

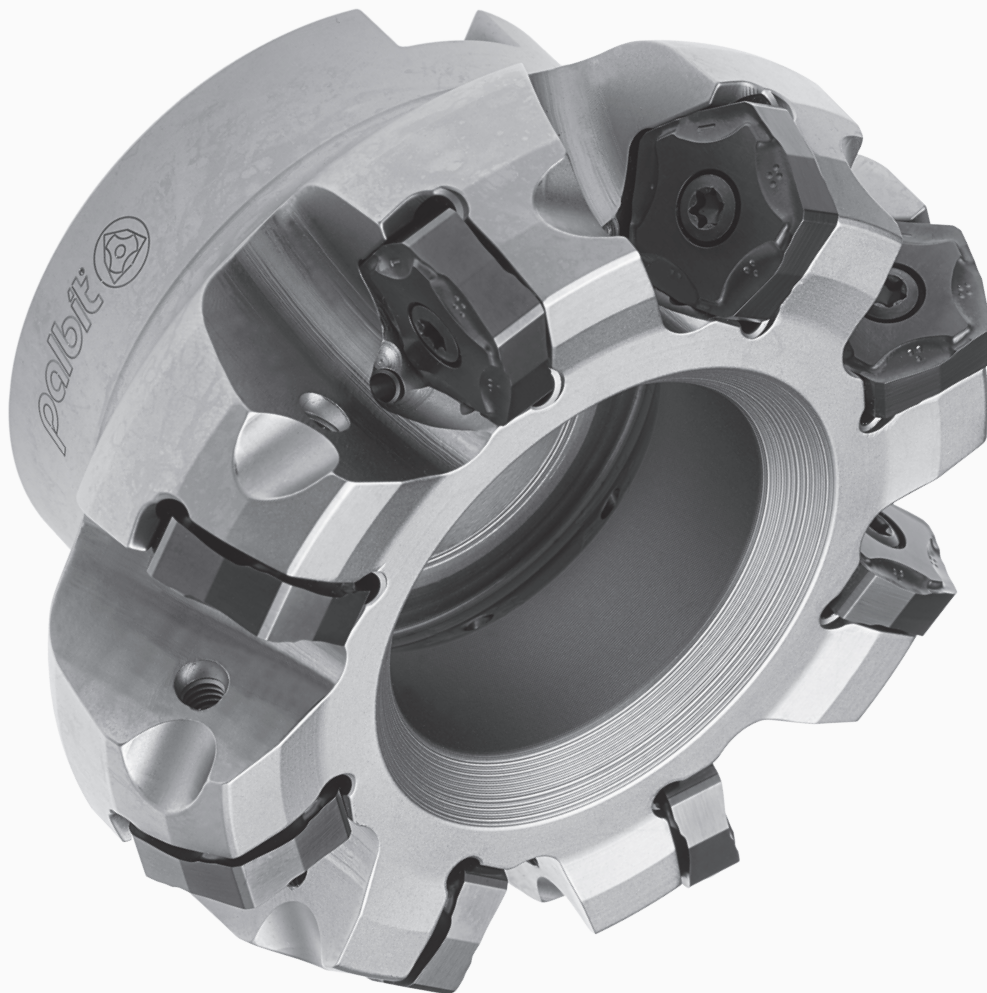
90260

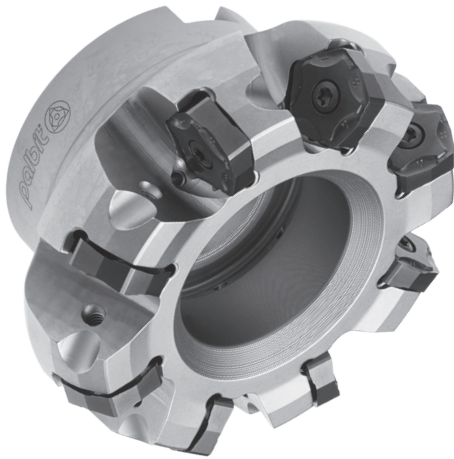
PLUS

Optimized performance on cast irons and forged steels

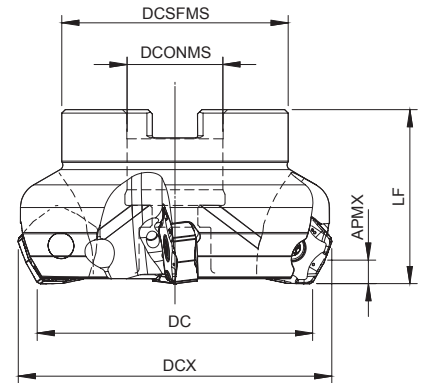
MILLING

Facing





Arbor Mounting
KAPR=60° | GAMP=-7°



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)		
181050200	050A90260-05-07-022040	5	50	59,05	22	48	40	0,388	A	5,0	PN... 1105...	☼
181050300	063A90260-06-07-022040	6	63	72,05	22	52	40	0,597	A	5,0	PN... 1105...	☼
181050400	080A90260-08-07-027050	8	80	89,05	27	60	50	1,072	B	5,0	PN... 1105...	☼
181045900	100A90260-10-07-032050	10	100	109,05	32	80	50	1,745	B	5,0	PN... 1105...	☼
181050500	125A90260-12-07-040063	12	125	134,05	40	90	63	3,047	B	5,0	PN... 1105...	☼
181050600	160A90260-14-07-U040063	14	160	169,05	40	110	63	4,397	C	5,0	PN... 1105...	☼

