

49090

PLUS

Double-sided shoulder milling insert

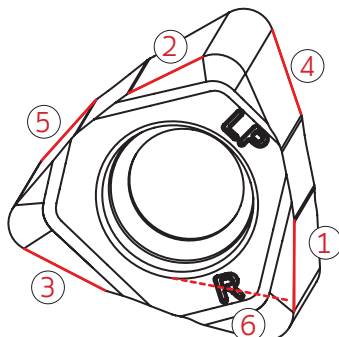
MILLING

Shouldering | Facing



PLUS 49090 is a new milling line with a negative insert of 6 cutting edges.

6 cutting edges



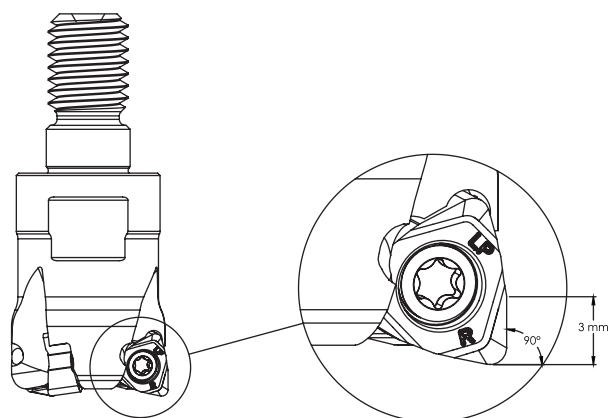
Features

- 6-cornered design for economic advantage
- Fully effective cutting edge length in square shoulder milling
- Low cutting force even in large depth of cut
- Machining depth of cut up to 3mm
- Plus 49090 is well suited for small and medium sized milling machines

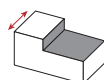
The 90° setting angle ensures a true 90° square in one operation, saving valuable production time.

Benefits

- True 90 degrees
- High productivity
- Lower cost per edge
- High quality surface finish



Main operations

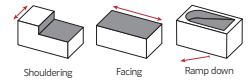


Shouldering

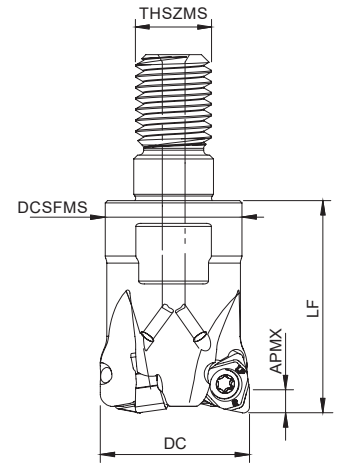
Working materials



HEXAPLUS 49090
WNHU 04



Threaded Coupling
KAPR=90° | GAMP=-7°



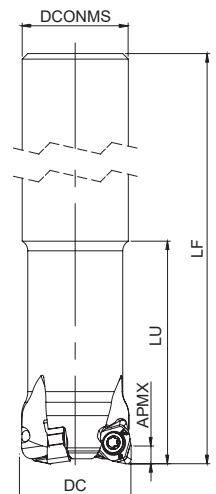
Order code Código	Reference Referência Referencia	CICT	Dimensions Dimensões Dimensiones (mm)				WT	Specification	Insert Pastilha Inserto	Stock
			DC	THSZMS	DCSFMS	LF		APMX (mm)		
181136000	016R49090-02-07-M08023	2	16	M08	13	23	0,023	3,00	WNHU 04T3..	☉
181128300	020R49090-03-07-M10028	3	20	M10	18	28	0,052	3,00	WNHU 04T3..	☉
181110900	025R49090-04-07-M12030	4	25	M12	21	30	0,078	3,00	WNHU 04T3..	☉
181128400	032R49090-05-07-M16035	5	32	M16	29	35	0,150	3,00	WNHU 04T3..	☉

☉ Stock item | Produto de stock | Itens de stock

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



Cylindrical Shank
KAPR=90° | GAMP=-7°



Order code Código	Reference Referência Referencia	CICT	Dimensions Dimensões Dimensiones (mm)				WT	Specification	Insert Pastilha Inserto	Stock
			DC	DCONMS	LF	LU		APMX (mm)		
181136100	016E49090-02-07-U015150	2	16	15	150	32	0,185	3,00	WNHU 04T3..	☉
181136200	020E49090-03-07-U019150	3	20	19	150	40	0,292	3,00	WNHU 04T3..	☉
181136300	025E49090-04-07-U024150	4	25	24	150	50	0,471	3,00	WNHU 04T3..	☉

