

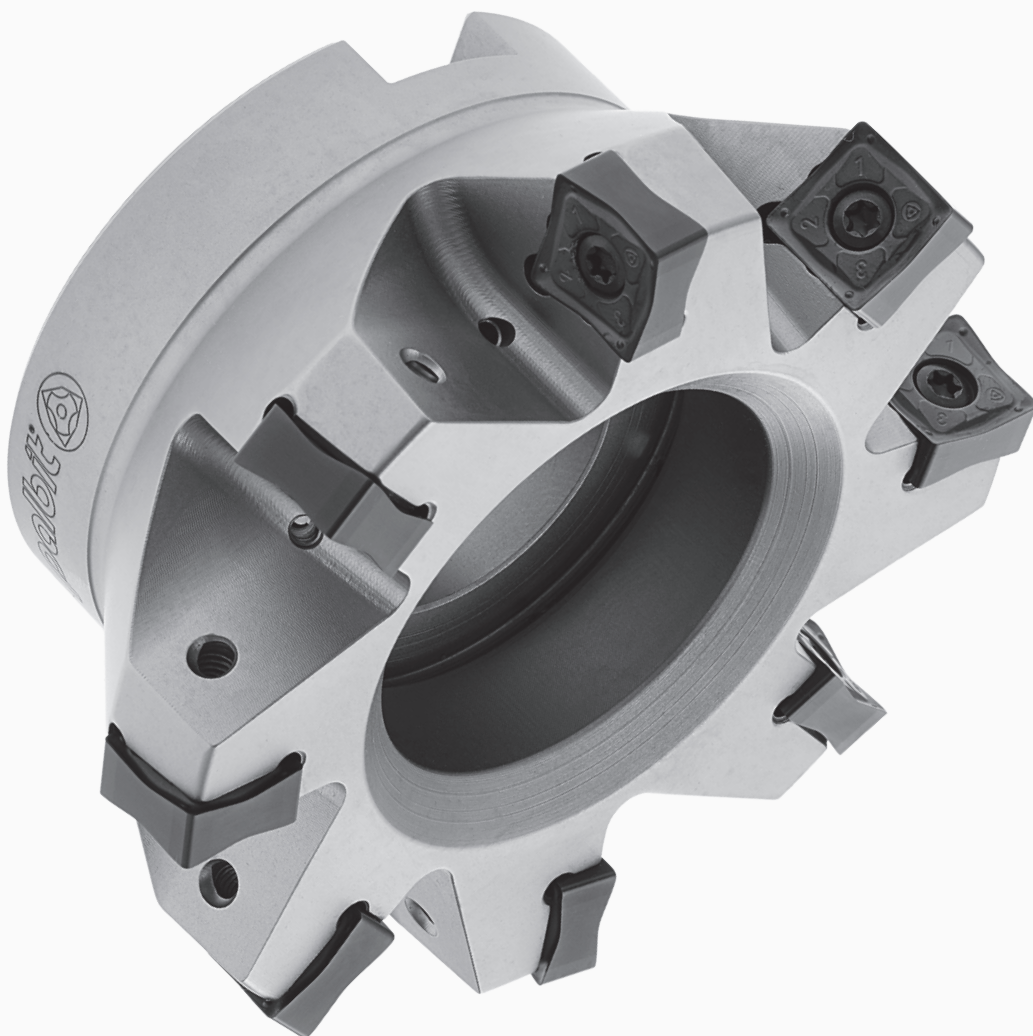
28088

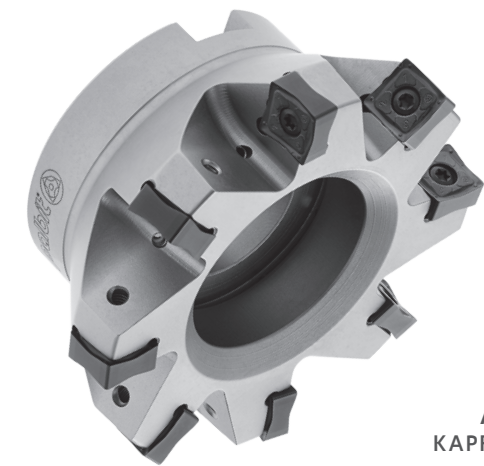
PLUS

Solution for face milling with 88° lead angle

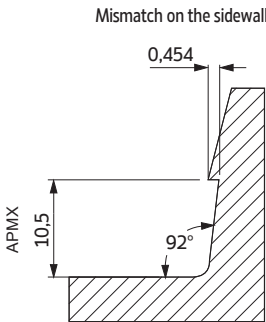
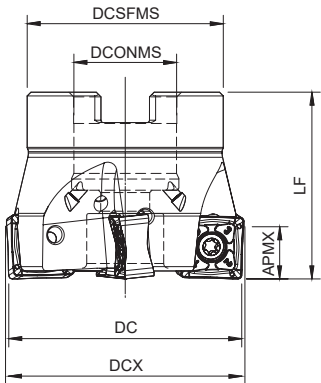
MILLING

Facing | Shouldering





Arbor Mounting
KAPR=88° | GAMP=-6°

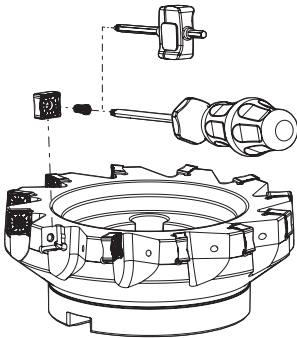


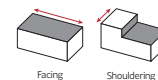
Order code Código	Reference Referência Referencia	CICT	Dimensions Dimensões Dimensiones (mm)					WT	Specifications		Insert Pastilha Inserto	Stock
			DC	DCX	DCONMS	DCSFMS	LF		Arbor Type	APMX (mm)		
181084300	050A28088-05-06-022040	5	50	50,9	22	42	40	0,4	A	10,5	SN... 1206...	⊗
181091600	063A28088-06-06-022040	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

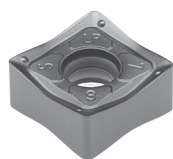
SPARE PARTS Acessórios | Repuestos

Cutter DC	Order separately				Order separately	
	Insert Screw	Key (Torx)	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	-	-

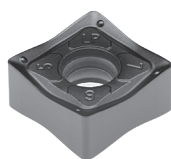




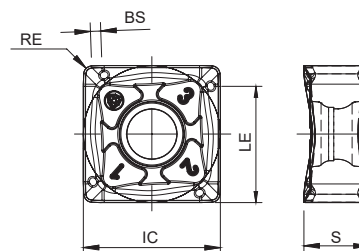
SNH(K)U 1206 Inserts | Pastilhas | Plaquetas



SNHU-LP



SNKU-LP



		P					M		K								Dimensions Dimensões Dimensiones (mm)				
		CVD	PVD				PVD		CVD				PVD								
			(2)Grade code	T9	G4	T1	P3	G6	P3	G6	L5	L6	L9	T9	G4	T1					
(1) Geometry code	ISO Reference	PHS740	PH7920	PHP920	PH7930	PH7740	PH7930	PH7740	PH5705	PH5320	PH5740	PHS740	PH7920	PHP920	PH7930	PH7740	IC	S	LE	RE	BS
1112020	SNHU 120608 ZNER-LP																13,30	6,35	11,60	0,80	1,00
1112278	SNKU 120608 ZNER-LP																13,30	6,35	11,60	0,80	1,00

First choice | Primeira opção | 1ª opção

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponível 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	PH5320	PHP920	PH7920	PH7930	PH5740	PHS740	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)								Feed fz (mm/t)
				← Wear Resistance				Toughness →				
				PH5705	PH5320	PHP920	PH7920	PH7930	PH5740	PHS740	PH7740	SNH(K)U 1206
P	1	Unalloyed Steel	125-220	-	-	180-250	180-240	160-220	-	140-220	140-200	0,10 (0,25) 0,35
	2	Low-Alloyed Steel	220-280	-	-	160-230	160-220	140-200	-	120-200	130-180	0,10 (0,25) 0,35
	3	High-Alloyed Steel	280-380	-	-	140-220	140-210	120-190	-	100-190	100-170	0,10 (0,25) 0,35
M	4	SS - Ferritic / Martensitic	200-330	-	-	-	-	140-200	-	-	130-180	0,10 (0,25) 0,35
	5	SS - Austenitic	200-330	-	-	-	-	120-160	-	-	110-160	0,10 (0,25) 0,35
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	-	-	100-140	-	-	90-150	0,10 (0,25) 0,35
K	7	Malleable Cast Iron	130-230	160-290	150-280	160-270	160-260	150-240	160-260	-	140-220	0,10 (0,25) 0,35
	8	Grey Cast Iron	180-245	170-320	160-320	140-250	140-240	140-230	140-240	-	120-210	0,10 (0,25) 0,35
	9	Nodular Cast iron	160-250	140-200	100-190	120-210	120-200	100-190	120-200	-	100-190	0,10 (0,25) 0,35

28088

PLUS

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Check the QrCode for more information



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