PHG & PHS New Turning Grades

The best grades for machinning Steels and Stainless Steels

palbit
TOOLING SOLUTIONS EXPERTS
SINCE1916

NEW
PHG & PHS
New Turning Grades

Cosmic Technology **for better Productivity**

PHG
NEW
GRADE

PHG105
NEW
P05-P10

First choice for continuous cut with hardness higher than 38HRC

New CVD coating with Al_2O_3+TiN combined with a very hard substrate.

PHG115
P10-P25

Suitable for high to medium cutting speeds on steels

New CVD coating with Al_2O_3+TiN.

PHG125
P20-P35

Ideal for general application in all kind of steels

Carbide grade suitable for medium machining of steels at medium cutting speeds.

PHG140
NEW
P25-P45

First choice for roughing to heavy roughing operations with interrupted cut at medium to low cutting speeds

Binary substrate grade (Wc - Co) with medium grain size combined with a medium temperature CVD coating.

PHG128
NEW
P40-P50

A very high toughness grade ideal for heavy roughing applications while using on large I.C inserts

New CVD coating with Al_2O_3+TiN.

VIDEO

Top coating (TiN)

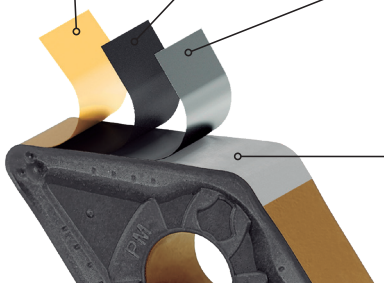
A yellow TiN-coating on insert allows easier wear detection.

CVD - Alumina Coating (Al_2O_3)

High-strength alumina coating. The top surface is smooth and does not stick to the chip.

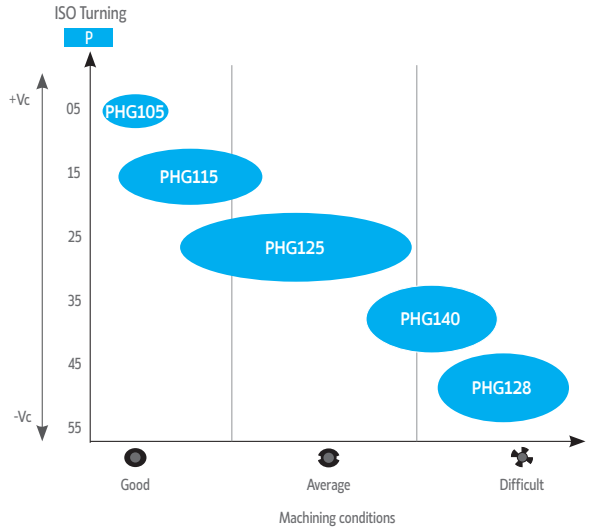
Inner coating Ti(C,N)

Fine grain TiCN (titantium carbide) coating with columnar structure which is hard and wear resistant against abrasive wear.



SUBSTRATE

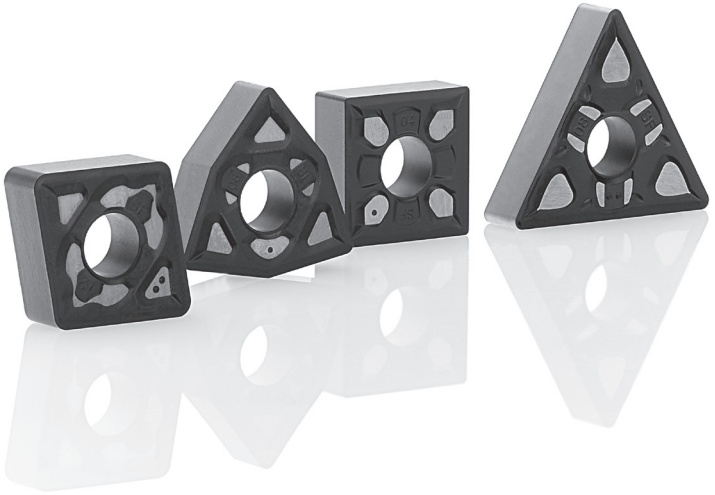
Cemented-carbide substrate that combines high strength with reliable toughness.



PHS TURNING GRADE FOR STAINLESS STEELS | Grau de torneamento PHS | Calidad de torneado PHS

NEW

PHS
NEW
GRADE



PHS215 NEW
M10-M25

Suitable for high to medium cutting speeds in stainless steel. Ideal for turning on good condition of cut (continuous cut)

PHS225 NEW
M15-M30

First choice for general application on turning of stainless steels

Carbide grade suitable for medium machining of stainless steels and super alloys at medium cutting speeds.

PHS240 NEW
M25-M45

First choice for roughing to heavy roughing operations with interrupted cut at medium to low cutting speeds on stainless steel.

Top coating (TiC)

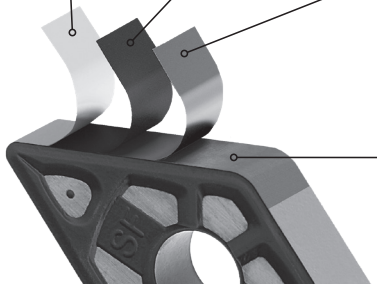
A grey TiC-coating on insert allows easier wear detection.

