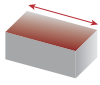
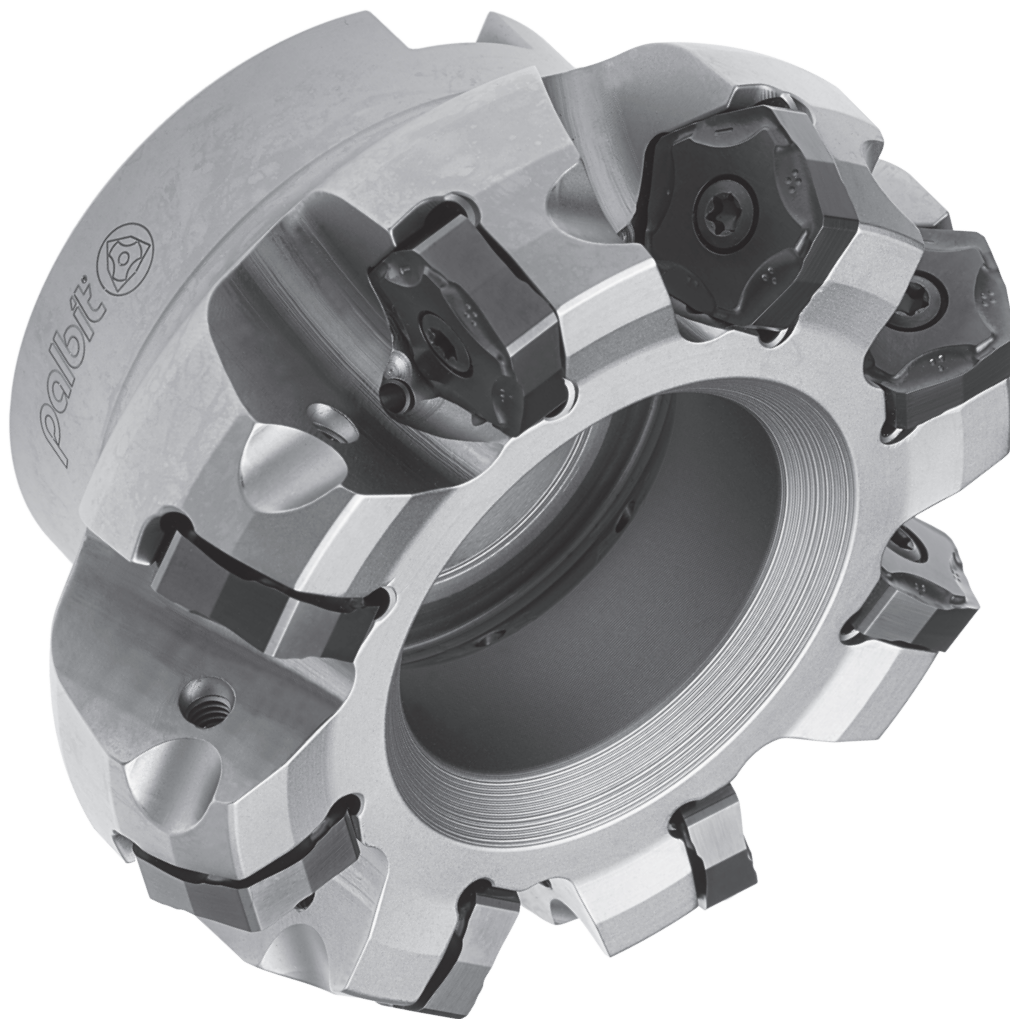


Optimized performance face milling of cast irons and forged steels

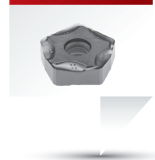


Facing

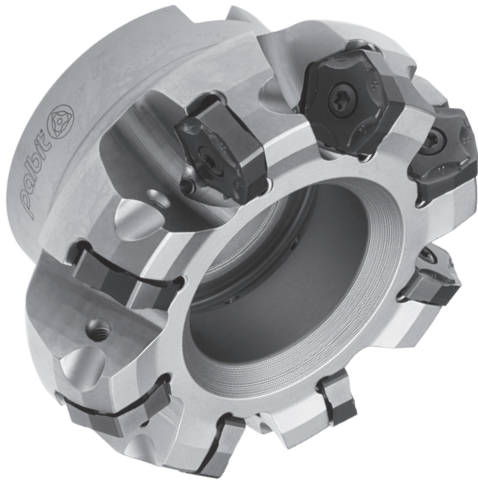
PLUS
90260



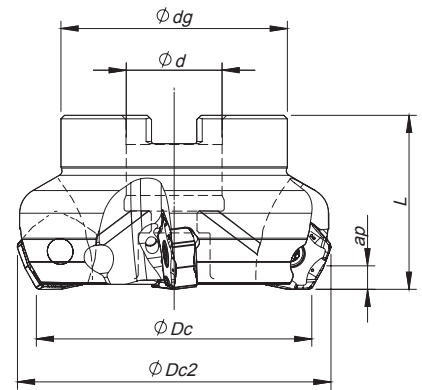
INSERT SIZE
11 PN...
1105



SINCE 1916



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



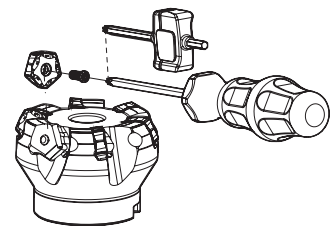
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)					Kg	Specifications		Insert Pastilha Inserto	Stock
			ϕDc	$\phi Dc2$	ϕd	ϕdg	L		Arbor Type	Ap max (mm)		
181050200	050A90260-05-07-022040	5	50	59,05	22	48	40	0,388	A	5,0	PN... 1105...	
181050300	063A90260-06-07-022040	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

SPARE PARTS | Complementos | Repuestos

Cutter ϕDc	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	-	-





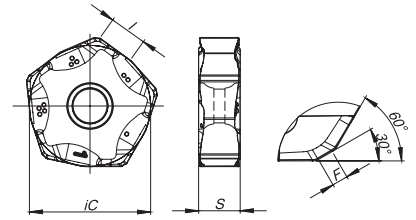
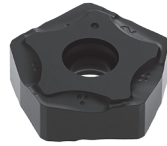
PNH(K)X 1105 | Inserts | Pastilhas | Plaquetas

PNHX-MK

PNHX-HK

PNKX-MK

PNH(K)X-MK | HK



Geometry code	ISO Reference	P						M			K						N		S		H	Dimensions Dimensões Dimensiones (mm)				
		CVD		PVD				CVD		PVD	CVD			PVD			UNC	PCD	PVD		PVD					
		T9	P7	G1	G4	P3	G6	R1	G4	G6	L5	L6	L9	G1	G4	P3	G6	10	D6	P3	G6					
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

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	-	190-280	180-250	-	0,15-0,30
	2	Low-Alloyed Steel	220-280	-	180-240	170-210	-	0,15-0,30
	3	High-Alloyed Steel	280-380	-	170-220	160-200	-	0,15-0,25
K	7	Malleable Cast Iron	130-230	190-340	-	-	170-300	0,12-0,35
	8	Grey Cast Iron	180-245	180-300	-	-	150-260	0,12-0,35
	9	Nodular Cast iron	160-250	140-250	-	-	130-220	0,12-0,30

(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 a_p and V_c by 30% and keep the same f_z per tooth.

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

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