

The best solution for High productivity milling



Facing



Slanted Shoulder
& Chamfer



PLUS
90945



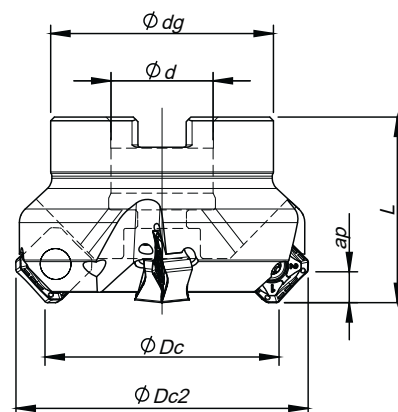
INSERT SIZE
12 SN...
1206



100
YEARS
SINCE 1916



Arbor Mounting
 $\kappa_r = 45^\circ$ | $\gamma_p = -6^\circ$



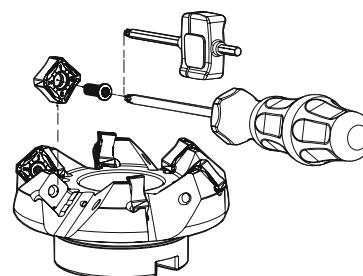
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)					 Kg	Specifications		Insert Pastilha Inserto	Stock	
			ϕDc	$\phi Dc2$	ϕd	ϕdg	L		Arbor Type	A_p max (mm)			
181048200	050A90945-04-06-022040		4	50	63	22	48	40	0,424	A	6,0	SN... 1206	
181067000	050A90945-06-06-022040		6	50	63	22	48	40	0,415	A	6,0	SN... 1206	
181048300	063A90945-06-06-022040		6	63	76	22	52	40	0,575	A	6,0	SN... 1206	
181067100	063A90945-08-06-022040		8	63	76	22	52	40	0,577	A	6,0	SN... 1206	
181048400	080A90945-07-06-027050		7	80	93	27	60	50	0,966	B	6,0	SN... 1206	
181067200	080A90945-10-06-027050		10	80	93	27	60	50	0,950	B	6,0	SN... 1206	
181048500	100A90945-08-06-032050		8	100	113	32	80	50	1,667	B	6,0	SN... 1206	
181067300	100A90945-12-06-032050		12	100	113	32	80	50	1,650	B	6,0	SN... 1206	
181048600	125A90945-10-06-040063		10	125	138	40	90	63	2,890	B	6,0	SN... 1206	
181048700	160A90945-12-06-U040063		12	160	173	40	110	63	4,360	C	6,0	SN... 1206	
181052800	200A90945-14-06-U060063		14	200	213	60	172	63	8,890	C	6,0	SN... 1206	
181064700	250A90945-16-06-U060063		16	250	263	60	172	63	11,490	C	6,0	SN... 1206	

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

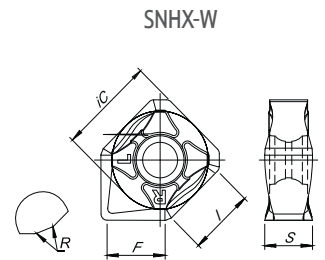
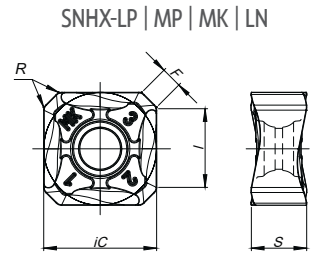
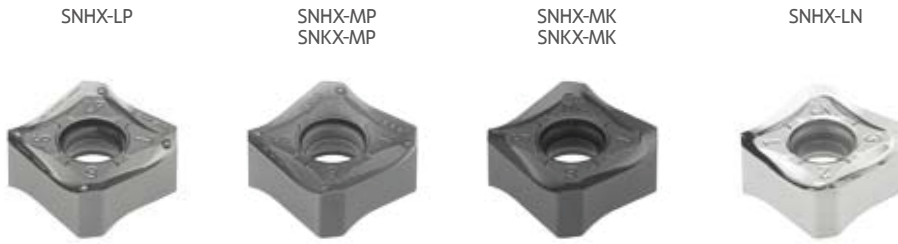
SPARE PARTS || Complementos | Complementos

Cutter ϕDc	Insert Screw	Key (Torx)	Torque Value	Screw	DIN 6368 Wrench
A90945 - 50 - 63	P0401200	XT15	3,0	-	-
A90945 - 80	P0401200	XT15	3,0	J0123510	SD6368-12
A90945 - 100	P0401200	PT15	3,0	J0164110	SD6368-16
A90945 - 125	P0401200	PT15	3,0	J0204610	SD6368-20
A90945 - 160 - 250	P0401200	PT15	3,0	-	-





