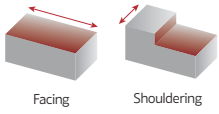
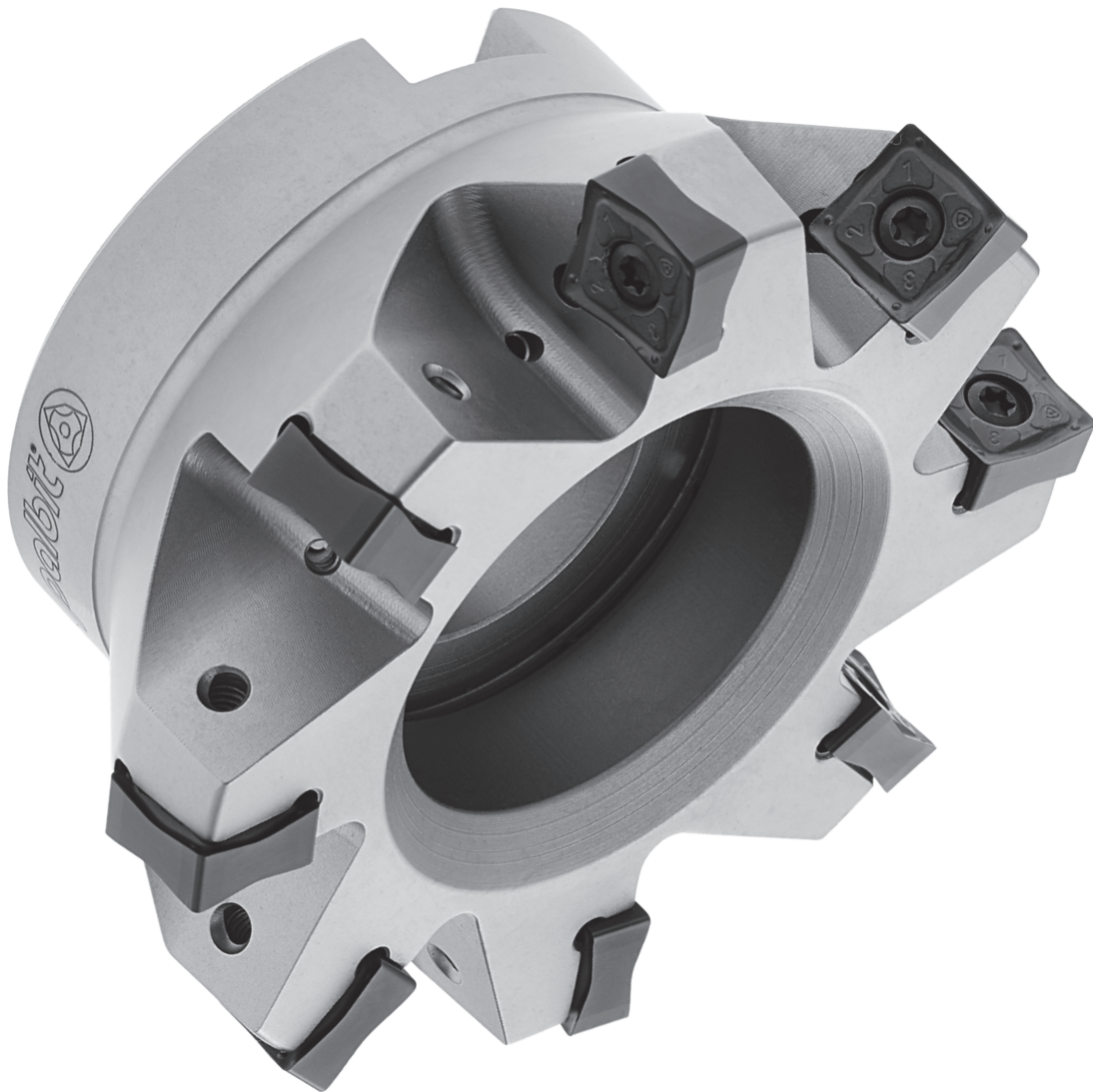
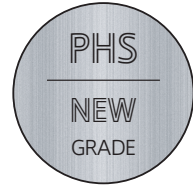


