



TGPLUS

90390 | LNXT 1506..

High performance
tangential shoulder milling



Cutters

- Excellent machining stability.
- Available in regular and fine pitch cutters.
- Internal coolant supply up to 125 mm.

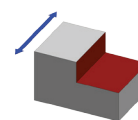
Specifications

- Geometry: 90° tangential milling.
- Cutter diameter:
 - Arbor Mounting (A): Ø50 till Ø160.
- Workpiece materials: Steel, stainless steel, cast iron and HRSA.

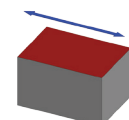
Inserts

- Robust geometry.
- Tangential insert with 4 corners available.
- High rake angle insert reduces cutting force.
- Improved pocket configuration.

Applications



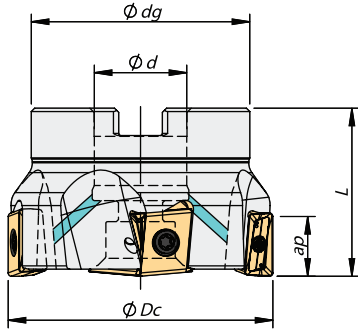
Shouldering



Facing

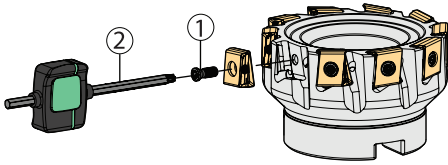
$K_r = 90^\circ$
 $\gamma_p = -5^\circ$

Arbor Mounting



Order Code	Reference		Dimensions (mm)				Specifications		Stock
			Ø Dc	Ø d	Ø dg	L	Arbor Style	a _p Max. (mm)	
181069200	050A90390-05-05-022040	5	050	22	42	40	A	14,00	
181066400	063A90390-05-05-022040	5	063	22	52	40	A		
181051000	063A90390-08-05-022040	8	063	22	52	40	A		
181066500	080A90390-07-05-027050	7	080	27	60	50	B		
181052000	080A90390-10-05-032050	10	080	27	60	50	B		
181066600	100A90390-08-05-032050	8	100	32	80	50	B		
181051100	100A90390-12-05-032050	12	100	32	80	50	B		
181066700	125A90390-09-05-040063	9	125	40	90	63	B		
181051200	125A90390-15-05-040063	15	125	40	90	63	B		
181051300	160A90390-10-05-U040063	10	160	40	110	63	C		
181066800	160A90390-20-05-U040063	20	160	40	110	63	C		

Screws & Keys



Item	1	2	Order Separately		
Cutter ØDc	Insert Screw	Key (Torx)	Torque Value	Screw	DIN 6368 Wrench
A90390 – 50 - 63	P0401200	XT15	3,0	-	-
A90390 – 80	P0401200	XT15	3,0	J0123510	SD6368-12
A90390 – 100	P0401200	XT15	3,0	J0164110	SD6368-16
A90390 – 125	P0401200	XT15	3,0	J0204610	SD6368-20
A90390 – 160	P0401200	XT15	3,0	-	-

LNXT 1506..

(1) Geometry	(2) Grade Code	P		M		K		S		Dimensions (mm)						
		54	68	I5	68	I5	54	68	I5	68	I5	IC	S	I	R	F
		PH6910	PH6920	PH6740	PH6920	PH6740	PH6910	PH6920	PH6740	PH6920	PH6740					
1111313	LNXT 150608 PNER-MP										11,00	6,35	15,0	0,8	1,8	
1111591	LNXT 150608 PNSR-HP										11,00	6,35	15,0	0,8	1,8	
1111524	LNXT 150608 PNER-W										11,00	6,35	15,2	0,8	5,5	
1111590	LNXT 150612 PNER-MP										11,00	6,35	15,0	1,2	1,8	

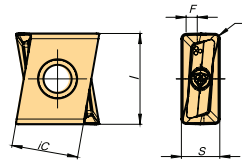
First choice / 1ª escolha / 1ª opción Stock items / Itens de stock Available under request / Disponibilidade sob consulta / Disponible bajo consulta

Order code = (1) Geometry Code + (2) Grade Code

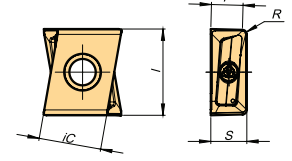
Chip Breakers

Chip Breaker	Feature
Geometry MP Gen. machining of steels	Chip-breaker with a reinforced chanfer for general applications on steels.
Geometry HP Heavy machining of steels	Chip-breaker with a reinforced chanfer for medium to heavy cutting conditions.
Geometry W Wiper	Chip-breaker wiper for the best finishing solutions.

LNXT - MP / HP



LNXT - W



Rec. Cutting Conditions

ISO	HB (Brinell)	Vc (m/min)			fz (mm/t)			
		PH6910	PH6920	PH6740	LNXT 15.. MP	LNXT 15.. HP	LNXT 15.. W	
P	Unalloyed Steel	125 - 220	180 - 250	150 - 230	130 - 160	0,10 - 0,35	0,10 - 0,35	0,10 - 0,30
	Low-Alloyed Steel	220 - 280	170 - 210	140 - 220	120 - 150	0,10 - 0,35	0,10 - 0,35	0,10 - 0,30
	High-Alloyed Steel	280 - 380	160 - 200	130 - 180	100 - 130	0,10 - 0,30	0,10 - 0,30	0,10 - 0,30
M	Ferritic / Martensitic	200 - 330	-	120 - 160	100 - 120	0,10 - 0,30	-	-
	Austenitic / Duplex	200 - 330	-	100 - 150	80 - 110	0,10 - 0,30	-	-
	Duplex	230 - 260	-	70 - 110	70 - 100	0,10 - 0,25	-	-
K	Malleable Cast Iron	130 - 230	170 - 300	150 - 280	130 - 250	0,10 - 0,40	0,10 - 0,40	0,10 - 0,40
	Grey Cast Iron	180 - 245	150 - 250	130 - 230	110 - 220	0,10 - 0,40	0,10 - 0,40	0,10 - 0,40
	Nodular Cast Iron	160 - 250	90 - 210	80 - 190	80 - 170	0,10 - 0,35	0,10 - 0,35	0,10 - 0,40
S	Heat Resistant Super Alloys	200 - 320	-	20 - 90	20 - 80	0,07 - 0,20	-	-