

PLUS

90260 | PNHX 1105

*Optimized performance face milling
of cast irons and forged steels*



Cutters

- High cutting depth & cutting stability.
- Lower power requirements and smooth cutting.
- New generation of chip maker "Wave Plus".

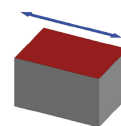
Specifications

- Geometry: 60° face milling.
- Cutter diameters:
 - Arbor Mounting (A): Ø50 till Ø160
- Workpiece materials: Cast iron and steel.

Inserts

- 10 effective cutting edges that enable improved production economy.
- Excellent machined surface rugosity due to wiper cutting edge.
- Improved insert design for optimal distribution of cutting forces.

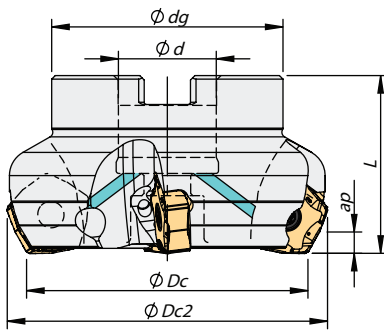
Applications



Facing

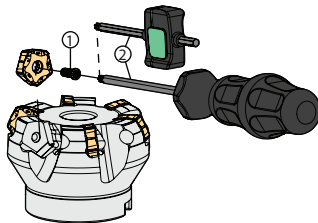
$K_r = 60^\circ$
 $\gamma_p = -7^\circ$

Arbor Mounting



Order Code	Reference		Dimensions (mm)				Arbor Style	a_p Max.	Stock
			ϕDc	ϕd	ϕdg	L			
181050200	050A90260-05-07-022040	5	50	22	48	40	A	5,0	
181050300	063A90260-06-07-022040	6	63	22	52	40	A	5,0	
181050400	080A90260-08-07-027050	8	80	27	60	50	B	5,0	
181045900	100A90260-10-07-032050	10	100	32	80	50	B	5,0	
181050500	125A90260-12-07-040063	12	125	40	90	63	B	5,0	
181050600	160A90260-14-07-U040063	14	16	40	110	63	C	5,0	

Screws & Keys



Item	1		2	
	Cutter ϕDc	Insert Screw	Key (Torx)	Torque Value
A90260 – 50 - 63	P0401200	XT15	3,0	
A90260 – 80	P0401200	XT15	3,0	
A90260 – 100	P0401200	XT15	3,0	
A90260 – 125	P0401200	XT15	3,0	
A90260 – 160	P0401200	PT15	3,0	

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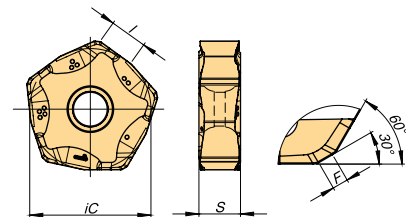
(1) Geometry	(2) Grade Code	P						K				Dimensions (mm)			
		54	68	66	I5	78	86	54	68	D2	I5	iC	S	I	F
		PH6910	PH6920	PH6930	PH6740	PH6125	PH6135	PH6910	PH6920	PH6705	PH6740				
1111374	PNHX 1105 ZNER-MK											16,50	5,66	5,7	1,3

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

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

Chip Breaker

Chip Breaker	Features
Geometry MK General machining of cast irons	Angles optimized for greater stability and durability of the edge in the machining of cast iron.



Rec. Cutting Conditions

ISO	PSM	Material	HB (Brinell) Grade	V_c (mm/min)				Feed f_z (mm/t)
				← Wear Resistance		→ Toughness		
				PH6910	PH6705	PH6920	PH6740	
P	1	Unalloyed steel	125-220	180-250	-	150-230	130-160	0,15-0,28
	2	Low-alloyed steel	220-280	170-210	-	140-220	120-150	0,15-0,28
	3	High-alloy steel	280-380	160-200	-	130-180	100-130	0,15-0,25
K	7	Malleable cast iron	130-230	170-300	160-295	150-280	130-250	0,12-0,35
	8	Grey cast iron	180-245	150-250	140-245	130-230	110-220	0,12-0,35
	9	Nodular cast iron	160-250	90-210	90-205	80-190	80-170	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.