☼ Stock item | Produto de stock | Itens de stock

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

PNH(K)X 1105 Inserts | Pastilhas | Plaquetas



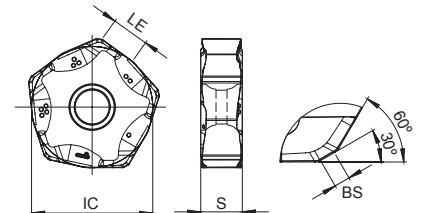
PNHX-MK



PNHX-HK



PNKX-MK



	⁽²⁾ Grade code	P		K				Dimensions Dimensões Dimensiones (mm)				
		PVD		CVD		PVD						
		G1	G4	L5	L9	G1	G4	IC	S	LE	RE	BS
⁽¹⁾ Geometry code	ISO Reference	PH7910	PH7920	PH5705	PH5740	PH7910	PH7920					
1111374	PNHX 1105 ZNER-MK	☼	☼	☼	☼	☼	☼	16,50	5,66	5,70	-	1,30
1111998	PNHX 1105 ZNER-HK			☼	○			16,50	5,66	5,70	-	1,30
1112294	PNKX 1105 ZNER-MK	☼	☼	☼	○	☼	☼	16,50	5,66	5,70	-	1,30

☼ First choice | Primeira opção | 1ª opción

☼ Stock item | Produto de stock | Itens de stock

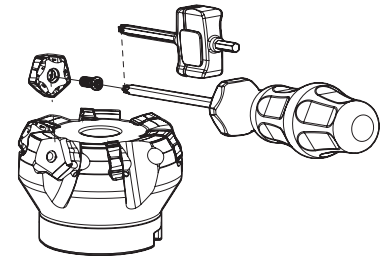
○ Available under request | Disponível sobre consulta
Disponible bajo consulta

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



SPARE PARTS Accesórios | Repuestos

Cutter DC	Insert Screw	Key (Torx)	Order separately		Order separately	
			Key (Torx - Nm)	Torque Value	Screw	DIN 6368 Wrench
A90260 – 50 - 63	P0401200	XT15	DT1530	3,0	-	-
A90260 – 80	P0401200	XT15	DT1530	3,0	J0123510	SD6368-12
A90260 – 100	P0401200	PT15	DT1530	3,0	J0164110	SD6368-16
A90260 – 125	P0401200	PT15	DT1530	3,0	J0204610	SD6368-20
A90260 – 160	P0401200	PT15	DT1530	3,0	-	-



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

ISO	PSM	Material	HB (brinell)	Grades				
				← Wear Resistance			Toughness →	
				PH5705	PH7910	PH7920	PH5740	PH7740
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	✓	✓	✓	✓	

● 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	PH7910	PH7920	PH5740	
P	1	Unalloyed Steel	125-220	-	180-250	180-240	-	0,15-0,30
	2	Low-Alloyed Steel	220-280	-	160-230	160-220	-	0,15-0,30
	3	High-Alloyed Steel	280-380	-	140-220	140-210	-	0,15-0,25
K	7	Malleable Cast Iron	130-230	160-290	180-300	160-260	160-260	0,12-0,35
	8	Grey Cast Iron	180-245	170-320	160-250	140-240	140-240	0,12-0,35
	9	Nodular Cast iron	160-250	140-200	150-200	120-200	120-200	0,12-0,30

CHIP BREAKER SELECTION GUIDE Guia para aplicações do quebra-aperas | Guía para aplicación del rompevirutas

ISO	PSM	Material	HB (Brinell)	Chip breaker application	
				1st choice	Difficult Operations
				P	1
2	Low-Alloyed Steel	220-280	PNH(K)X 11... MK		-
3	High-Alloyed Steel	280-380	PNH(K)X 11... MK		-
K	7	Malleable Cast Iron	130-230	PNH(K)X 11... MK	PNH(K)X 11... HK
	8	Grey Cast Iron	180-245	PNH(K)X 11... MK	PNH(K)X 11... HK
	9	Nodular Cast iron	160-250	PNH(K)X 11... MK	PNH(K)X 11... HK

90260

PLUS

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Check the QrCode for more information



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