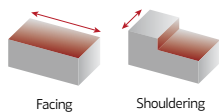
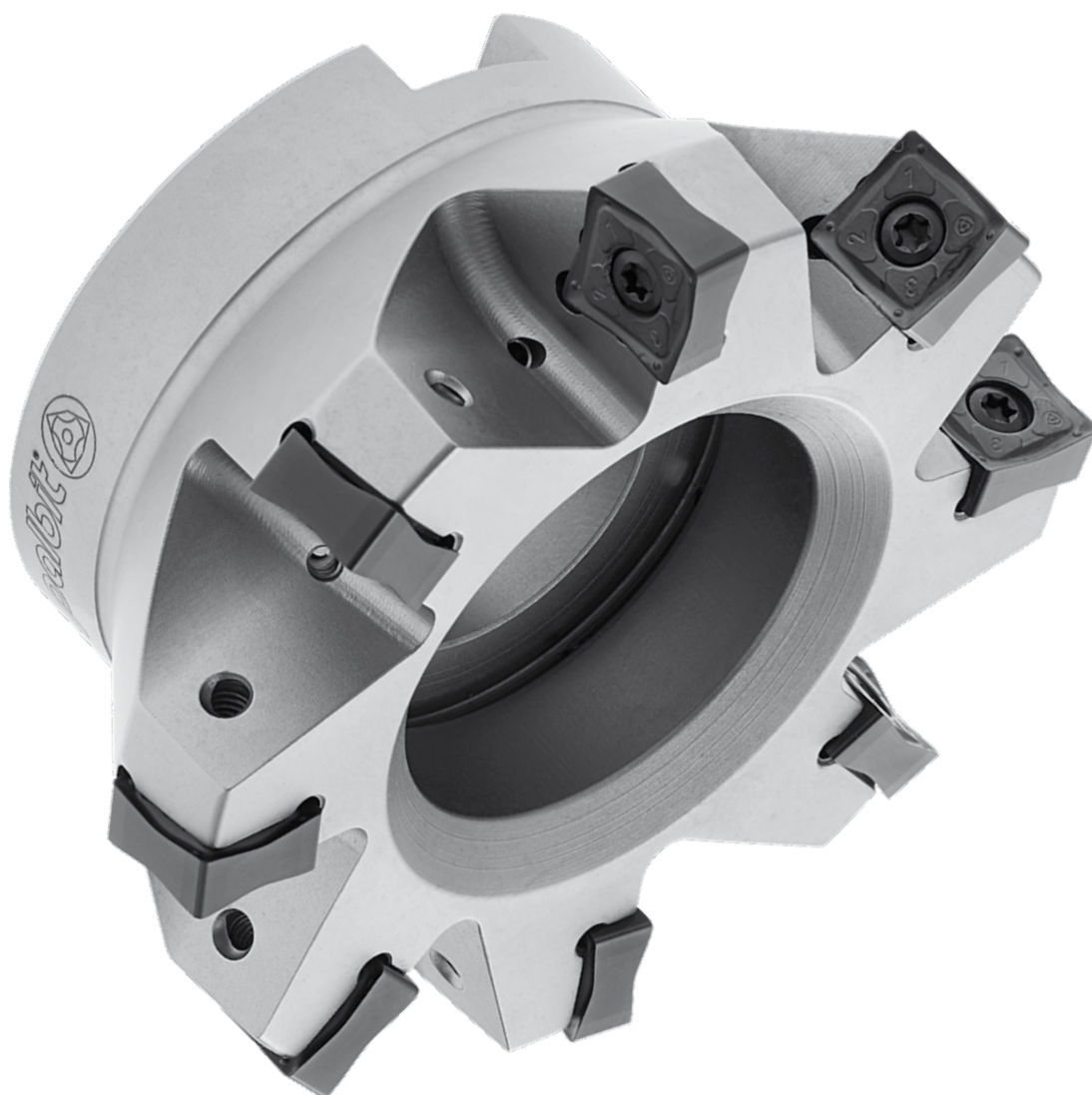


