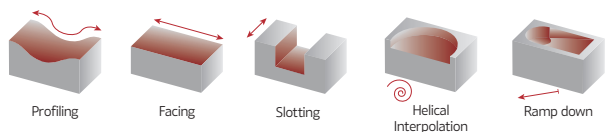


Double-sided round milling insert

palbit[®]
TOOLING SOLUTIONS EXPERTS
SINCE 1916

TOROMILL X2
35190



INSERT SIZE
12 RNHX
1204

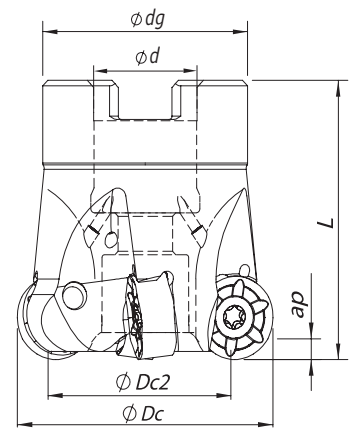


SINCE 1916



Arbor Mounting

$\gamma_p = -7^\circ$



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)		
181111600	040A35190-04-07-016040	4	40	32	16	32	40	0,20	A	3,0	RNHX 1204 MOE...	
181100200	050A35190-05-07-022040	5	50	42	22	40	40	0,24	A	3,0	RNHX 1204 MOE...	
181128800	063A35190-06-07-022050	6	63	49	22	48	50	0,55	A	3,0	RNHX 1204 MOE...	
181128900	080A35190-07-07-027050	7	80	60	27	60	50	0,78	A	3,0	RNHX 1204 MOE...	
181175600	100A35190-09-07-032050	9	100	80	32	70	50	1,00	B	3,0	RNHX 1204 MOE...	

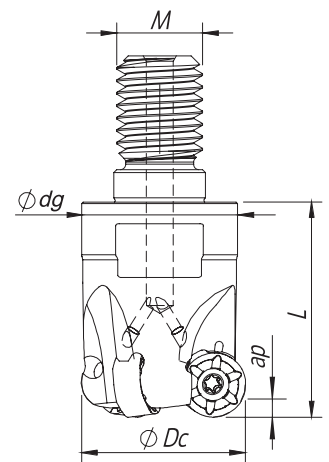
Stock item | Produto de stock | Itens de stock

Available under request (see page A-8) | Disponível sobre consulta (consulte a página A-8) | Disponible bajo consulta (mire pagina A-8)



Threaded Coupling

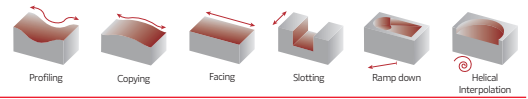
$\gamma_p = -7^\circ$



Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications		Insert Pastilha Inserto	Stock
			ϕDc	ϕM	ϕdg	L		Ap max (mm)			
181128500	032R35190-03-07-M16040	3	32	M16	29	40	0,16	3,0	RNHX 1204 MOE...		
181128700	042R35190-04-07-M16040	4	42	M16	29	40	0,20	3,0	RNHX 1204 MOE...		

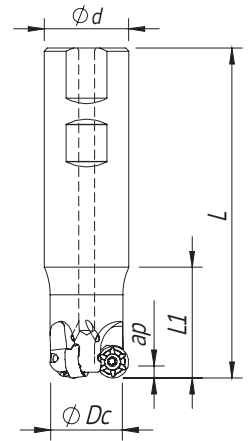
Stock item | Produto de stock | Itens de stock

Available under request (see page A-8) | Disponível sobre consulta (consulte a página A-8) | Disponible bajo consulta (mire pagina A-8)



Weldon Shank

$\gamma_p = -7^\circ$



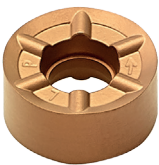
Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications	Insert Pastilha Inserto	Stock
			ØDc	Ød/M	L	L1		Ap max (mm)		
181087000	032W35190-03-07-032125	3	32	32	125	42	0,98	3,0	RNHX 1204 MOE...	

Stock item | Produto de stock | Itens de stock

Available under request (see page A-9) | Disponível sobre consulta (consulte a página A-9) | Disponible bajo consulta (mire pagina A-9)

RNHX 1204... || Inserts | Pastilhas | Plaquetas

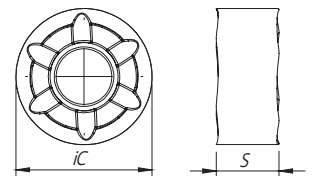
RNHX-LP



RNHX-MP



RNHX-LP | MP



(1) Geometry code	ISO Reference	P				M			K		S		Dimensions Dimensões Dimensiones (mm)	
		PVD				PVD			PVD		PVD			
		(2) Grade code	T1	P4	Z2	X9	Z2	Z3	T1	P4	X9	Z3	IC	S
1112030	RNHX 1204 MOE-LP											12,00	4,76	
1112052	RNHX 1204 MOE-MP											12,00	4,76	

First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

Available under request (see page A-9) | Disponível sobre consulta (consulte a página A-9) | Disponible bajo consulta (mire pagina A-9)

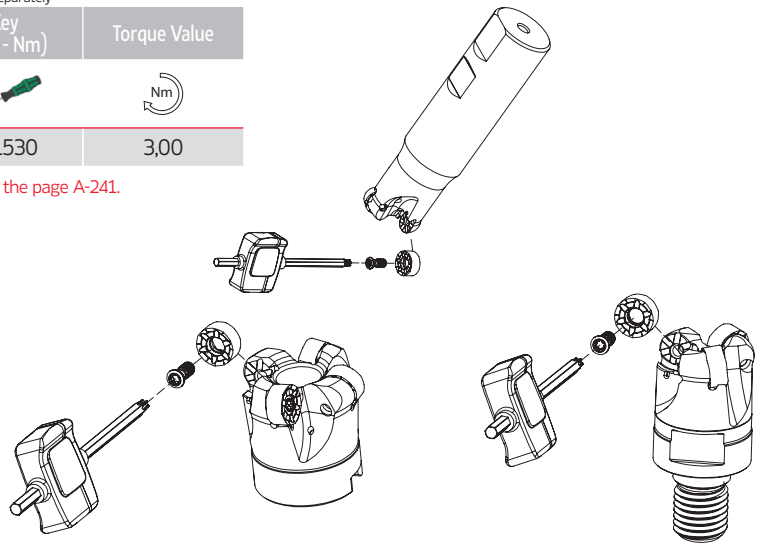
Insert order code = (1) Geometry Code + (2) Grade Code

TOROMILL X2 35190

SPARE PARTS | Complementos | Repuestos

Cutter ØDc	Insert Screw	Key (Torx)	Order separately	
			Key (Torx - Nm)	Torque Value
35190	P0401065	XT15	DT1530	3,00

Note: The toolholder is supplied with the XT/PT key. To order the DT key please check the page A-241.
Check the procedures for the clamping screws on the page A-241.



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

ISO	PSM	Material	HB (Brinell)	Grades				
				← Wear Resistance			Toughness →	
				PHP920	PHP930	PHH930	PHP530	PHH530
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	200-330			✓		✓
	6	SS - Austenitic-ferritic (Duplex)	230-260			✓		✓
K	7	Malleable Cast Iron	130-230	✓	✓			
	8	Grey Cast Iron	180-245	✓	✓			
	9	Nodular Cast iron	160-250	✓	✓			
S	11	Heat Resistant Super Alloys	200-320			✓		✓

● Good Conditions
 ● Average Conditions
 ● Difficult Conditions

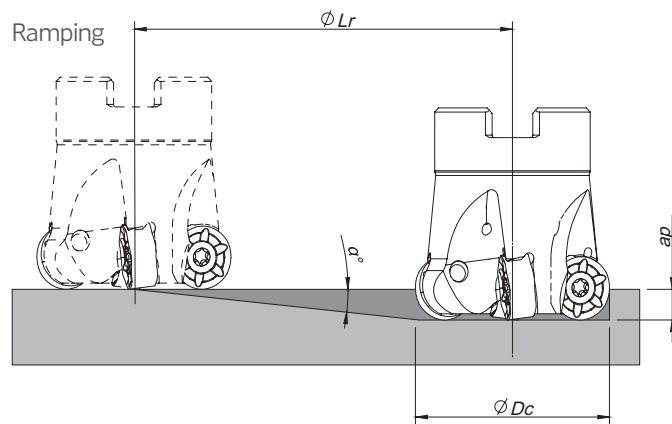
RECOMMENDED CUTTING CONDITIONS | Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min)					RNHX... 12	
				← Wear Resistance			Toughness →		LP	MP
				PHP920	PHP930	PHH930	PHP530	PHH530		
P	1	Unalloyed Steel	125-220	180-250	160-230	-	180-340	-	0,15-0,45	0,15-0,50
	2	Low-Alloyed Steel	220-280	160-230	140-210	-	180-340	-	0,15-0,45	0,15-0,50
	3	High-Alloyed Steel	280-380	140-220	120-200	-	180-330	-	0,15-0,45	0,15-0,45
M	4	SS - Ferritic / Martensitic	200-330	-	-	140-210	150-270	170-280	0,10-0,35	-
	5	SS - Austenitic	200-330	-	-	120-170	-	160-280	0,10-0,35	-
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	100-150	-	150-260	0,10-0,35	-
K	7	Malleable Cast Iron	130-230	-	150-280	-	-	-	-	0,15-0,55
	8	Grey Cast Iron	180-245	-	130-230	-	-	-	-	0,15-0,55
	9	Nodular Cast iron	160-250	-	80-190	-	-	-	-	0,15-0,50
S	11	Heat Resistant Super Alloys	200-320	-	-	30-110	-	30-150	0,05-0,30	-

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

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

RAMPING | Descida em rampa | Bajada en rampa



Insert	ϕDc	Ramping		
		Max Ramp a°	Max ap	Min Lr
RNHX 1204	32	1	3	171,9
	40	0,8	3	214,8
	42	0,8	3	214,8
	50	0,8	3	214,8
	63	0,6	3	286,5
	80	0,5	3	343,8



TOROMILL X2 35190

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