

A small step for Palbit
A big step for productivity



NEW
PHG GRADE
Positive inserts



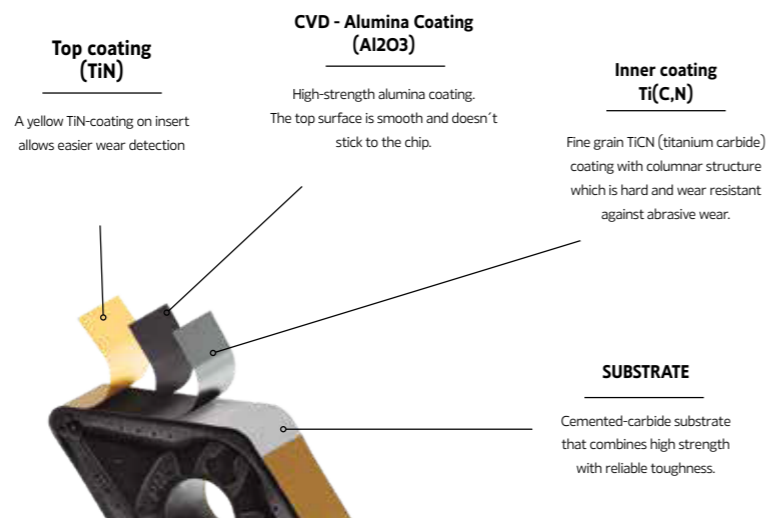
SCAN
ME!

PHG

NEW
GRADE

SINCE 1916

COATING DESCRIPTION



APPLICATION

- External and internal turning
- Roughing to finishing
- Wet and dry machining



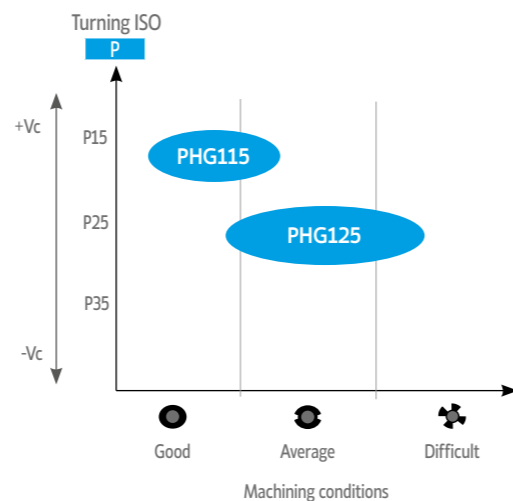
GRADES MAIN FEATURES

PHG115

- Continuous to light-interrupted cuts
- High cutting speed
- Enables long time machining
- Hard workpiece materials


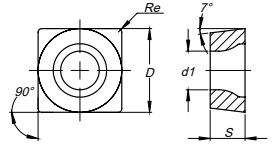

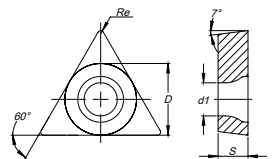

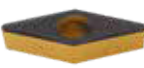
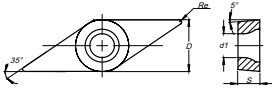
PHG125

- First choice for the majority of steel turning applications
- Continuous to interrupted cuts



Inserts Pastilhas Plaquetas	(1) Geometry code	(2) Grade code ANSI Reference	CVD-MT		Dimensions (in) Dimensões (in) Dimensiones (in)				Cutting Conditions Condições de Corte Condiciones de Corte					Technical drawing Desenho técnico Dibujo técnico	
			PHG115	PHG125	D	S	Re	d1	ap (in)	Min	Max	fn (in/rev)	Min		Max
 CCMT-MP	1121697	CCMT 21.51-MP	○	⊗	1/4	3/32	1/64	0.110	0.025	0.008	0.094	0.004	0.002	0.007	
	1121661	CCMT 21.52-MP	○	⊗	1/4	3/32	1/32	0.110	0.025	0.016	0.094	0.007	0.003	0.014	
	1121700	CCMT 32.51-MP	⊗	⊗	3/8	5/32	1/64	0.173	0.025	0.010	0.118	0.006	0.003	0.009	
	1121687	CCMT 32.52-MP	⊗	⊗	3/8	5/32	1/32	0.173	0.031	0.020	0.118	0.008	0.004	0.016	
	1121719	CCMT 431-MP	⊗	⊗	1/2	3/16	1/64	0.217	0.038	0.012	0.142	0.007	0.004	0.011	
 Medium	1121722	CCMT 432-MP	⊗	⊗	1/2	3/16	1/32	0.217	0.038	0.024	0.142	0.009	0.005	0.018	
	1121724	CCMT 433-MP	○	○	1/2	3/16	3/64	0.217	0.038	0.028	0.142	0.014	0.006	0.024	
	1121681	DCMT 21.51-MP	○	○	1/4	3/32	1/64	0.110	0.024	0.007	0.089	0.004	0.002	0.007	
 DCMT-MP	1121684	DCMT 21.52-MP	⊗	○	1/4	3/32	1/32	0.110	0.024	0.015	0.089	0.008	0.003	0.014	
	1121648	DCMT 32.51-MP	⊗	⊗	3/8	5/32	1/64	0.173	0.031	0.010	0.118	0.006	0.003	0.009	
 Medium	1121706	DCMT 32.52-MP	⊗	⊗	3/8	5/32	1/32	0.173	0.031	0.020	0.118	0.010	0.004	0.016	
	1121708	DCMT 32.53-MP	⊗	⊗	3/8	5/32	3/64	0.173	0.031	0.024	0.118	0.014	0.005	0.024	
 DCMT-FP	1121713	DCMT 52.32-FP	⊗	○	3/8	5/32	1/32	0.173	0.014	0.006	0.079	0.006	0.003	0.012	
 Finishing															
 RCMT-RF	1123848	RCMT 2507M0-RF	⊗	⊗	0.984	5/16	-	0.283	0.248	0.098	0.394	0.031	0.010	0.098	
 Roughing to Medium															
 RCMT-RM	1123856	RCMT 2006M0-RM	⊗	⊗	0.787	1/4	-	0.256	0.157	0.079	0.315	0.018	0.005	0.025	
 Roughing to Medium															
 RCMX-RM	1123678	RCMX 3209M0-RM	⊗	⊗	1.260	3/8	-	0.374	0.256	0.126	0.512	0.071	0.031	0.098	
 Roughing to Medium															
 RCMX-ST	1121428	RCMX 2006M0-ST	⊗	○	0.787	1/4	-	0.256	0.197	0.079	0.315	0.025	0.008	0.079	
 Roughing to Medium	1123910	RCMX 3009M0-ST	⊗	⊗	1.181	3/8	-	0.394	0.276	0.118	0.433	0.035	0.012	0.110	
 RCMX-RR	1123666	RCMX 3209M0-RR	○	⊗	1.260	3/8	-	0.374	0.256	0.126	0.512	0.071	0.031	0.098	
 Roughing to Medium															