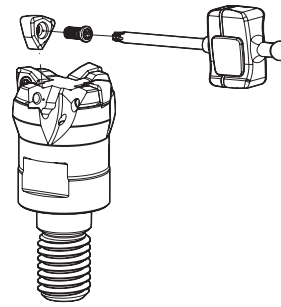
☉ Stock item | Produto de stock | Itens de stock

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

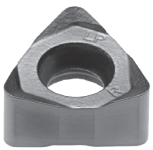
PLUS 49090

SPARE PARTS Acessórios | Repuestos

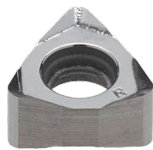
Cutter DC	Insert Screw	Key (Torx)	Order separately	
			Key (Torx - Nm)	Torque Value
R49090 - 20-32	P0250704	XT08	DT0812	1,2
E49090 - 16-25	P0250704	XT08	DT0812	1,2



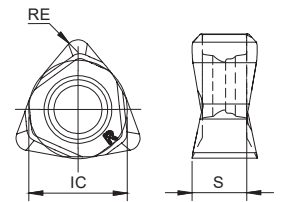
WNHU 04T3.. Inserts | Pastilhas | Plaquitass



WNHU-LP



WNHU-LN



WNHU-LP | LN

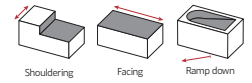
Geometry code	ISO Reference	P			K			N	Dimensões Dimensões Dimensiones (mm)		
		PVD			PVD			UNC	IC	S	RE
		X5	T1	P4	X5	T1	P4	10			
1112277	WNHU 04T308 PNER-LP	☉	☹	☉	☉	☹	☉		6,35	3,50	0,80
1113167	WNHU 04T316 PNER-LP		☹			☹			6,35	3,40	1,60
1112988	WNHU 04T308 PNFR-LN						☹		6,35	3,50	0,80

☉ First choice | Primeira opção | 1ª opción

☼ 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 →	
				PH0910	PHP910	PHP920	PHP930
P	1	Unalloyed Steel	125-220	○	○	○	○
	2	Low-Alloyed Steel	220-280		○	○	○
	3	High-Alloyed Steel	280-380		○	○	○
K	7	Malleable Cast Iron	130-230		○	○	○
	8	Grey Cast Iron	180-245		○	○	○
	9	Nodular Cast iron	160-250		○	○	○
N	10	Aluminium and Non Ferrous	30-130	✓			

○ 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 →		WNHU 04T3..-LP	WNHU 04T3..-LN
				PH0910	PHP910	PHP920	PHP930		
P	1	Unalloyed Steel	125-220	-	180-250	180-250	160-230	0,10-0,30	-
	2	Low-Alloyed Steel	220-280	-	160-240	160-230	140-210	0,10-0,30	-
	3	High-Alloyed Steel	280-380	-	140-230	140-220	120-200	0,10-0,25	-
K	7	Malleable Cast Iron	130-230	-	180-300	160-270	150-250	0,10-0,30	-
	8	Grey Cast Iron	180-245	-	160-250	140-250	140-230	0,10-0,30	-
	9	Nodular Cast iron	160-250	-	150-210	120-210	100-200	0,10-0,25	-
N	10	Aluminium and Non Ferrous	30-130	100-2000	-	-	-	-	0,10-0,30

Insert	Feed fz (mm/t)		AP Rec.
	Roughing	Finishing	
WNHU 04T3..	0,15-0,30	0,10-0,25	0,50-3,00

49090

PLUS

Double-sided shoulder milling insert



Check the QrCode for more information



HEADQUARTERS

PALBIT. S.A.

T (+351) 234 540 300 | F (+351) 234 540 301

palbit@palbit.pt | www.palbit.pt

Branch office

PALBIT México, S de RL de CV

T (+52) 5555 454 543 | F (+52) 5552 509 190

info@palbit.com.mx | www.palbit.pt/mx

Branch office

PALBIT Brasil

T (+55) 011 25 343 648

palbit@palbit.com.br | www.palbit.pt/br