	SN88 D4.00-A1.50/2.50-11-12	11	4.000	4.035	1.500	2.874	2.500	3.30	A	0.413	SN... 1206...	○
181104000	SN88 D4.00-A1.25/2.00-08-12	8	4.000	4.035	1.250	2.874	2.000	3.52	A	0.413	SN... 1206...	◈
181104200	SN88 D5.00-A1.50/2.50-12-12	12	5.000	5.035	1.500	3.386	2.500	6.83	A	0.413	SN... 1206...	○
181104300	SN88 D6.00-A2.00/2.50U-18-12	18	6.000	6.035	2.000	4.882	2.500	7.71	B	0.413	SN... 1206...	◉
181104400	SN88 D8.00-A2.50/2.50U-14-12	14	8.000	8.035	2.500	5.512	2.500	13.90	C	0.413	SN... 1206...	◉
181104500	SN88 D10.0-A2.50/2.50U-22-12	22	10.000	10.035	2.500	7.087	2.500	15.87	C	0.413	SN... 1206...	◉

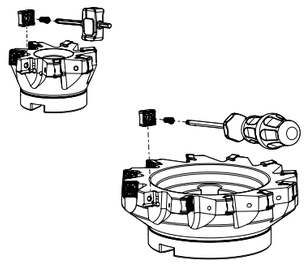
◉ Stock item | Produto de stock | Itens de stock

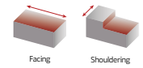
○ Available under request | Disponível sobre consulta | Disponible bajo consulta

◈ Inventory maintained. To be replaced by new item. | Iten em stock. Será substituido por novo item | Iten en stock. Será reemplezado por nuevo iten.

SPARE PARTS | Complementos | Complementos

Cutter ØDc	Insert Screw	Key (Torx)	Torque Value
			lbf/in
SN88-A-12 - 2.00-3.00	P0401200	XT15	26.6
SN88-A-12 - 4.00-10.00	P0401200	PT15	26.6

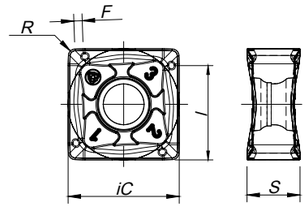




SNH(K)U 1206 | Inserts | Pastilhas | Plaquitas

SNHU-LP

SNKU-LP NEW



		P				M				K							N		S	H		Dimensions (in)				
		PVD				CVD	PVD			CVD			PVD				UNC	PCD	PVD	PVD	CBN					
	(2) Grade code	G1	G4	P3	G6	R1	G4	P3	G6	L5	L6	L9	G1	G4	P3	G6	10	D6	P3	P7	D4					
(1) Geometry code	ISO Reference	PH7910	PH7920	PH7930	PH7740	PHM740	PH7920	PH7930	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH7740	PH0910	PDP410	PH7930	PH7603	PBH910	iC	S	I	R	F
1112020	SNHU 120608 ZNER-LP		◈	◉	◉			◈	◉	◈		◉										0.524	1/4	0.457	0.031	0.039
NEW 1112278	SNKU 120608 ZNER-LP		◈	◉	◉			◈	◉	◈		◉										0.524	1/4	0.457	0.031	0.039

◈ 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

GRADES SELECTION GUIDE

ISO	PSM	Material	HB (Brinell)	Grades ◄— Wear Resistance — Toughness —► PH5705 ◉	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 / Duplex	200-330			✓		✓
	6	SS - Duplex	230-260			✓		✓
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) ← Wear Resistance		Toughness →
				PH5705	PH7920	PH7930
P	1	Unalloyed Steel	125-220	-	591 **(820)** 1 050	-
	2	Low-Alloyed Steel	220-280	-	460 **(591)** 820	-
	3	High-Alloyed Steel	280-380	-	427 **(591)** 722	-
M	4	SS - Ferritic / Martensitic	200-330	-	-	460 **(558)** 624
	5	SS - Austenitic / Duplex	200-330	-	-	394 **(460)** 558
	6	SS - Duplex	230-260	-	-	328 **(394)** 492
K	7	Malleable Cast Iron	130-230	525 **(591)** 968	-	-
	8	Grey Cast Iron	180-245	558 **(886)** 1 116	-	-
	9	Nodular Cast iron	160-250	394 **(492)** 656	-	-

Vc (sfm) ← Wear Resistance	Toughness →	Feed fz (in/t)
PH5740	PH7740	SNH(K)U 1206...
460 **(558)** 624	492 **(591)** 656	0.004 **(0.010)** 0.014
394 **(460)** 558	427 **(492)** 591	0.004 **(0.010)** 0.014
328 **(394)** 492	361 **(427)** 525	0.004 **(0.010)** 0.014
-	427 **(492)** 558	0.004 **(0.010)** 0.014
-	328 **(427)** 525	0.004 **(0.010)** 0.014
-	263 **(328)** 460	0.004 **(0.010)** 0.014
460 **(525)** 820	-	0.004 **(0.010)** 0.014
476 **(591)** 919	-	0.004 **(0.010)** 0.014
345 **(492)** 558	-	0.004 **(0.010)** 0.014

(Note 1) The above table indicates the cutting conditions of 70% of the tool engagement.
(Note 2) With low workspace clamping rigidity or long overhang of the tool, adjust cutting speed and feed to 70 or 80% of the recommended conditions above
(Note 3) Surface finishing is determinated by speed/feed used.
(Note 4) PH5... can be used wet or dry. PH7... use only air.

Selection Example:

ISO	PSM	Material	HB (brinell)	Vc (sfm) ← Wear Resistance	Toughness →	Feed f_z (in/t)
				PH5705	PH5740	SNHU 1206... SNKU 1206...
K	7	Malleable cast iron	130-230	525 **(591)** 968	460 **(525)** 820	0.004 **(0.010)** 0.014
	8	Grey cast iron	180-245	558 **(886)** 1 116	476 **(591)** 919	0.004 **(0.010)** 0.014
	9	Nodular cast iron	160-250	394 **(492)** 656	345 **(492)** 558	0.004 **(0.010)** 0.014

This example shows the recommended starting cutting conditions, indicated in **Bold type**.

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