Solution for face milling with 88° lead angle



palbit
CUTTING TOOLS SOLUTIONS

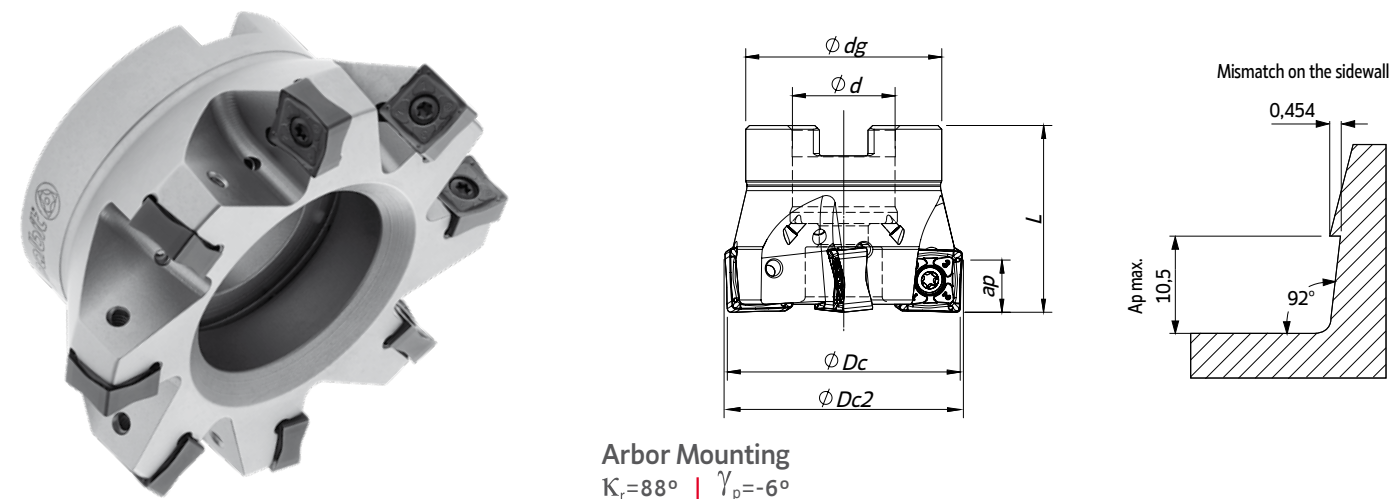
PLUS
28088



INSERT SIZE
12 SN...U
1206



100
YEARS
SINCE 1916



Arbor Mounting
 $K_r=88^\circ$ | $\gamma_p=-6^\circ$

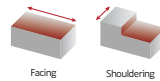
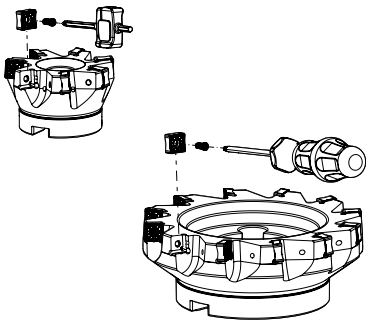
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)					Kg	Specifications		Insert Pastilha Inserto	Stock
			ϕDc	$\phi Dc2$	ϕd	ϕdg	L		Arbor Type	Ap max (mm)		
181084300	050A28088-05-06-022040	5	50	50,9	22	42	40	0,4	A	10,5	SN... 1206...	
181091600	063A28088-06-06-022040	6	63	63,9	22	48	40	0,5	A	10,5	SN... 1206...	
181091700	080A28088-07-06-027050	7	80	80,9	27	60	50	1,0	A	10,5	SN... 1206...	
181091800	080A28088-09-06-027050	9	80	80,9	27	60	50	0,9	A	10,5	SN... 1206...	
181091900	100A28088-08-06-032050	8	100	100,9	32	73	50	1,6	B	10,5	SN... 1206...	
181092000	100A28088-11-06-032050	11	100	100,9	32	73	50	1,5	B	10,5	SN... 1206...	
181092100	125A28088-10-06-040063	10	125	125,9	40	90	63	3,1	B	10,5	SN... 1206...	
181092200	125A28088-14-06-040063	14	125	125,9	40	90	63	3,0	B	10,5	SN... 1206...	
181092300	160A28088-12-06-U040063	12	160	160,9	40	110	63	3,7	C	10,5	SN... 1206...	
181092700	160A28088-18-06-U040063	18	160	160,9	40	110	63	3,5	C	10,5	SN... 1206...	
181092800	200A28088-14-06-U060063	14	200	200,9	60	172	63	6,3	C	10,5	SN... 1206...	
181092900	200A28088-22-06-U060063	22	200	200,9	60	172	63	6,1	C	10,5	SN... 1206...	

