

One Small Step for Palbit/Pilot,  
One Big Step for Productivity

**palbit**<sup>®</sup>  
TOOLING SOLUTIONS EXPERTS  
SINCE 1916

PalbitUSA.com

**PILOT**  
Precision Products

NEW  
PHG GRADE  
Positive inserts (Imperial)

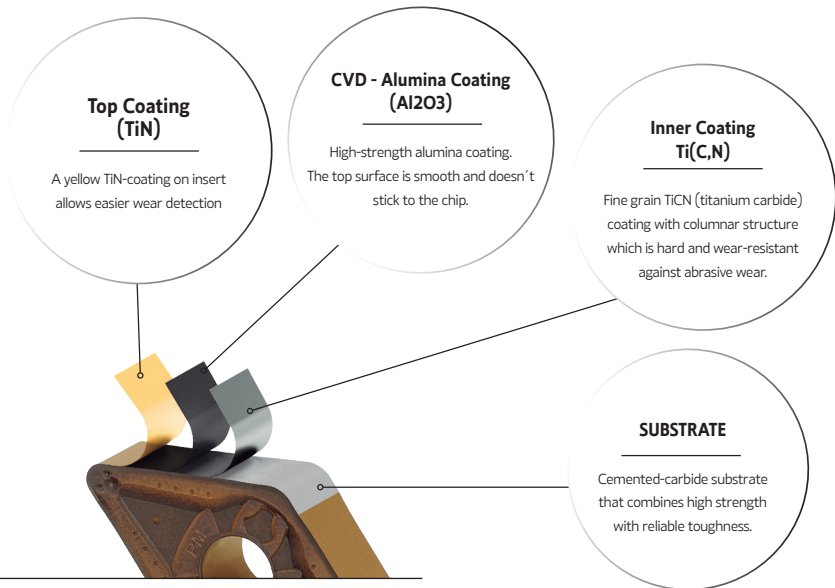
**palbit**<sup>®</sup>  
CUTTING TOOLS SOLUTIONS

**PILOT**  
Precision Products

PHG

NEW  
GRADE

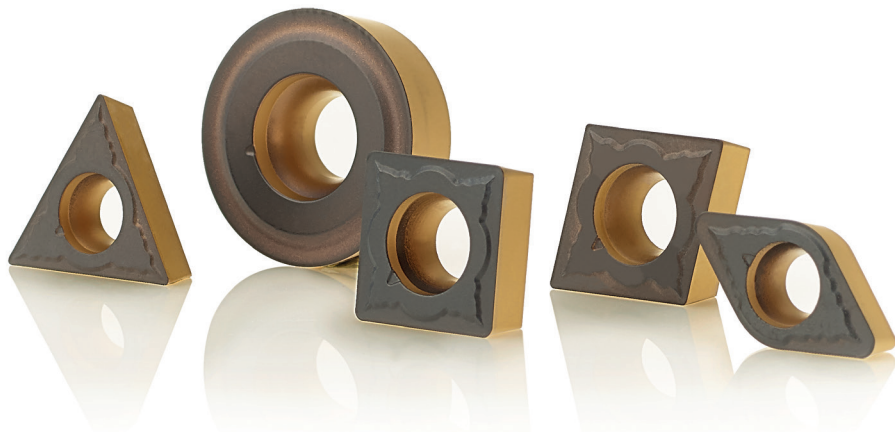
SINCE 1916



## COATING DESCRIPTION

## APPLICATION

- External and internal turning
- Roughing to finishing
- Wet and dry machining



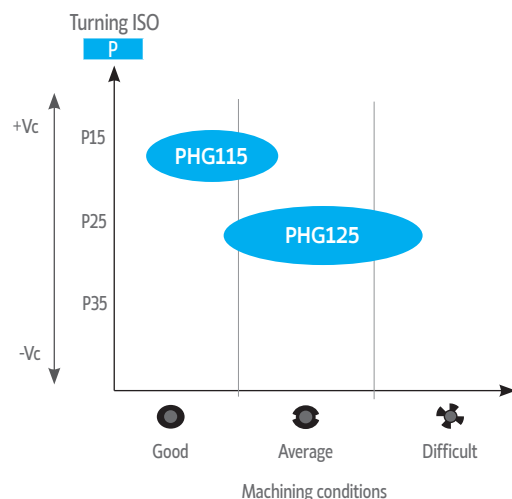
## GRADES' MAIN FEATURES

### PHG115

- Continuous to lightly-interrupted cuts
- High cutting speed
- Enables continuous machining
- Hard workpiece materials


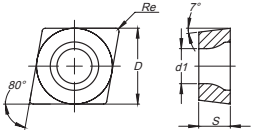
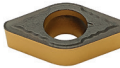
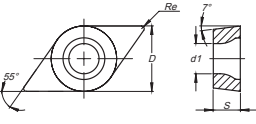
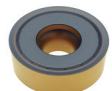
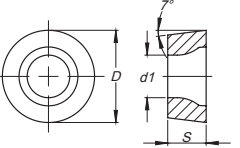

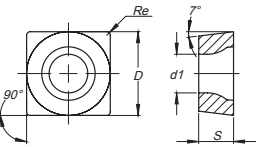
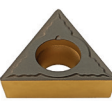
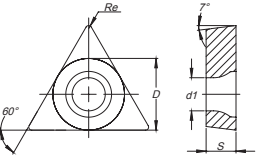
### PHG125

- First choice for the majority of steel turning applications
- Continuous to interrupted cuts