CVD - Alumina Coating (Al_2O_3)

High-strength alumina coating. The top surface is smooth and does not stick to the chip.

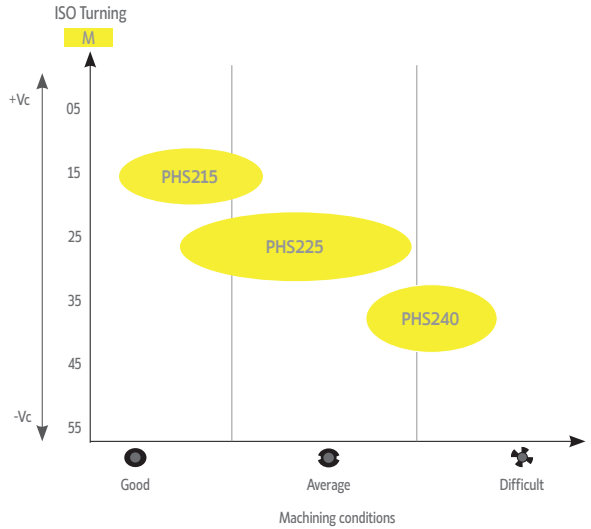
Inner coating Ti(C,N)

Fine grain TiCN (titantium carbide) coating with columnar structure which is hard and wear resistant against abrasive wear.



SUBSTRATE

Cemented-carbide substrate that combines high strength with reliable toughness.

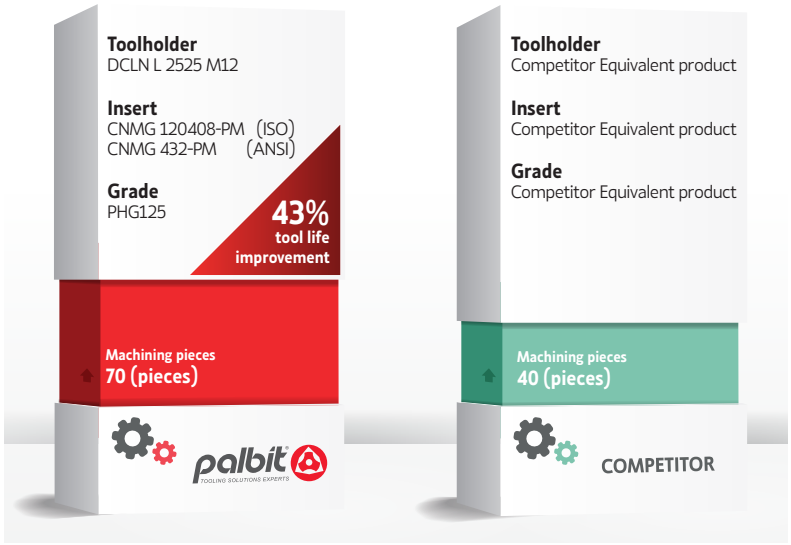


VIDEO

palbit SINCE 1916

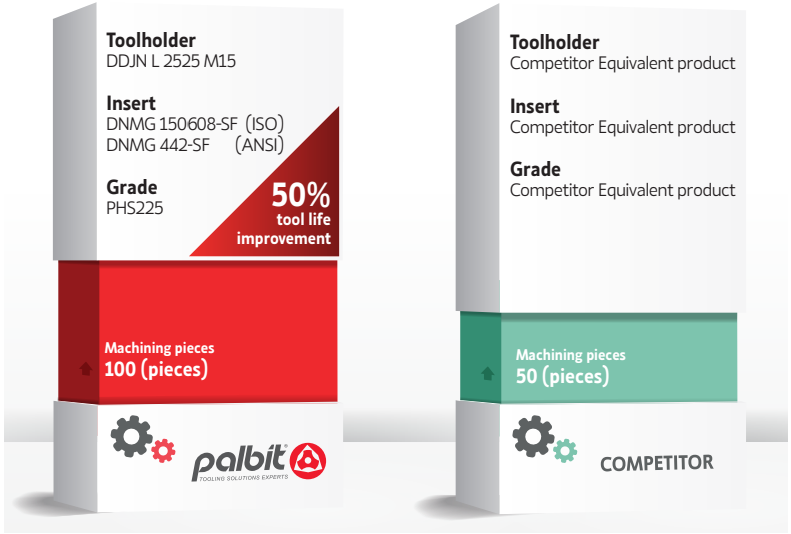
PHG NEW GRADE

PHS NEW GRADE



Workpiece material: Low-alloy steel, Ck45 (200 HB)

Cutting speed: Vc	200 m/min	656 sfm
Feed per tooth: fn	0,30 mm/r	0.012 in/r
Depth of cut: ap	3,00 mm	0.118 in
Operation	External turning	
Coolant	Emulsion	



Workpiece material: stainless steel, AISI 316

Cutting speed: Vc	180 m/min	590 sfm
Feed per tooth: fn	0,30 mm/r	0.012 in/r
Depth of cut: ap	2,00 mm	0.078 in
Operation	External turning	
Coolant	Emulsion	

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