

High performance face milling



Facing

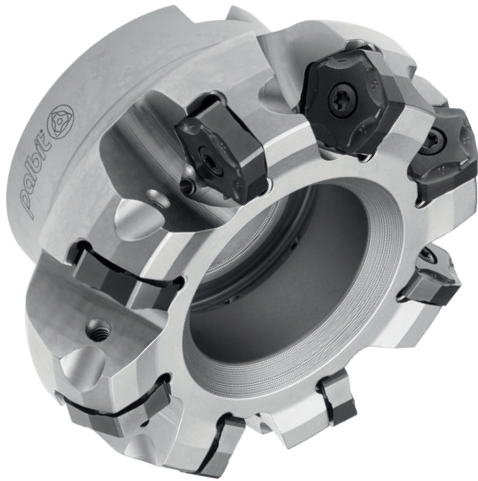
PLUS
PN60-11



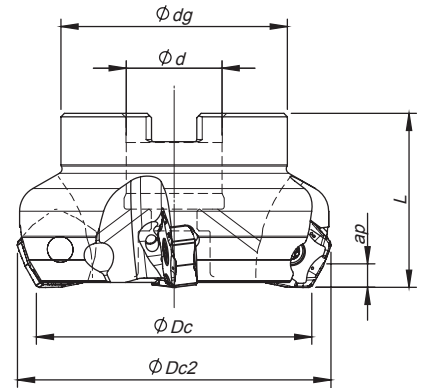
INSERT SIZE
11 PN...
1105



SINCE 1916



Arbor Mounting
 $K_r=60^\circ$ | $\gamma_p -7^\circ$



Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (in)							Specifications		Insert Pastilha Inserto	Stock
			ϕDc	$\phi Dc2$	ϕd	ϕdg	L	Arbor Type		Ap max (in)			
181055700	PN60 D2.00-A.750/1.75-05-11	5	2.000	2.356	0.750	1.772	1.750	0.97	A	0.200	PN... 1105...		
181063800	PN60 D2.50-A1.00/1.75-05-11	5	2.500	2.856	1.000	2.205	1.750	1.60	A	0.200	PN... 1105...		
181055800	PN60 D2.50-A1.00/1.75-06-11	6	2.500	2.856	1.000	2.205	1.750	1.52	A	0.200	PN... 1105...		
181063900	PN60 D3.00-A1.00/2.00-06-11	6	3.000	3.356	1.000	2.205	2.000	2.44	A	0.200	PN... 1105...		
181055900	PN60 D3.00-A1.00/2.00-08-11	8	3.000	3.356	1.000	2.205	2.000	2.27	A	0.200	PN... 1105...		
181064000	PN60 D4.00-A1.25/2.00-07-11	7	4.000	4.356	1.250	2.874	2.000	4.09	A	0.200	PN... 1105...		
181056000	PN60 D4.00-A1.25/2.00-10-11	10	4.000	4.356	1.250	2.874	2.000	4.07	A	0.200	PN... 1105...		
181064100	PN60 D5.00-A1.50/2.50-08-11	8	5.000	5.356	1.500	3.386	2.500	7.33	A	0.200	PN... 1105...		
181056100	PN60 D5.00-A1.50/2.50-12-11	12	5.000	5.356	1.500	3.386	2.500	7.29	A	0.200	PN... 1105...		
181064200	PN60 D6.00-A2.00/2.50U-10-11	10	6.000	6.356	2.000	4.882	2.500	9.35	B	0.200	PN... 1105...		
181056200	PN60 D6.00-A2.00/2.50U-14-11	14	6.000	6.356	2.000	4.882	2.500	9.46	B	0.200	PN... 1105...		
181056300	PN60 D8.00-A2.50/2.50U-16-11	16	8.000	8.356	2.500	5.512	2.500	14.54	C	0.200	PN... 1105...		
181056400	PN60 D10.0-A2.50/2.50U-18-11	18	10.000	10.356	2.500	7.087	2.500	26.29	C	0.200	PN... 1105...		