# POSITIVE INSERTS

NEW

Inserts	(1) Geometry code	(2) Grade code ANSI Reference	P		CVD-MT				Dimensions (mm)					Cutting Conditions			Technical Drawing
			R2	R3	D	S	Re	d1	ap (mm)	Min	Max	fn (mm/rev)	Min	Max	Relief angle 7°		
			PHG115	PHG125													
 CCMT-MP  Finishing	1121697	CCMT 21.51-MP	○	⊗	1/4	3/32	1/64	0.110	0.025	0.008	0.094	0.004	0.002	0.007			
	1121661	CCMT 21.52-MP	○	⊗	1/4	3/32	1/32	0.110	0.025	0.016	0.094	0.007	0.003	0.014			
	1121700	CCMT 32.51-MP	⊗	⊗	3/8	5/32	1/64	0.173	0.025	0.010	0.118	0.006	0.003	0.009			
	1121687	CCMT 32.52-MP	⊗	⊗	3/8	5/32	1/32	0.173	0.031	0.020	0.118	0.008	0.004	0.016			
	1121719	CCMT 431-MP	⊗	⊗	1/2	3/16	1/64	0.217	0.038	0.012	0.142	0.007	0.004	0.011			
	1121722	CCMT 432-MP	⊗	⊗	1/2	3/16	1/32	0.217	0.038	0.024	0.142	0.009	0.005	0.018			
1121724	CCMT 433-MP	○	○	1/2	3/16	3/64	0.217	0.038	0.028	0.142	0.014	0.006	0.024				
 DCMT-MP  Finishing	1121681	DCMT 21.51-MP	○	○	1/4	3/32	1/64	0.110	0.024	0.007	0.089	0.004	0.002	0.007			
	1121684	DCMT 21.52-MP	⊗	○	1/4	3/32	1/32	0.110	0.024	0.015	0.089	0.008	0.003	0.014			
	1121648	DCMT 32.51-MP	⊗	⊗	3/8	5/32	1/64	0.173	0.031	0.010	0.118	0.006	0.003	0.009			
	1121706	DCMT 32.52-MP	⊗	⊗	3/8	5/32	1/32	0.173	0.031	0.020	0.118	0.010	0.004	0.016			
1121708	DCMT 32.53-MP	⊗	⊗	3/8	5/32	3/64	0.173	0.031	0.024	0.118	0.014	0.005	0.024				
 RCMT-RF  Roughing to Medium	1123848	RCMT 2507M0-RF	⊗	⊗	0.984	5/16	-	0.283	0.248	0.098	0.394	0.031	0.010	0.098			
	1123856	RCMT 2006M0-RM	⊗	⊗	0.787	1/4	-	0.256	0.157	0.079	0.315	0.018	0.005	0.025			
 SCMT-MP  Finishing	1121762	SCMT 32.51-MP	○	⊗	3/8	5/32	1/64	0.173	0.031	0.010	0.118	0.006	0.003	0.009			
	1121768	SCMT 32.52-MP	○	⊗	3/8	5/32	1/32	0.173	0.031	0.020	0.118	0.010	0.004	0.016			
	1121770	SCMT 431-MP	○	○	1/2	3/16	1/64	0.217	0.038	0.012	0.142	0.007	0.004	0.011			
	1121783	SCMT 432-MP	○	⊗	1/2	3/16	1/32	0.217	0.038	0.024	0.142	0.010	0.005	0.018			
	1121785	SCMT 433-MP	○	○	1/2	3/16	3/64	0.217	0.038	0.028	0.142	0.014	0.006	0.024			
 TCMT-MP  Finishing	1121703	TCMT 1.81.51-MP	○	○	7/32	3/32	1/64	0.098	0.024	0.007	0.089	0.004	0.002	0.007			
	1121812	TCMT 1.81.52-MP	○	○	7/32	3/32	1/32	0.098	0.024	0.015	0.089	0.006	0.003	0.009			
	1121970	TCMT 21.51-MP	⊗	⊗	1/4	3/32	1/64	0.110	0.026	0.008	0.098	0.005	0.002	0.007			
	1121971	TCMT 21.52-MP	⊗	⊗	1/4	3/32	1/32	0.110	0.026	0.017	0.098	0.007	0.004	0.010			
	1121972	TCMT 21.53-MP	○	○	1/4	3/32	3/64	0.110	0.026	0.020	0.098	0.008	0.004	0.016			
	1121820	TCMT 221-MP	○	○	1/4	1/8	1/64	0.110	0.026	0.008	0.098	0.005	0.002	0.007			
	1121827	TCMT 222-MP	⊗	○	1/4	1/8	1/32	0.110	0.026	0.017	0.098	0.008	0.004	0.016			
	1121829	TCMT 223-MP	○	○	1/4	1/8	3/64	0.110	0.026	0.020	0.098	0.012	0.004	0.020			
	1121836	TCMT 32.51-MP	⊗	⊗	3/8	5/32	1/64	0.173	0.031	0.010	0.118	0.006	0.003	0.010			
	1121840	TCMT 32.52-MP	⊗	⊗	3/8	5/32	1/32	0.173	0.031	0.020	0.118	0.009	0.004	0.018			
1121844	TCMT 32.53-MP	⊗	⊗	3/8	5/32	3/64	0.173	0.031	0.024	0.118	0.014	0.005	0.024				
1121849	TCMT 432-MP	○	⊗	1/2	3/16	1/32	0.217	0.038	0.024	0.142	0.010	0.005	0.018				

⊗ First choice

⊗ Stock Items

○ Available Upon Request



PalbitUSA.com



PHG GRADE <sup>NEW</sup>  
Positive inserts (Imperial)

U.S. Partner:



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