

Double-sided round milling insert

palbit[®]
CUTTING TOOLS SOLUTIONS

TOROMILL X2
35190



INSERT SIZE
12 RNHX
1204

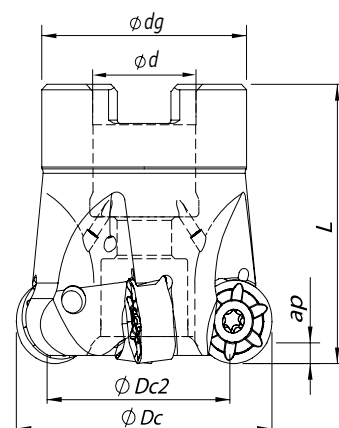


SINCE **1916**



Arbor Mounting

$\gamma_p = -7^\circ$



Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)					Kg	Specifications		Insert Pastilha Inserto	Stock
			ϕDc	$\phi Dc2$	$\phi d/M$	ϕdg	L		Arbor Type	Ap max (mm)		
181111600	040A35190-04-07-016040	4	40	32	16	32	40	0,20	A	3,0	RNHX 1204 M0E...	
181100200	050A35190-05-07-022040	5	50	42	22	40	40	0,24	A	3,0	RNHX 1204 M0E...	
181128800	063A35190-06-07-022050	6	63	49	22	48	50	0,55	A	3,0	RNHX 1204 M0E...	
181128900	080A35190-07-07-027050	7	80	60	27	60	50	0,78	A	3,0	RNHX 1204 M0E...	

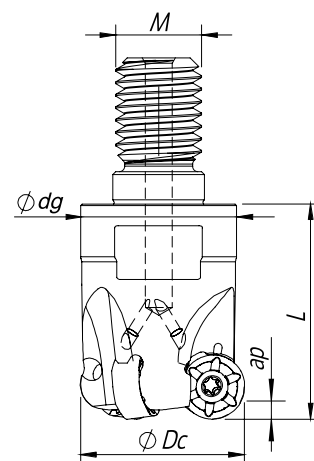
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta



Threaded Coupling

$\gamma_p = -7^\circ$

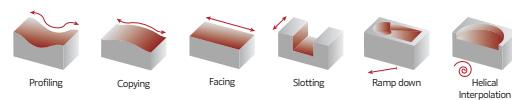


Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications		Insert Pastilha Inserto	Stock
			ϕDc	$\phi d/M$	ϕdg	L		Ap max (mm)			
181128500	032R35190-03-07-M16040	3	32	M16	29	40	0,16	3,0		RNHX 1204 M0E...	
181128700	042R35190-04-07-M16040	4	42	M16	29	40	0,20	3,0		RNHX 1204 M0E...	

Stock item | Produto de stock | Itens de stock

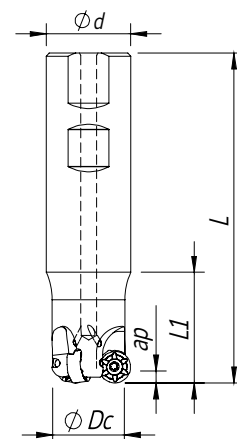
Available under request | Disponível sobre consulta | Disponible bajo consulta

TOROMILL X2 35190
RNHX



Weldon Shank

$\gamma_p = -7^\circ$



Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications	Insert Pastilha Inserto	Stock
			ØDc	Ød/M	L	L1		Ap max (mm)		
181087000	032W35190-03-07-032125	3	32	32	125	42	0,98	3,0	RNHX 1204 MOE...	

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

RNHX 1204... | Inserts | Pastilhas | Plaquetas

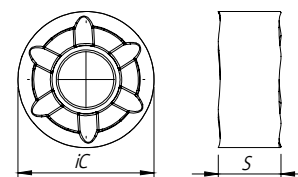
RNHX-LP



RNHX-MP



RNHX-LP | MP



		P						M				K						N		S		H	Dimensions Dimensões Dimensiones (mm)						
		CVD	PVD					CVD	PVD			CVD			PVD			UNC	PCD	CVD	PVD	PVD							
		⁽²⁾ Grade code	T9	P7	G1	G4	P3	G6	R1	G4	P3	G6	L5	L6	L9	G1	G4	P3	G6	10	D6	R1						P3	G6
⁽¹⁾ Geometry code	ISO Reference	PH5740	PH7603	PH7910	PH7920	PH7930	PH7740	PHM740	PH7920	PH7930	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH7740	PH0910	PDP410	PHM740	PH7930	PH7740	PH7603	IC	S	I	F	B
1112030	RNHX 1204 M0E-LP																								12,00	4,76	-	-	-
1112052	RNHX 1204 M0E-MP																								12,00	4,76	-	-	-