SNH(K)X 1206 | Inserts | Pastilhas | Plaquetas



		P						M				K			N		S		H	Dimensions (mm)							
		PVD						CVD	PVD			CVD			PVD	UNC	PCD	PVD	PVD								
		P7	G1	G4	P3	G6		R1	G4	P3	G6	L5	L6	L9	G1	G4	P3	10	D6						P3	G6	P7
(1) Geometry code	(2) Grade code	PH7603	PH7910	PH7920	PH7930	PH7740	PHM740	PH7920	PH7930	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7930	PH0910	PDP410	PH7930	PH7740	PH7603	iC	S	I	R	F	
NEW	1112293	SNKX 1206 ANSN-MP			⊗		⊗																12,70	6,35	9,30	0,80	2,00
NEW	1112249	SNKX 1206 ANEN-MK									⊗	⊗	⊗										12,70	6,35	9,30	0,80	2,00
	1111452	SNHX 1206 ANEN-LP			⊗	⊗				⊗							⊗	⊗			⊗		12,70	6,35	9,30	0,80	2,00
	1111502	SNHX 1206 ANSN-MP		⊗	⊗	⊗																	12,70	6,35	9,30	0,80	2,00
	1111503	SNHX 1206 ANEN-MK									⊗		⊗	⊗	⊗								12,70	6,35	9,30	0,80	2,00
	1111504	SNHX 1206 ANFN-LN															⊗						12,70	6,35	9,30	0,80	2,00
	1111899	SNHX 1206 ANFN-W*		⊗	⊗																		12,70	6,30	9,30	0,40	7,60

⊗ 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

* Wiper insert with 2 rights and 2 left-hand cutting edges.

RECOMMENDED CUTTING CONDITIONS

ISO	PSM	Material	HB (Brinell)	Vc (m/min)			
				← Wear Resistance		Toughness →	
				PH0910	PH5705	PH7910	PH7920
P	1	Unalloyed Steel	125-220	-	-	190-280	180-250
	2	Low-Alloyed Steel	220-280	-	-	180-240	170-210
	3	High-Alloyed Steel	280-380	-	-	170-220	160-200
M	4	SS - Ferritic / Martensitic	200-330	-	-	-	-
	5	SS - Austenitic / Duplex	200-330	-	-	-	-
	6	SS - Duplex	230-260	-	-	-	-
K	7	Malleable Cast Iron	130-230	-	190-340	180-320	170-300
	8	Grey Cast Iron	180-245	-	180-300	170-280	150-250
	9	Nodular Cast iron	160-250	-	140-250	100-240	90-210
N	10	Alluminium and Non Ferrous	30-130	350-1200	-	-	-
S	11	Heat Resistant Super Alloys	200-320	-	-	-	-

(Note 1) Cutting conditions $a_e/D_c=70\%$.

(Note 2) It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:

- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

(Note 3) PH5... can be used wet or dry. PH7... use only air.

GRADES SELECTION GUIDE

ISO	PSM	Material	HB (Brinell)	Grades						
				← Wear Resistance				Toughness →		
				PH0910	PH5705	PH7910	PH7920	PH7930	PH5740	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 / Duplex	200-330					●		
	6	SS - Duplex	230-260					●		
K	7	Malleable Cast Iron	130-230		●		●		●	
	8	Grey Cast Iron	180-245		●		●		●	
	9	Nodular Cast iron	160-250		●		●		●	
N	10	Alluminium and Non Ferrous	30-130	●						
S	11	Heat Resistant Super Alloys	200-320					●		

● Good Conditions

● Average Conditions

● Difficult Conditions

CHIP-BREAKER SELECTION GUIDE

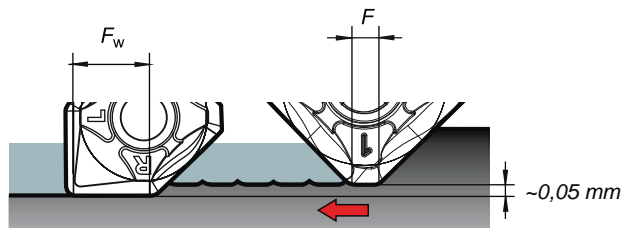
ISO	PSM	Material	HB (Brinell)	Chip-Breaker Application	
				1st choice	Difficult Operations
P	1	Unalloyed Steel	125-220	SNHX 12... LP	SNH(K)X 12... MP
	2	Low-Alloyed Steel	220-280	SNHX 12... LP	SNH(K)X 12... MP
	3	High-Alloyed Steel	280-380	SNH(K)X 12... MP	-
M	4	SS - Ferritic / Martensitic	200-330	SNHX 12... LP	-
	5	SS - Austenitic / Duplex	200-330	SNHX 12... LP	-
	6	SS - Duplex	230-260	SNHX 12... LP	-
K	7	Malleable Cast Iron	130-230	SNH(K)X 12... MK	-
	8	Grey Cast Iron	180-245	SNH(K)X 12... MK	-
	9	Nodular Cast iron	160-250	SNH(K)X 12... MK	-
N	10	Alluminium and Non Ferrous	30-130	SNHX 12... LN	-
S	11	Heat Resistant Super Alloys	200-320	SNHX 12... LP	-

