

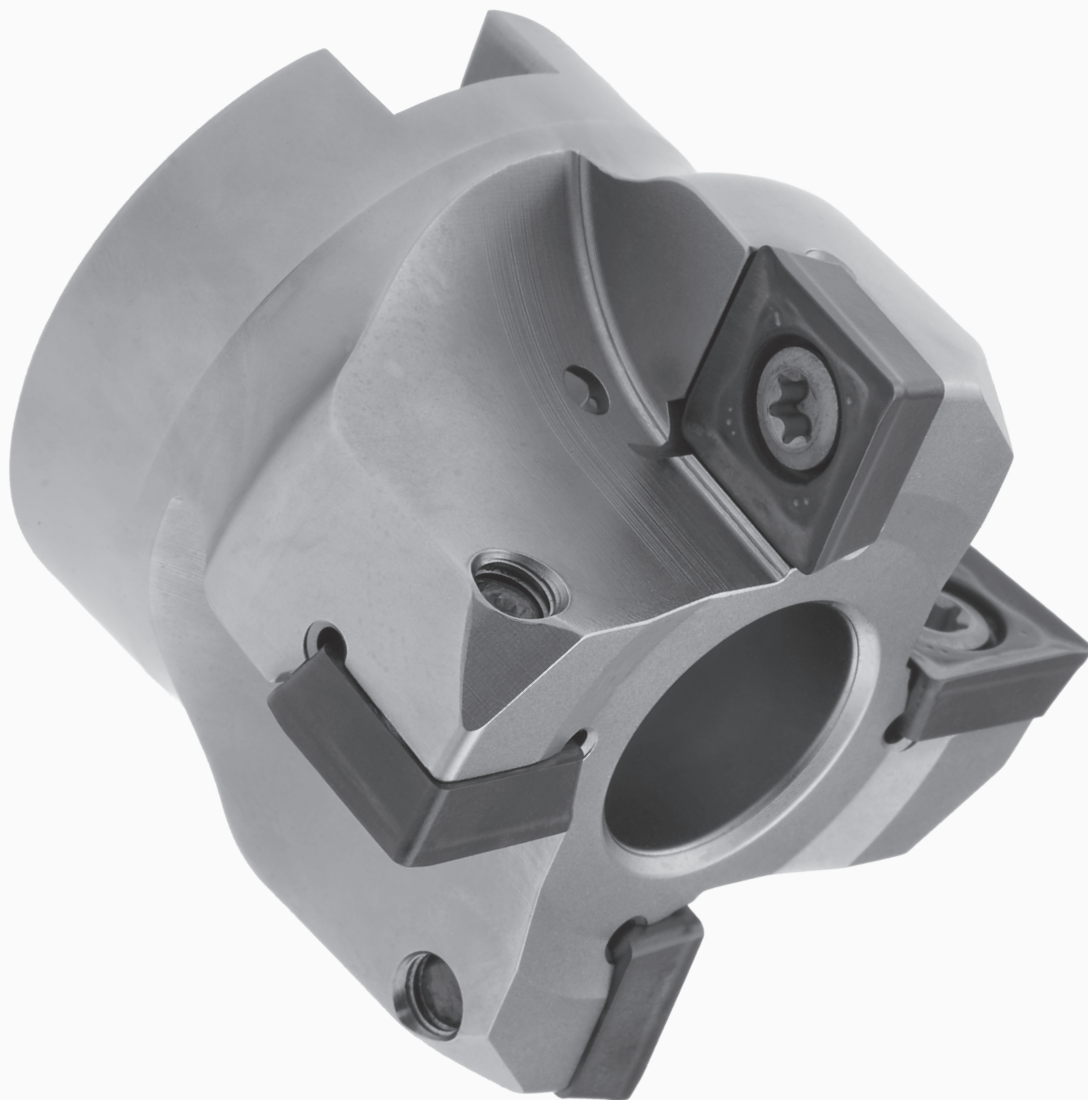
06290

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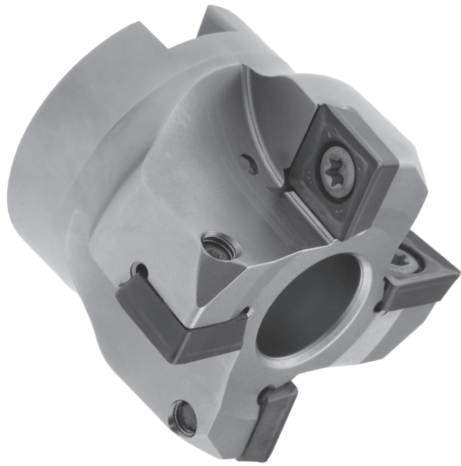
Positive square shoulder milling line