⊗ First choice | 1ª Escolha | 1ª Opción ⊗ Stock Items | Itens de stock ○ Available under request | Disponível sob consulta | Disponible bajo consulta

Inserts Pastilhas Plaquetas	(1) Geometry code	(2) Grade code ANSI Reference	P		Dimensions (in) Dimensões (in) Dimensiones (in)				Cutting Conditions Condições de Corte Condiciones de Corte					Technical drawing Desenho técnico Dibujo técnico Relief angle 7°	
			CVD-MT		D	S	Re	d1	ap (in)	Min	Max	fn (in/ rev)	Min		Max
			R2	R3											
PHG115	PHG125	PHG115	PHG125												
 Medium	1121762	SCMT 32.51-MP	○	⊗	3/8	5/32	1/64	0.173	0.031	0.010	0.118	0.006	0.003	0.009	
	1121768	SCMT 32.52-MP	○	⊗	3/8	5/32	1/32	0.173	0.031	0.020	0.118	0.010	0.004	0.016	
	1121770	SCMT 431-MP	○	○	1/2	3/16	1/64	0.217	0.038	0.012	0.142	0.007	0.004	0.011	
	1121783	SCMT 432-MP	○	⊗	1/2	3/16	1/32	0.217	0.038	0.024	0.142	0.010	0.005	0.018	
	1121785	SCMT 433-MP	○	○	1/2	3/16	3/64	0.217	0.038	0.028	0.142	0.014	0.006	0.024	
 Medium	1121703	TCMT 1.81.51-MP	○	○	7/32	3/32	1/64	0.098	0.024	0.007	0.089	0.004	0.002	0.007	
	1121812	TCMT 1.81.52-MP	○	○	7/32	3/32	1/32	0.098	0.024	0.015	0.089	0.006	0.003	0.009	
	1121970	TCMT 21.51-MP	⊗	⊗	1/4	3/32	1/64	0.110	0.026	0.008	0.098	0.005	0.002	0.007	
	1121971	TCMT 21.52-MP	⊗	⊗	1/4	3/32	1/32	0.110	0.026	0.017	0.098	0.007	0.004	0.010	
	1121972	TCMT 21.53-MP	○	○	1/4	3/32	3/64	0.110	0.026	0.020	0.098	0.008	0.004	0.016	
	1121820	TCMT 221-MP	○	○	1/4	1/8	1/64	0.110	0.026	0.008	0.098	0.005	0.002	0.007	
	1121827	TCMT 222-MP	⊗	○	1/4	1/8	1/32	0.110	0.026	0.017	0.098	0.008	0.004	0.016	
	1121829	TCMT 223-MP	○	○	1/4	1/8	3/64	0.110	0.026	0.020	0.098	0.012	0.004	0.020	
	1121836	TCMT 32.51-MP	⊗	⊗	3/8	5/32	1/64	0.173	0.031	0.010	0.118	0.006	0.003	0.010	
	1121840	TCMT 32.52-MP	⊗	⊗	3/8	5/32	1/32	0.173	0.031	0.020	0.118	0.009	0.004	0.018	
1121844	TCMT 32.53-MP	⊗	⊗	3/8	5/32	3/64	0.173	0.031	0.024	0.118	0.014	0.005	0.024		
1121849	TCMT 432-MP	○	⊗	1/2	3/16	1/32	0.217	0.038	0.024	0.142	0.010	0.005	0.018		
 Finishing	1121962	TCMT 21.51-FP	⊗	⊗	1/4	3/32	1/64	0.110	0.012	0.004	0.067	0.004	0.002	0.007	
 Medium	1121988	VCMT 331-MP	⊗	⊗	3/8	3/16	1/64	0.173	0.028	0.009	0.106	0.006	0.003	0.008	

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