

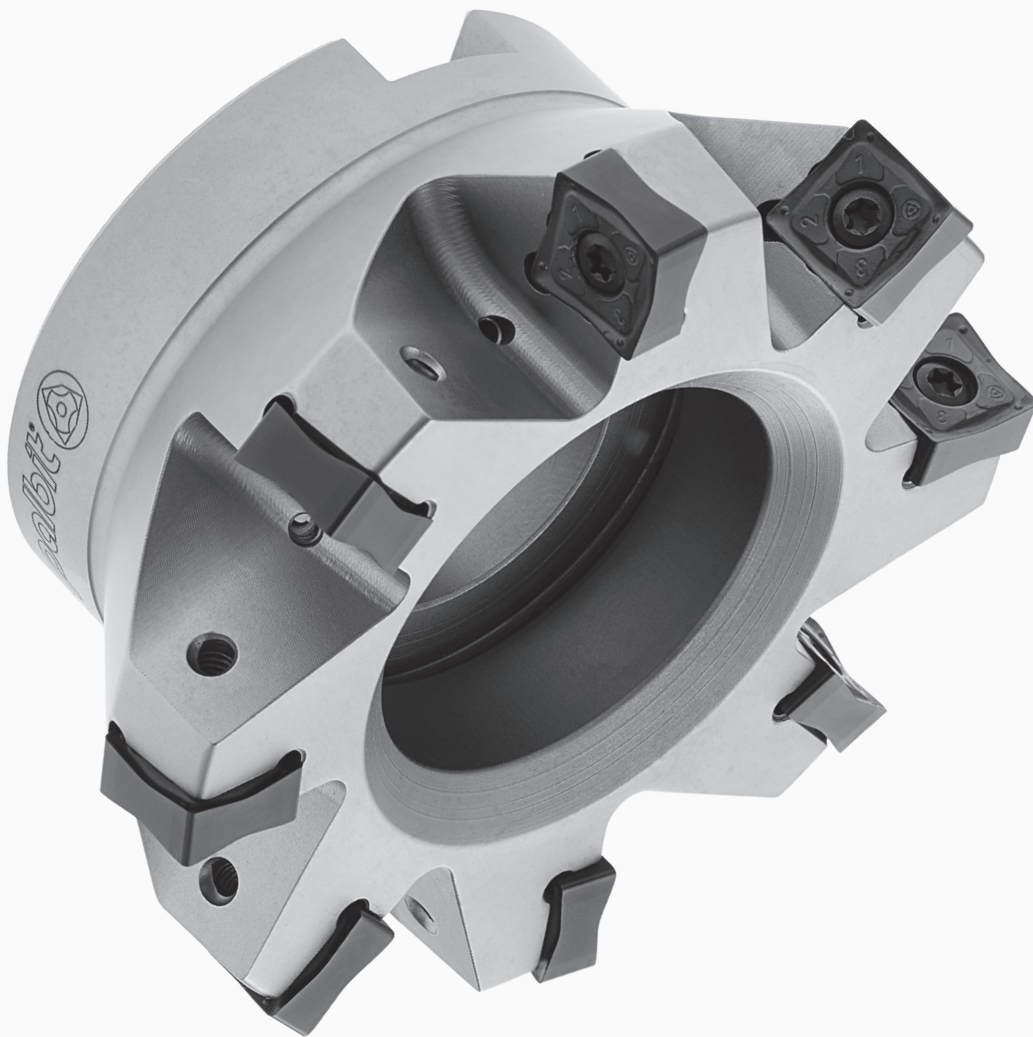
28088

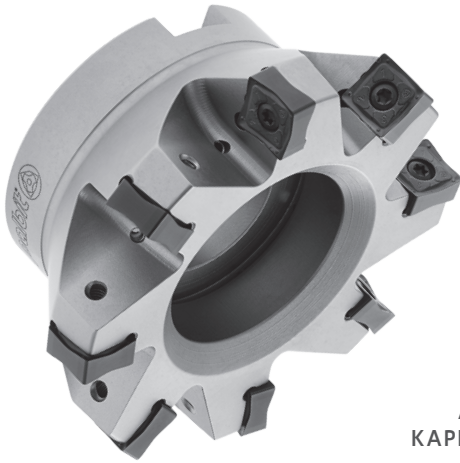
# PLUS

Solution for face milling with 88° lead angle

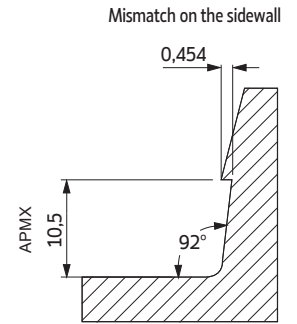
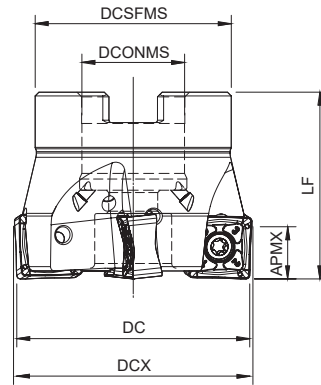
**MILLING**