First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

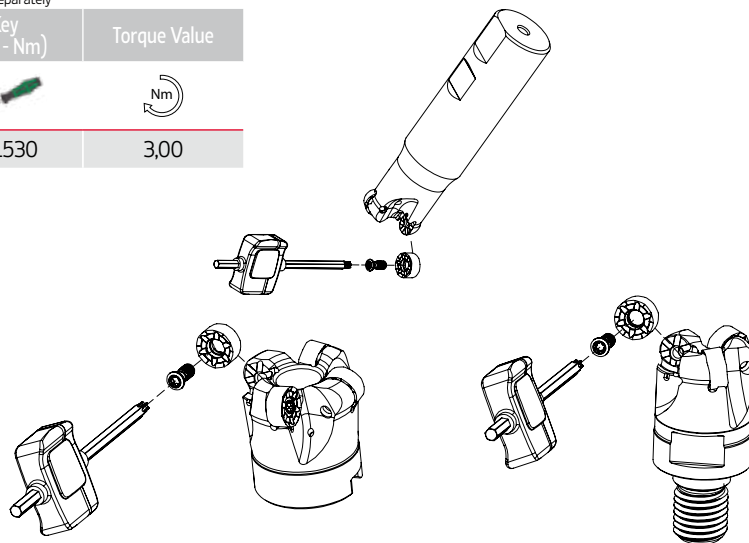
Available under request | Disponível sobre consulta
Disponible bajo consulta

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

TOROMILL X2 35190

SPARE PARTS | Complementos | Repuestos

Cutter ØDc	Insert Screw	Key (Torx)	Order separately	
			Key (Torx - Nm)	Torque Value
35190	P0401065	XT15	DT1530	3,00



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

ISO	PSM	Material	HB (Brinell)	Grades		
				← Wear Resistance		Toughness →
				PH7920	PH7930	PHM740
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

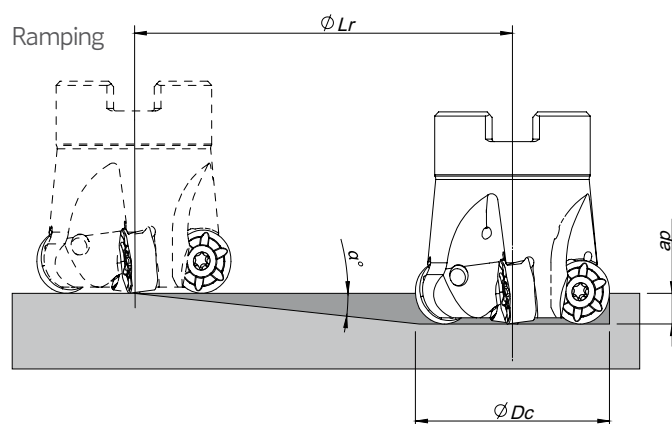
RECOMMENDED CUTTING CONDITIONS | Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min)			RNHX... 12	
				← Wear Resistance		Toughness →	fz (mm/t)	ap (mm)
				PH7920	PH7930	PHM740		
P	1	Unalloyed Steel	125-220	150-230	130-210	-	0,15-0,50	0,50-3,00
	2	Low-Alloyed Steel	220-280	140-220	120-200	-	0,15-0,50	0,50-3,00
	3	High-Alloyed Steel	280-380	130-180	110-160	-	0,15-0,50	0,50-3,00
M	4	SS - Ferritic / Martensitic	200-330	-	100-120	100-130	0,10-0,35	0,50-3,00
	5	SS - Austenitic	200-330	-	80-110	80-120	0,10-0,35	0,50-3,00
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	70-100	70-110	0,10-0,35	0,50-3,00
K	7	Malleable Cast Iron	130-230	-	150-280	-	0,15-0,55	0,50-3,00
	8	Grey Cast Iron	180-245	-	130-230	-	0,15-0,55	0,50-3,00
	9	Nodular Cast iron	160-250	-	80-190	-	0,15-0,55	0,50-3,00
S	11	Heat Resistant Super Alloys	200-320	-	20-80	20-90	0,05-0,30	0,50-3,00

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	LP	MP
	2	Low-Alloyed Steel	220-280	LP	MP
	3	High-Alloyed Steel	280-380	MP	-
M	4	SS - Ferritic / Martensitic	200-330	LP	-
	5	SS - Austenitic	200-330	LP	-
	6	SS - Austenitic-ferritic (Duplex)	230-260	LP	MP
K	7	Malleable Cast Iron	130-230	MP	-
	8	Grey Cast Iron	180-245	MP	-
	9	Nodular Cast iron	160-250	MP	-
S	11	Heat Resistant Super Alloys	200-320	LP	-

RAMPING || Descida em rampa | Bajada en rampa



Insert	φDc	Ramping		
		Max Ramp α°	Max ap	Min Lr
RNHX 1204	32	1	3	171,9
	40	0,8	3	214,8
	42	0,8	3	214,8
	50	0,8	3	214,8
	63	0,6	3	286,5
	80	0,5	3	343,8



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