# Solution for face milling with 88° lead angle



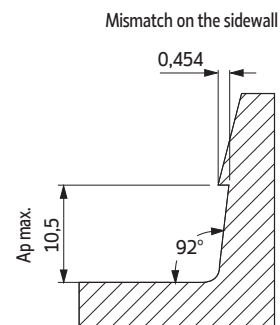
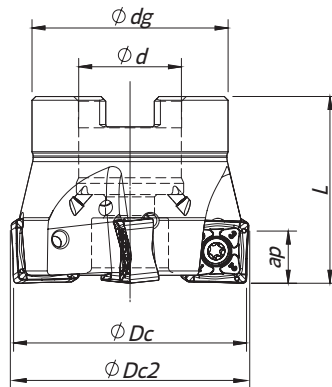
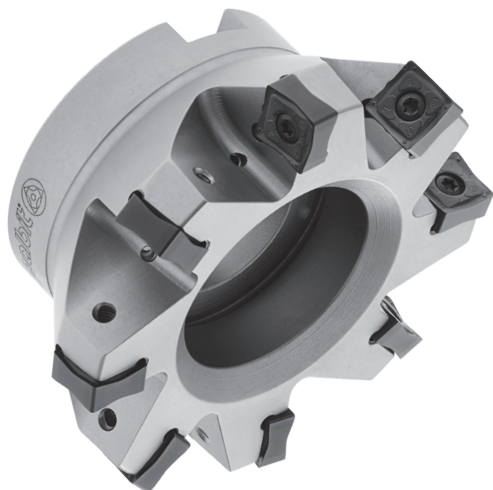
PLUS  
28088



INSERT SIZE  
**12** SN...U  
1206



SINCE 1916



**Arbor Mounting**  
 $K_r=88^\circ$  |  $\gamma_p=-6^\circ$

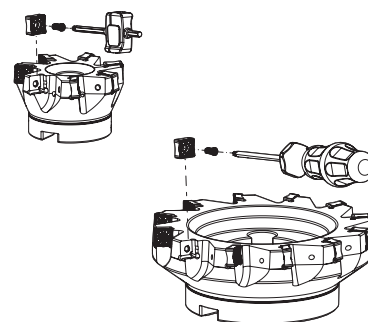
Order code Código	Reference Referência Referencia		Dimensions   Dimensões   Dimensiones (mm)					Kg	Specifications		Insert Pastilha Inserto	Stock
			$\phi Dc$	$\phi Dc2$	$\phi d$	$\phi dg$	L		Arbor Type	Ap max (mm)		
181084300	050A28088-05-06-022040	5	50	50,9	22	42	40	0,4	A	10,5	SN... 1206...	
181091600	063A28088-06-06-022040	6	63	63,9	22	48	40	0,5	A	10,5	SN... 1206...	
181091700	080A28088-07-06-027050	7	80	80,9	27	60	50	1,0	A	10,5	SN... 1206...	
181091800	080A28088-09-06-027050	9	80	80,9	27	60	50	0,9	A	10,5	SN... 1206...	
181091900	100A28088-08-06-032050	8	100	100,9	32	73	50	1,6	B	10,5	SN... 1206...	
181092000	100A28088-11-06-032050	11	100	100,9	32	73	50	1,5	B	10,5	SN... 1206...	
181092100	125A28088-10-06-040063	10	125	125,9	40	90	63	3,1	B	10,5	SN... 1206...	
181092200	125A28088-14-06-040063	14	125	125,9	40	90	63	3,0	B	10,5	SN... 1206...	
181092300	160A28088-12-06-U040063	12	160	160,9	40	110	63	3,7	C	10,5	SN... 1206...	
181092700	160A28088-18-06-U040063	18	160	160,9	40	110	63	3,5	C	10,5	SN... 1206...	
181092800	200A28088-14-06-U060063	14	200	200,9	60	172	63	6,3	C	10,5	SN... 1206...	
181092900	200A28088-22-06-U060063	22	200	200,9	60	172	63	6,1	C	10,5	SN... 1206...	

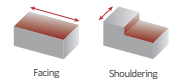
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

## SPARE PARTS || Complementos | Repuestos

Cutter $\phi Dc$	Insert Screw	Key (Torx)	Order separately		Order separately	
			Key (Torx - Nm)	Torque Value	Screw	DIN 6368 Wrench
A28088 - 50 - 80	P0401200	XT15	DT1530	3,0	-	-
A28088 - 100	P0401200	PT15	DT1530	3,0	J0164110	SD6368-16
A28088 - 125	P0401200	PT15	DT1530	3,0	J0204610	SD6368-20
A28088 - 160 - 200	P0401200	PT15	DT1530	3,0	-	-





# SNH(K)U 1206 | Inserts | Pastilhas | Plaquetas

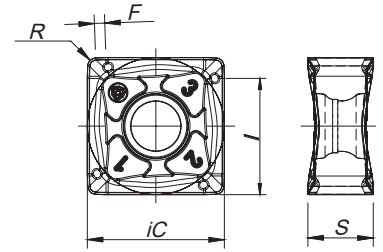
SNHU-LP

SNKU-LP  
(PHS grade)

NEW



SNH(K)U-LP



Geometry code	ISO Reference	P					M				K				N	S	H	Dimensions Dimensões Dimensiones (mm)									
		CVD	PVD				CVD	PVD			CVD			PVD	UNC	PCD	PVD	PVD	iC	S	I	R	F				
		T9	G1	G4	P3	G6	R1	G4	P3	G6	L5	L6	L9	G1	G4	P3	G6	10						D6	P3	P7	
1112020	SNHU 120608 ZNER-LP			⊗	⊗	⊗					⊗	⊗	⊗	⊗									13,30	6,35	11,60	0,80	1,00
NEW 1112278	SNKU 120608 ZNER-LP	⊗		⊗	⊗	⊗					⊗	⊗	⊗	⊗									13,30	6,35	11,60	0,80	1,00

⊗ 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	PH7920	PH7930	PH5740	PH5740	PH7740
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	✓			✓		

● 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)		
				← Wear Resistance		Toughness →
				PH5705	PH7920	PH7930
P	1	Unalloyed Steel	125-220	-	180 <b>(250)</b> 320	-
	2	Low-Alloyed Steel	220-280	-	140 <b>(180)</b> 250	-
	3	High-Alloyed Steel	280-380	-	130 <b>(180)</b> 220	-
M	4	SS - Ferritic / Martensitic	200-330	-	-	140 <b>(170)</b> 190
	5	SS - Austenitic	200-330	-	-	120 <b>(140)</b> 170
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	100 <b>(120)</b> 150
K	7	Malleable Cast Iron	130-230	160 <b>(180)</b> 295	-	-
	8	Grey Cast Iron	180-245	170 <b>(270)</b> 340	-	-
	9	Nodular Cast iron	160-250	120 <b>(150)</b> 200	-	-

ISO	PSM	Material	HB (Brinell)	Vc (m/min)			Feed fz (mm/t)
				← Wear Resistance		Toughness →	
				PH5740	PHS740	PH7740	
P	1	Unalloyed Steel	125-220	140 <b>(170)</b> 190	140 <b>(170)</b> 190	150 <b>(180)</b> 200	0,10 <b>(0,25)</b> 0,35
	2	Low-Alloyed Steel	220-280	120 <b>(140)</b> 170	120 <b>(140)</b> 170	130 <b>(150)</b> 180	0,10 <b>(0,25)</b> 0,35
	3	High-Alloyed Steel	280-380	100 <b>(120)</b> 150	100 <b>(120)</b> 150	110 <b>(130)</b> 160	0,10 <b>(0,25)</b> 0,35
M	4	SS - Ferritic / Martensitic	200-330	-	-	130 <b>(150)</b> 170	0,10 <b>(0,25)</b> 0,35
	5	SS - Austenitic	200-330	-	-	100 <b>(130)</b> 160	0,10 <b>(0,25)</b> 0,35
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	80 <b>(100)</b> 140	0,10 <b>(0,25)</b> 0,35
K	7	Malleable Cast Iron	130-230	140 <b>(160)</b> 250	-	-	0,10 <b>(0,25)</b> 0,35
	8	Grey Cast Iron	180-245	145 <b>(180)</b> 280	-	-	0,10 <b>(0,25)</b> 0,35
	9	Nodular Cast iron	160-250	105 <b>(150)</b> 170	-	-	0,10 <b>(0,25)</b> 0,35

(Note 1) The above table indicates the cutting conditions of 70% of the tool engagement.

(Note 2) With low workspace clamping rigidity or long overhang of the tool, adjust cutting speed and feed to 70 or 80% of the recommended conditions above.

(Note 3) Surface finishing is determined by speed/feed used.

(Note 4) PH5... and PHS... can be used wet or dry. PH7... use only air.

### Selection Example:

ISO	PSM	Material	HB (brinell)	Vc (m/min)		Feed fz (mm/t)
				← Wear Resistance		
				PH5705	PH5740	
K	7	Malleable cast iron	130-230	160 <b>(180)</b> 295	140 <b>(160)</b> 250	0,10 <b>(0,25)</b> 0,35
	8	Grey cast iron	180-245	170 <b>(270)</b> 340	145 <b>(180)</b> 280	0,10 <b>(0,25)</b> 0,35
	9	Nodular cast iron	160-250	<del>120</del> <b>(150)</b> 200	<del>105</del> <b>(150)</b> 170	<del>0,10</del> <b>(0,25)</b> 0,35

This example shows the recommended starting cutting conditions, indicated in Bold type.