MILLING

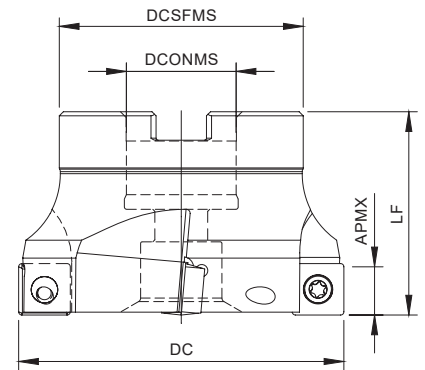
Shouldering | Facing



LINEPRO 06290



Arbor Mounting
KAPR=90° | GAMP=+6°



Order code Código	Reference Referência Referencia	CICT	Dimensions Dimensões Dimensiones (mm)				WT	Specifications		Insert Pastilha Inserto	Stock
			DC	DCONMS	DCSFMS	LF		Arbor Type	APMX (mm)		
181167700	040A06290-03-06-016040	3	40	16	39	40	0,2	A	11	SP...1204	☺
181167800	050A06290-04-06-022040	4	50	22	49	40	0,35	A	11	SP...1204	☺
181167900	063A06290-05-06-027050	5	63	27	60	50	0,7	A	11	SP...1204	☺
181168000	080A06290-06-06-027050	6	80	27	60	50	1,15	A	11	SP...1204	☺
181168100	100A06290-08-06-032050	8	100	32	80	50	1,75	A	11	SP...1204	☺
181168200	125A06290-08-06-040063	8	125	40	96	63	3,05	B	11	SP...1204	☺
181065600	160A06290-10-06-U040063	10	160	40	100	63	4,2	C	11	SP...1204	☺

☺ Stock item | Produto de stock | Itens de stock

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

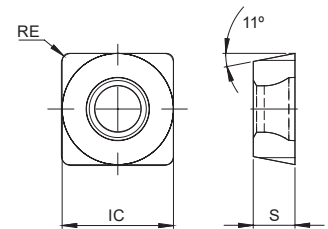
SP.. 1204... Inserts | Pastilhas | Plaquitás



SPG(M)X-MP



SPG(M)X-MS



SPG(M)X-MP | MS

		P	M	K	S	Dimensions Dimensões Dimensiones (mm)		
		PVD	PVD	PVD	PVD	IC	S	RE
(2) Grade code		T1	X9	T1	X9			
(1) Geometry code	ISO Reference	PHP920	PHH930	PHP920	PHH930			
1113002	SPGX 120408 PDSR-MP	☺		☺		12,70	4,76	0,80
1113003	SPGX 120408 PDSR-MS		☺		☺	12,70	4,76	0,80
1112916	SPMX 120408 PDSR-MP	☺		☺		12,70	4,76	0,80
1112999	SPMX 120408 PDSR-MS		☺		☺	12,70	4,76	0,80

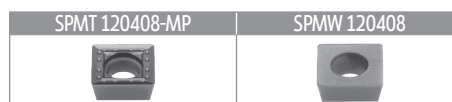
☺ First choice | Primeira opção | 1ª opción

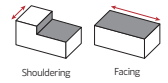
☺ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta
Disponible bajo consulta

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

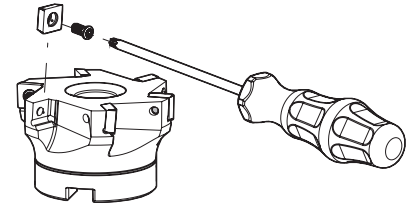
Note: It is possible to use other inserts





SPARE PARTS Acessórios | Repuestos

Cutter DC	Insert Screw	Key (Torx)	Order separately		Order separately	
			Key (Torx - Nm)	Torque Value	Screw	DIN 6368 Wrench
A06290 - 40 - 160	P0501100	PT20	DT2050	5,00	J0204610	SD6368-20



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

ISO	PSM	Material	HB (Brinell)	Grades	
				← Wear Resistance	Toughness →
				PHP920	PHH930
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)		Feed fz (mm/t)	
				← Wear Resistance	Toughness →		
				PHP920	PHH930	SPG(M)X...MP	SPM(M)X...MS
P	1	Unalloyed Steel	125-220	180-250	-	0,08-0,20	-
	2	Low-Alloyed Steel	220-280	170-210	-	0,08-0,20	-
	3	High-Alloyed Steel	280-380	160-200	-	0,08-0,20	-
M	4	SS - Ferritic / Martensitic	200-330	-	120-180	-	0,08-0,20
	5	SS - Austenitic	200-330	-	100-160	-	0,08-0,20
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	70-140	-	0,08-0,20
K	7	Malleable Cast Iron	130-230	170-300	-	0,10-0,30	-
	8	Grey Cast Iron	180-245	150-250	-	0,10-0,30	-
	9	Nodular Cast iron	160-250	90-210	-	0,10-0,30	-
S	11	Heat Resistant Super Alloys	200-320	-	30-75	-	0,08-0,15

(Note 1) Cutting conditions ae/DC=70%

(Note 2) Cutting conditions should be adjusted according to the machine and work rigidity.

(Note 3) If chattering occurs, reduce ap and Vc by 30% and keep the same fz per tooth.

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
P	1	Unalloyed Steel	125-220	... MP
	2	Low-Alloyed Steel	220-280	... MP
	3	High-Alloyed Steel	280-380	... MP
M	4	SS - Ferritic / Martensitic	200-330	... MS
	5	SS - Austenitic	200-330	... MS
	6	SS - Austenitic-ferritic (Duplex)	230-260	... MS
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	... MS

06290

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Positive square shoulder milling line



Check the QrCode for more information



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