Vc (m/min)			Feed fz (mm/t)				
← Wear Resistance		Toughness →					
PH7930	PH5740	PH7740	SNHX 12... LP	SNH(K)X 12... MP	SNH(K)X 12... MK	SNHX 12... LN	SNHX 12... W
160-220	-	140-170	0,10-0,35	0,10-0,35	-	-	0,10-0,35
150-180	-	130-160	0,10-0,35	0,10-0,35	-	-	0,10-0,35
130-160	-	110-140	0,10-0,30	0,10-0,30	-	-	0,10-0,30
120-180	-	-	0,10-0,30	-	-	-	-
100-160	-	-	0,10-0,30	-	-	-	-
70-140	-	-	0,10-0,25	-	-	-	-
160-280	170-300	130-250	0,10-0,35	-	0,10-0,35	-	0,10-0,40
140-240	150-260	110-220	0,10-0,35	-	0,10-0,35	-	0,10-0,40
90-200	130-220	80-170	0,10-0,30	-	0,10-0,30	-	0,10-0,40
-	-	-	-	-	-	0,10-0,35	-
30-75	-	-	0,07-0,20	-	-	-	-

WIPER INSERTS

Rec. Cutting Conditions

- F_w at least 40% larger than $f_n (f_n - f_2 \times Z)$;
- Axial depth of cut 0,5 - 0,8mm.



Example:

- The width of the parallel land (F) of the insert is 2,0mm
- Width a cutter of 10 inserts and using a feed per tooth (f_z) of 0,3mm, i.e. 33% bigger than the parallel land.
- To obtain a good surface finish, the feed per revolution should be a maximum of 80% of 2mm = 1,6mm.
- Then wiper insert will have a parallel land (F_w) with a width of approximately 7,6mm.
- Result: Feed per revolution (f_n) could be increased from 1,6mm to 60% of 7,6mm = 4,56mm.

Note: Other limitations, such a machine power, must be taken into consideration.

How to use a wiper insert

- Since wiper is one corner use to standard cutters, please attach the insert with the parallel land down to the workspace cutting surface.

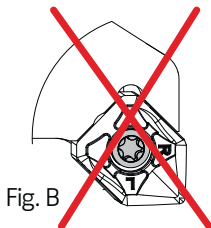
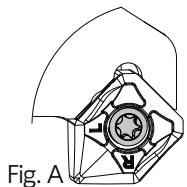
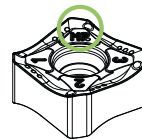


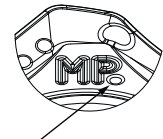
Fig. A

Fig. B

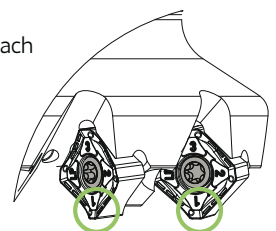
When using wiper insert, install the insert as shown on Fig. A if the insert is installed as shown on Fig. B breakage of the insert is inevitable and normal surface finish can not be obtained.



This point shows the SNKX insert difference to SNHX



Put the same side of insert in each pocket for best radial and axial runout when using SNKX.





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90945

HEADQUARTERS

PALBIT, S.A.

P.O.Box 4 - Palhal

3854-908 - Branca ALB - Portugal

palbit@palbit.pt

www.palbit.pt

Branch office:

Palbit Brasil

Av. João XXIII, nº20. SI 41.42 - Vila Gilda

Stº André. SP. CEP 09190-500 SP Brasil

T (+55) 1125343648 | F (+55) 1125343648

palbit@palbit.com.br | www.palbit.com.br

Branch office:

PALBIT México

Emerson 150. Int.803-804. Colonia Chapultepec

Morales Delagación Miguel Hidalgo

C.P. 11570 México DF

T (+52) 5555454543 | F (+52) 5552509190

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



ZIBTR d.o.o.

Tel.: 01 896 22 80

Fax: 01 896 22 82

Splet: www.zibtr.com

E-pošta: zibtr@siol.net



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