Stock item | Produto de stock | Itens de stock

Available under request (see page A-10) | Disponível sobre consulta (consulte a página A-10) | Disponible bajo consulta (mire pagina A-10)

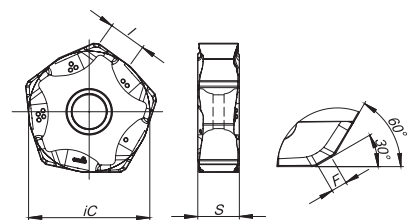
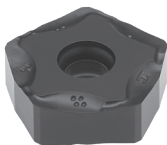
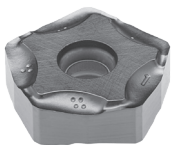
PNH(K)X 1105 | Inserts | Pastilhas | Plaquitás

PNHX-MK

PNHX-HK

PNKX-MK

PNH(K)X-MK | HK



	⁽²⁾ Grade code	P				K					Dimensions Dimensões Dimensiones (in)					
		PVD				CVD		PVD								
		G1	X5	G4	T1	L5	L9	G1	X5	G4	T1	IC	S	I	R	F
⁽¹⁾ Geometry code	ISO Reference	PH7910	PHP910	PH7920	PHP920	PH5705	PH5740	PH7910	PHP910	PH7920	PHP920	IC	S	I	R	F
1111374	PNHX 1105 ZNER-MK											0.650	0.223	0.224	-	0.051
1111998	PNHX 1105 ZNER-HK											0.650	0.223	0.224	-	0.051
1112294	PNKX 1105 ZNER-MK											0.650	0.223	0.224	-	0.051

First choice | 1ª Escolha | 1ª Opción

Stock available until sold out | Stock disponível até acabar o stock | Stock disponible hasta acabar el stock

Insert Order Code: ⁽¹⁾Geometry code + ⁽²⁾Grade code

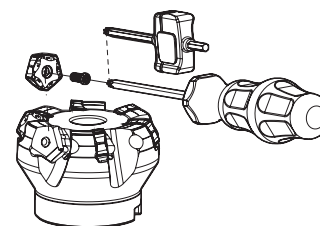
Stock items | Itens de stock

Available under request (see page A-11) | Disponível sobre consulta (consulte a página A-11) | Disponible bajo consulta (mire pagina A-11)



SPARE PARTS | Complementos | Complementos

Cutter ØDc	Insert Screw	Key (Torx)	Torque Value
			lbf/in
PN60-A-11 - 2.00-3.00	P0401200	XT15	26.6
PN60-A-11 - 4.00-10.00	P0401200	PT15	26.6



GRADES SELECTION GUIDE

ISO	PSM	Material	HB (brinell)	Grades					
				← Wear Resistance			Toughness →		
				PH5705	PH7910	PHP910	PH7920	PHP920	PH5740
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

ISO	PSM	Material	HB (Brinell)	Vc (sfm)				Feed fz (in/t)
				← Wear Resistance		Toughness →		
				PH5705	PH7910	PH7920	PH5740	
P	1	Unalloyed Steel	125-220	-	590-820	590-788	-	0.006-0.012
	2	Low-Alloyed Steel	220-280	-	525-755	525-722	-	0.006-0.012
	3	High-Alloyed Steel	280-380	-	460-722	460-690	-	0.006-0.010
K	7	Malleable Cast Iron	130-230	525-950	590-1004	525-854	525-854	0.005-0.014
	8	Grey Cast Iron	180-245	558-1050	525-820	460-788	460-788	0.005-0.014
	9	Nodular Cast iron	160-250	460-656	492-656	394-656	394-656	0.005-0.012

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

(Note 2) Cutting conditions should be adjusted according to the machine and work rigidity.

(Note 3) If chattering occurs, reduce ap and Vc by 30% and keep the same fz per tooth.

CHIP-BREAKER SELECTION GUIDE

ISO	PSM	Material	HB (Brinell)	Chip breaker Application	
				1st choice	Difficult Operations
P	1	Unalloyed Steel	125-220	PNH(K)X 11... MK	-
	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

PLUS
PN60-11

HEADQUARTERS

PALBIT, S.A.

P.O.Box 4 - Palhal

3854-908 - Branca ALB - Portugal

T (+351) 234540300 | F (+351) 234540301

palbit@palbit.pt

www.palbit.pt

Branch office:

PALBIT México

Emerson 150. Int.803-804. Colonia Chapultepec

Morales Delagación Miguel Hidalgo

C.P. 11570 México DF

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

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