Stock item | Produto de stock | Itens de stock

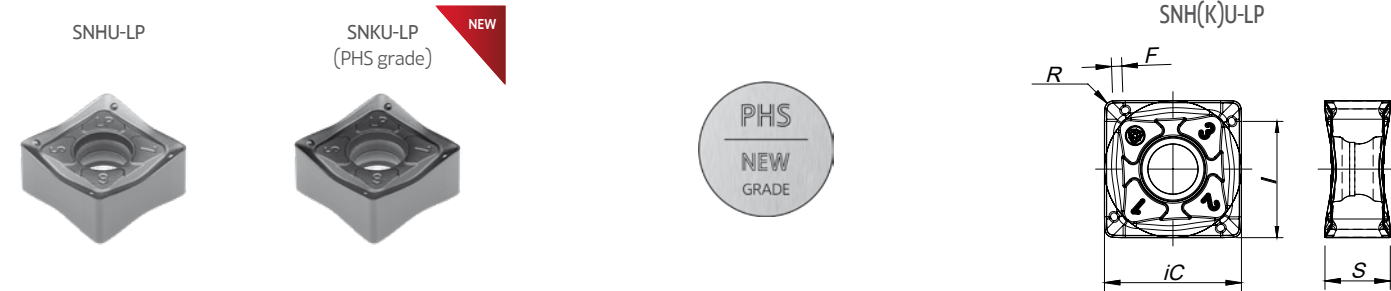
Available under request | Disponível sobre consulta | Disponible bajo consulta

SPARE PARTS | Complementos | Repuestos

Cutter ϕDc	Insert Screw	Key (Torx)	Order separately		Order separately	
			Key (Torx - Nm)	Torque Value	Screw	DIN 6368 Wrench
A28088 - 50 - 80	P0401200	XT15	DT1530	3,0	-	-
A28088 - 100	P0401200	PT15	DT1530	3,0	J0164110	SD6368-16
A28088 - 125	P0401200	PT15	DT1530	3,0	J0204610	SD6368-20
A28088 - 160 - 200	P0401200	PT15	DT1530	3,0	-	-



SNH(K)U 1206 | 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	G1	G4	P3	G6	R1	G4	P3	G6	L5	L6	L9	G1	G4	P3	G6	10						D6	P3	P7
⁽¹⁾ Geometry code	ISO Reference	PH5740	PH7910	PH7920	PH7930	PH7740	PHM740	PH7920	PH7930	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH7740	PH0910	PDP410	PH7930	PH7603	iC	S	I	R	F	
1112020	SNHU 120608 ZNER-LP																						13,30	6,35	11,60	0,80	1,00
1112278	SNKU 120608 ZNER-LP																						13,30	6,35	11,60	0,80	1,00

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	PH7920	PH7930	PH5740	PHS740	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	✓			✓		

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)		
				← Wear Resistance		Toughness →
				PH5705	PH7920	PH7930
P	1	Unalloyed Steel	125-220	-	180 (250) 320	-
	2	Low-Alloyed Steel	220-280	-	140 (180) 250	-
	3	High-Alloyed Steel	280-380	-	130 (180) 220	-
M	4	SS - Ferritic / Martensitic	200-330	-	-	140 (170) 190
	5	SS - Austenitic	200-330	-	-	120 (140) 170
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	100 (120) 150
K	7	Malleable Cast Iron	130-230	160 (180) 295	-	-
	8	Grey Cast Iron	180-245	170 (270) 340	-	-
	9	Nodular Cast iron	160-250	120 (150) 200	-	-

ISO	PSM	Material	HB (Brinell)	Vc (m/min)			Feed fz (mm/t)
				← Wear Resistance		Toughness →	
				PH5740	PHS740	PH7740	SNH(K)U 1206...
P	1	Unalloyed Steel	125-220	140 (170) 190	140 (170) 190	150 (180) 200	0,10 (0,25) 0,35
	2	Low-Alloyed Steel	220-280	120 (140) 170	120 (140) 170	130 (150) 180	0,10 (0,25) 0,35
	3	High-Alloyed Steel	280-380	100 (120) 150	100 (120) 150	110 (130) 160	0,10 (0,25) 0,35
M	4	SS - Ferritic / Martensitic	200-330	-	-	130 (150) 170	0,10 (0,25) 0,35
	5	SS - Austenitic	200-330	-	-	100 (130) 160	0,10 (0,25) 0,35
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	80 (100) 140	0,10 (0,25) 0,35
K	7	Malleable Cast Iron	130-230	140 (160) 250	-	-	0,10 (0,25) 0,35
	8	Grey Cast Iron	180-245	145 (180) 280	-	-	0,10 (0,25) 0,35
	9	Nodular Cast iron	160-250	105 (150) 170	-	-	0,10 (0,25) 0,35

(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 determined by speed/feed used.

(Note 4) PH5... and PHS... can be used wet or dry. PH7... use only air.

Selection Example:

ISO	PSM	Material	HB (brinell)	Vc (m/min)		Feed fz (mm/t)
				← Wear Resistance	Toughness →	
				PH5705	PH5740	SNHU 1206... SNKU 1206...
K	7	Malleable cast iron	130-230	160 (180) 295	140 (160) 250	0,10 (0,25) 0,35
	8	Grey cast iron	180-245	170 (270) 340	145 (180) 280	0,10 (0,25) 0,35
	9	Nodular cast iron	160-250	120 (150) 200	105 (150) 170	0,10 (0,25) 0,35

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

Cofinanciado por:

