

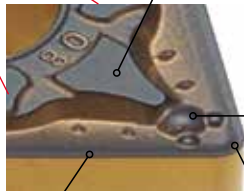
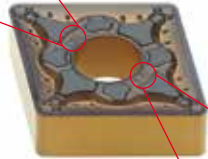


PM
NEW
CHIP-BREAKER

PHG
NEW
GRADE

QR code with play button icon
SCAN
ME!

A small step for Palbit, a big step for productivity



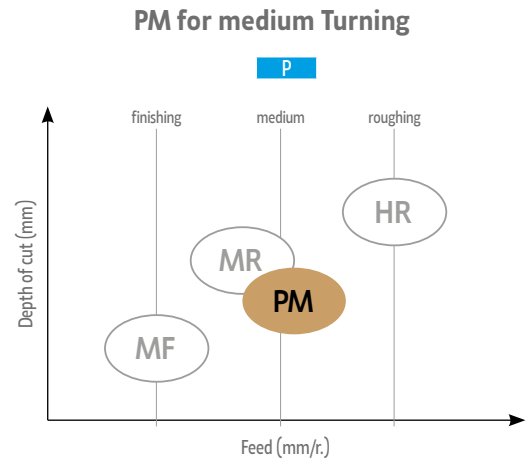
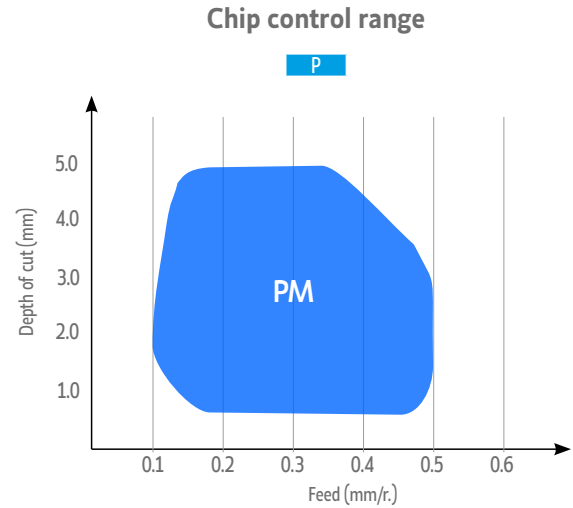
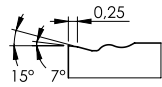
Chip-breaker Indication

Wide contact area
of insert with holder
prevents chipping due
to stable basis.

Newly developed chip-breaker for turning
Excellent chip control even when machining with a small depth of cut.
Suitable for machining with a variable depth of cut

Optimized and tough cutting edge Improvement
Fracture resistance provides high strength and reduced cutting forces

Proper rake angle
of cutting edge ensures better surface finish and low cutting resistance.



New medium temperature CVD coating with α - Al₂O₃+TiN.
Suitable for high to medium cutting speeds on steels & cast steels.

First choice for a majority of steel turning applications, roughing to finishing, continuous and interrupted cuts

Technical features

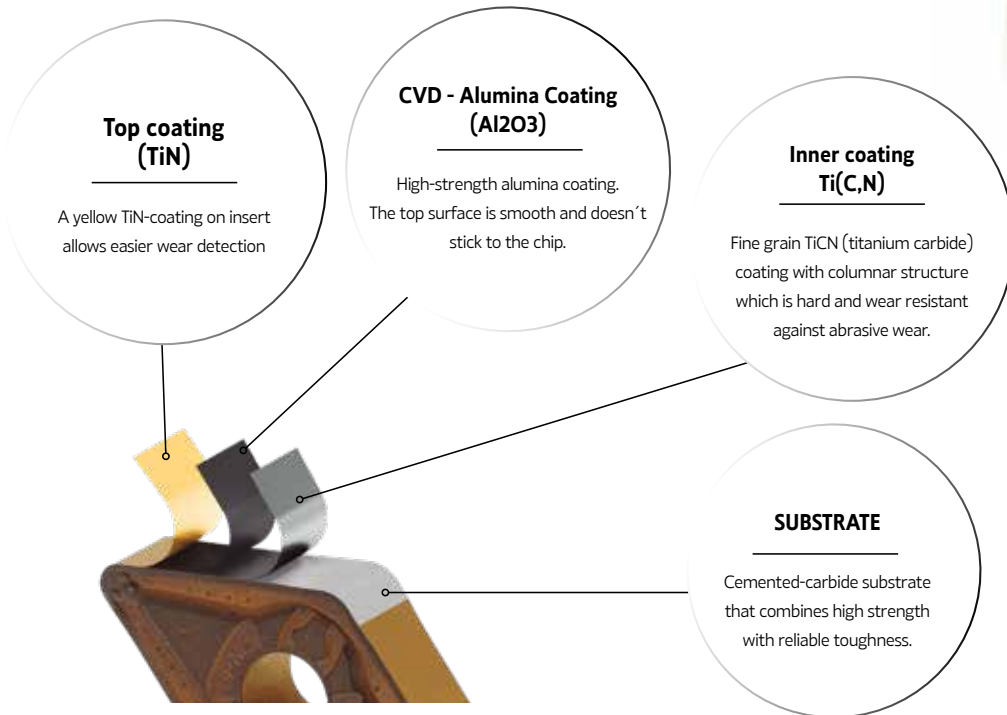
New grade (PHG...) for high wear resistance and long tool life
 The new grade create a strong barrier towards the cutting zone and the chip.

Heat-resistant substrate

The cemented-carbide substrate adds high strength and reliable toughness.
 Optimized to withstand heat, it is suitable for applications with focus on high material removal rate.

Other insert details

The MT-TiCN inner coating is hard and wear-resistant against abrasive wear.
 The yellow top TiN coating on the insert flank allows for easy wear detection.



Application

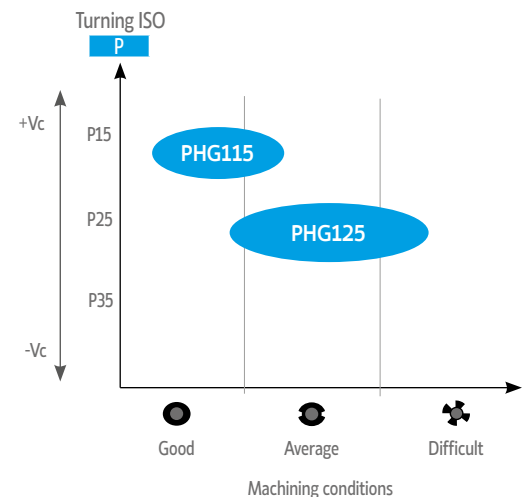
- External and internal turning
- Roughing to finishing
- Wet and dry machining


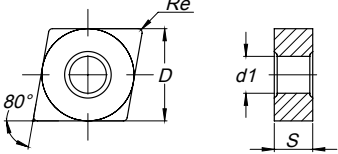

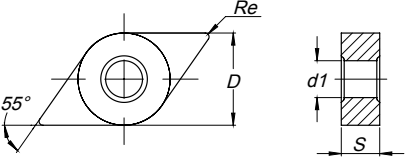

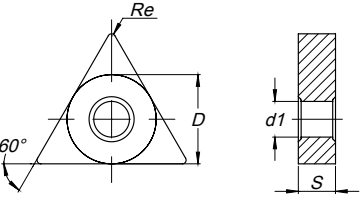

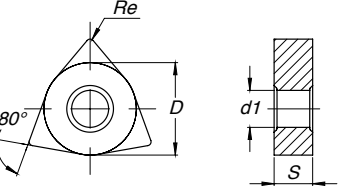
PHG125

- First choice for a vast majority of steel turning applications
- Continuous to interrupted cuts

PHG115

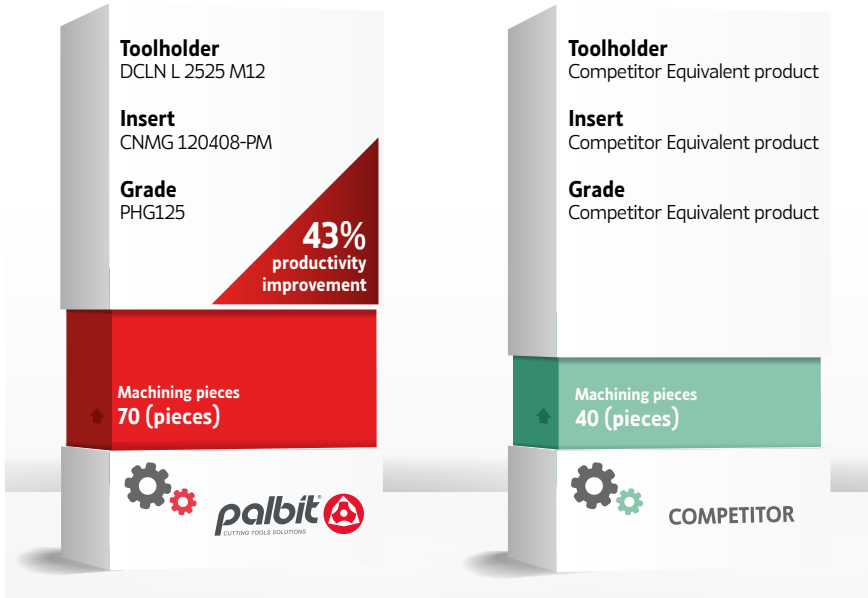
- Continuous to light-interrupted cuts
- High cutting speed
- Enables long time machining
- Hard workpiece materials



Inserts Pastilhas Plaquitas	(1) Geometry code	(2) Grade code		P		Dimensions (mm) Dimensões (mm) Dimensiones (mm)				Cutting Conditions Condições de Corte Condiciones de Corte					Technical drawing Desenho técnico Dibujo técnico	
				CVD-MT						ap (mm)	Min	Max	fn (mm/rev)	Min		Max
				R2	R3	PHG115	PHG125	D	S							
	1123919	CNMG 120404-PM	CNMG 431-PM	⊗	⊗	12,700	4,76	0,40	5,16	3,00	0,40	5,50	0,20	0,10	0,30	
	1123790	CNMG 120408-PM	CNMG 432-PM	⊗	⊗	12,700	4,76	0,80	5,16	3,00	0,50	5,50	0,30	0,15	0,50	
	1123920	CNMG 120412-PM	CNMG 433-PM	⊗	⊗	12,700	4,76	1,20	5,16	3,00	0,80	5,50	0,35	0,18	0,60	
Medium	1123921	CNMG 120416-PM	CNMG 434-PM	⊗	⊗	12,700	4,76	1,60	5,16	3,00	1,00	5,50	0,40	0,23	0,65	
	1123924	DNMG 150404-PM	DNMG 431-PM	⊗	⊗	12,700	4,76	0,40	5,16	3,00	0,40	6,00	0,20	0,10	0,30	
	1123916	DNMG 150408-PM	DNMG 432-PM	⊗	⊗	12,700	4,76	0,80	5,16	3,00	0,50	6,00	0,30	0,15	0,50	
	1123925	DNMG 150412-PM	DNMG 433-PM	⊗	⊗	12,700	4,76	1,20	5,16	3,00	0,80	6,00	0,35	0,18	0,60	
	1123926	DNMG 150416-PM	DNMG 434-PM	⊗	⊗	12,700	4,76	1,60	5,16	3,00	1,00	6,00	0,40	0,23	0,65	
	1124065	DNMG 150604-PM	DNMG 441-PM	⊗	⊗	12,700	6,35	0,40	5,16	2,50	0,50	5,00	0,25	0,15	0,40	
	1123777	DNMG 150608-PM	DNMG 442-PM	⊗	⊗	12,700	6,35	0,80	5,16	3,00	0,50	6,00	0,30	0,15	0,50	
1124066	DNMG 150612-PM	DNMG 443-PM	⊗	⊗	12,700	6,35	1,20	5,16	3,50	0,50	7,00	0,35	0,20	0,60		
	1123991	TNMG 160404-PM	TNMG 331-PM	⊗	⊗	9,525	4,76	0,40	3,81	3,00	0,40	5,00	0,20	0,10	0,30	
	1123917	TNMG 160408-PM	TNMG 332-PM	⊗	⊗	9,525	4,76	0,80	3,81	3,00	0,50	5,00	0,30	0,15	0,50	
	1123992	TNMG 160412-PM	TNMG 333-PM	⊗	⊗	9,525	4,76	1,20	3,81	3,00	0,80	5,00	0,35	0,18	0,60	
	1123993	TNMG 160416-PM	TNMG 334-PM	⊗	⊗	9,525	4,76	1,60	3,81	3,00	1,00	5,00	0,40	0,23	0,65	
	1123922	TNMG 220404-PM	TNMG 431-PM	⊗	⊗	12,700	4,76	0,40	5,16	4,00	0,40	6,60	0,20	0,10	0,30	
	1123923	TNMG 220408-PM	TNMG 432-PM	⊗	⊗	12,700	4,76	0,80	5,16	4,00	0,50	6,60	0,30	0,15	0,50	
	1123994	TNMG 220412-PM	TNMG 433-PM	⊗	⊗	12,700	4,76	1,20	5,16	4,00	0,80	6,60	0,35	0,18	0,60	
	1123995	TNMG 220416-PM	TNMG 434-PM	⊗	⊗	12,700	4,76	1,60	5,16	4,00	1,00	6,60	0,40	0,23	0,60	
	1123988	WNMG 080404-PM	WNMG 431-PM	⊗	⊗	12,700	4,76	0,40	5,16	2,50	0,50	4,00	0,22	0,10	0,30	
	1123918	WNMG 080408-PM	WNMG 432-PM	⊗	⊗	12,700	4,76	0,80	5,16	2,50	0,50	4,00	0,30	0,15	0,50	
	1123989	WNMG 080412-PM	WNMG 433-PM	⊗	⊗	12,700	4,76	1,20	5,16	2,50	0,80	4,00	0,35	0,18	0,60	
	1123990	WNMG 080416-PM	WNMG 434-PM	⊗	⊗	12,700	4,76	1,60	5,16	3,00	1,00	4,50	0,35	0,20	0,65	

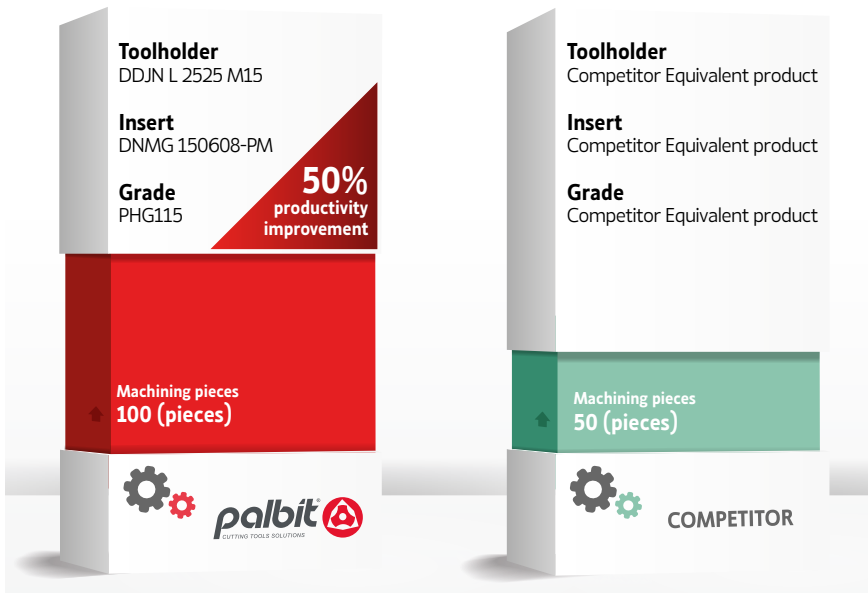
⊗ First choice | 1ª Escolha | 1ª Opción ⊗ Stock Itens | Itens de stock

Insert Order Code: (1) Geometry code + (2) Grade code



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

Cutting speed: Vc (m/min)	200
Feed per tooth: fn (mm/r)	0,30
Depth of cut: ap (mm)	3,00
Operation	External, axial and face turning
Coolant	Emulsion



Workpiece material: Low-alloy steel, 40Mn4 (255 HB)

Cutting speed: Vc (m/min)	250
Feed per tooth: fn (mm/r)	0,25
Depth of cut: ap (mm)	2,50
Operation	External turning
Coolant	Emulsion



PHG
NEW
GRADE

PM
NEW
CHIP-BREAKER

HEADQUARTERS

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A small step for Palbit, a big step for productivity

Cofinanciado por:

