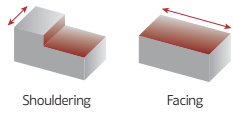


Positive Square Shoulder Milling Line



LINEPRO
06290

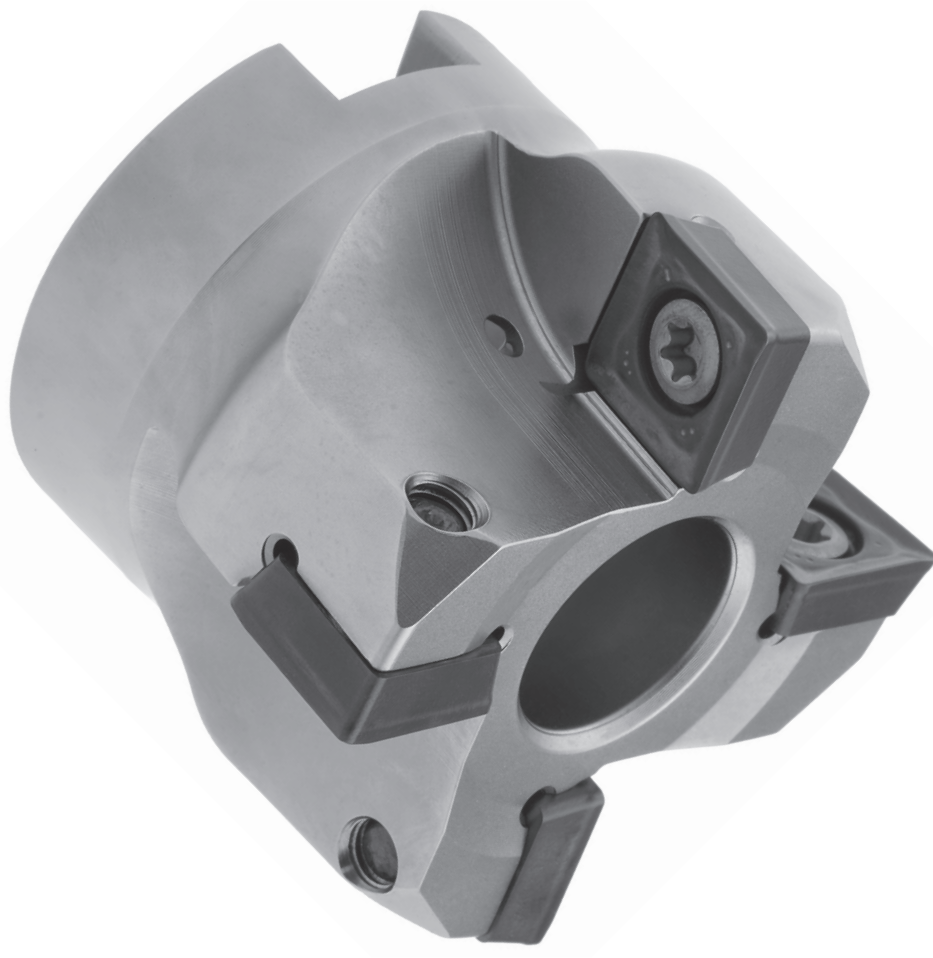
NEW

PHP

NEW
GRADE

PHH

NEW
GRADE

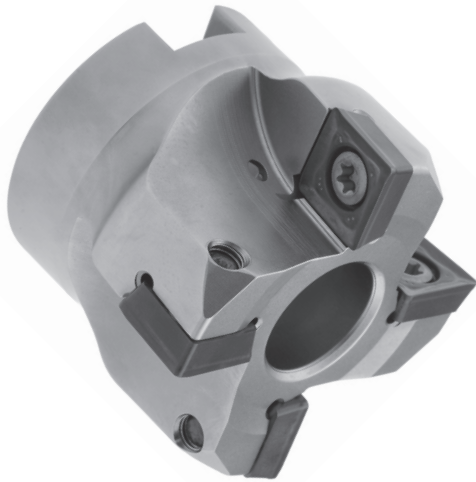


INSERT SIZE
12 SP...X
1204

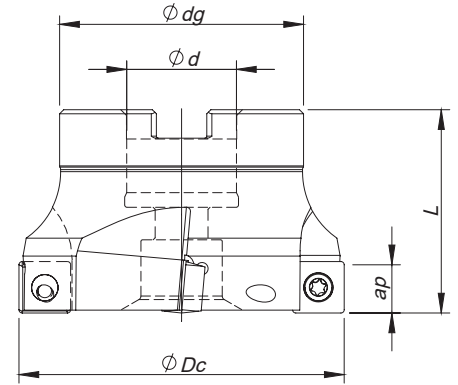


NEW

SINCE 1916



Arbor Mounting
 $K_r=90^\circ$ | $\gamma_p=+6^\circ$



Order code Código	Reference Referência Referencia		Dimensions Dimensões Dimensiones (mm)				Kg	Specifications		Insert Pastilha Inserto	Stock
			ϕDc	ϕd	ϕdg	L		Arbor Type	Ap max (mm)		
181167700	040A06290-03-06-016040	3	40	16	39	40	0,2	A	11	SP...1204	
181167800	050A06290-04-06-022040	4	50	22	49	40	0,35	A	11	SP...1204	
181167900	063A06290-05-06-027050	5	63	27	60	50	0,7	A	11	SP...1204	
181168000	080A06290-06-06-027050	6	80	27	60	50	1,15	A	11	SP...1204	
181168100	100A06290-08-06-032050	8	100	32	80	50	1,75	A	11	SP...1204	
181168200	125A06290-08-06-040063	8	125	40	96	63	3,05	B	11	SP...1204	
181065600	160A06290-10-06-U040063	10	160	40	100	63	4,2	C	11	SP...1204	

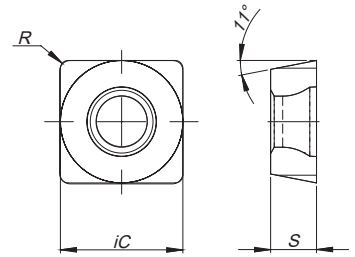
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

SP... 1204... || Inserts | Pastilhas | Plaquitas



SPGX-MP | SPMW-MS



Geometry code	ISO Reference	P	M	K	S	Dimensions Dimensões Dimensiones (mm)		
		PVD	PVD	PVD	PVD	iC	S	R
		(2) Grade code	T1	X9	T1			
(1)		PHP920	PHH930	PHP920	PHH930			
1113002	SPGX 120408 PDSR-MP					12,73	4,8	0,8
1113003	SPGX 120408 PDSR-MS					12,73	4,8	0,8
1112916	SPMX 120408 PDSR-MP					12,73	4,8	0,8
1112999	SPMX 120408 PDSR-MS					12,73	4,8	0,8

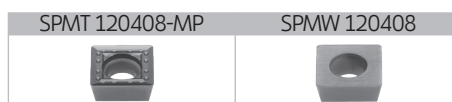
First choice | Primeira opção | 1ª opción

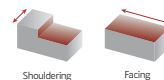
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

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

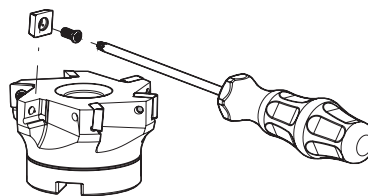
Note: It is possible to use other inserts, please check the General Catalogue on page A - 50





SPARE PARTS | Complementos | Repuestos

Cutter ØDc	Insert Screw	Key (Torx)	Order separately	
			Key (Torx - Nm)	Torque Value
A06290 – 40 - 160	P0501100	PT20	DT2050	5,00



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 →	SPG(M)X...MP	SPM(M)X...MS
				PHP920	PHH930		
P	1	Unalloyed Steel	125-220	180-250	-	0,08-0,20	-
	2	Low-Alloyed Steel	220-280	170-210	-	0,08-0,20	-
	3	High-Alloyed Steel	280-380	160-200	-	0,08-0,20	-
M	4	SS - Ferritic / Martensitic	200-330	-	120-180	-	0,08-0,20
	5	SS - Austenitic	200-330	-	100-160	-	0,08-0,20
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	70-140	-	0,08-0,20
K	7	Malleable Cast Iron	130-230	170-300	-	0,10-0,30	-
	8	Grey Cast Iron	180-245	150-250	-	0,10-0,30	-
	9	Nodular Cast iron	160-250	90-210	-	0,10-0,30	-
S	11	Heat Resistant Super Alloys	200-320	-	30-75	-	0,08-0,15

(Note 1) Cutting conditions ae/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 | Guia para aplicações do quebra- aparas | Guía para aplicación del rompevirutas

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

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