Facing | Shouldering





**Arbor Mounting**  
KAPR=88° | GAMP=-6°



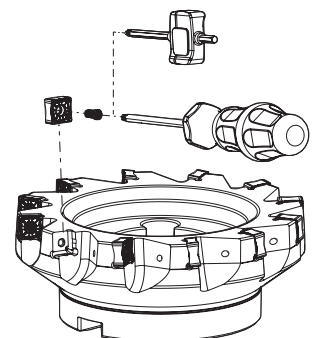
Order code Código	Reference Referência Referencia	CICT	Dimensions   Dimensões   Dimensiones (mm)					WT	Specifications		Insert Pastilha Inserto	Stock
			DC	DCX	DCONMS	DCSFMS	LF		Arbor Type	APMX (mm)		
181084300	050A28088-05-06-022040	5	50	50,9	22	42	40	0,4	A	10,5	SN... 1206...	☺
181091600	063A28088-06-06-022040	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...	☺

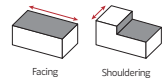
☺ Stock item | Produto de stock | Itens de stock

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

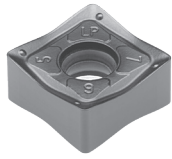
## SPARE PARTS Accessórios | Repuestos

Cutter DC	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	-	-

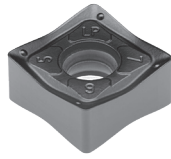




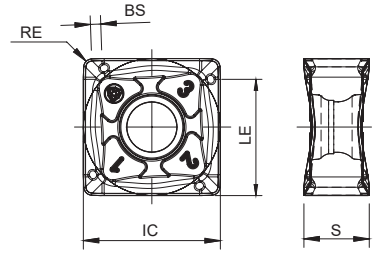
**SNH(K)U 1206** Inserts | Pastilhas | Plaquetas



SNHU-LP



SNKU-LP



(1) Geometry code	(2) Grade code	P					M		K								Dimensions Dimensões Dimensiones (mm)									
		CVD		PVD			PVD		CVD				PVD													
		T9	G4	T1	P3	G6	P3	G6	L5	L6	L9	T9	G4	T1	P3	G6	IC	S	LE	RE	BS					
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 opção
⊗ Stock item | Produto de stock | Itens de stock
○ Available under request | Disponível sobre consulta
Disponível 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	PH5320	PHP920	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)								Feed fz (mm/t)
				← Wear Resistance				Toughness →				
				PH5705	PH5320	PHP920	PH7920	PH7930	PH5740	PHS740	PH7740	
P	1	Unalloyed Steel	125-220	-	-	180-250	180-240	160-220	-	140-220	140-200	0,10 (0,25) 0,35
	2	Low-Alloyed Steel	220-280	-	-	160-230	160-220	140-200	-	120-200	130-180	0,10 (0,25) 0,35
	3	High-Alloyed Steel	280-380	-	-	140-220	140-210	120-190	-	100-190	100-170	0,10 (0,25) 0,35
M	4	SS - Ferritic / Martensitic	200-330	-	-	-	-	140-200	-	-	130-180	0,10 (0,25) 0,35
	5	SS - Austenitic	200-330	-	-	-	-	120-160	-	-	110-160	0,10 (0,25) 0,35
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	-	-	100-140	-	-	90-150	0,10 (0,25) 0,35
K	7	Malleable Cast Iron	130-230	160-290	150-280	160-270	160-260	150-240	160-260	-	140-220	0,10 (0,25) 0,35
	8	Grey Cast Iron	180-245	170-320	160-320	140-250	140-240	140-230	140-240	-	120-210	0,10 (0,25) 0,35
	9	Nodular Cast iron	160-250	140-200	100-190	120-210	120-200	100-190	120-200	-	100-190	0,10 (0,25) 0,35

28088

# PLUS

**Solution for face milling** with 88° lead angle



Check the QrCode for more information



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