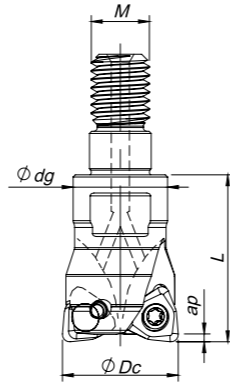


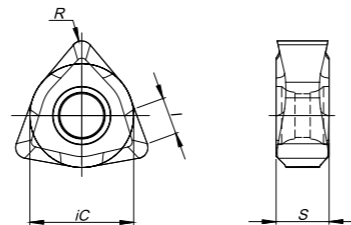
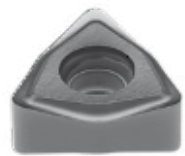
**Threaded Coupling**  
K<sub>r</sub> = 95° | γ<sub>p</sub> = -6°



Order code Código	Reference Referência Referencia	C	Dimensions   Dimensões   Dimensiones (mm)				Kg	Specifications Ap max (mm)	Insert Pastilha Inserto	Stock
			ØDc	M	Ødg	L				
181037500	025R45095-02-06-M12030	2	25	M12	21	30	0,079	0,3	WNHU 060410	⊗
181037600	035R45095-03-06-M16035	3	35	M16	29	35	0,185	0,3	WNHU 060410	⊗
181037700	042R45095-04-06-M16035	4	42	M16	29	35	0,219	0,3	WNHU 060410	⊗

⊗ Stock item | Produto de stock | Itens de stock      ○ Available under request (see page A-6) | Disponível sobre consulta (consulte a página A-6) | Disponible bajo consulta (mire página A-6)

**WNHU 060410** | Inserts | Pastilhas | Plaquetas

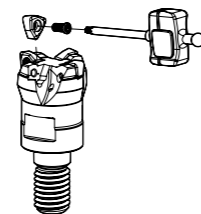


(1) Geometry code	ISO Reference	P						M				K				N	S	H	Dimensions Dimensões Dimensiones (mm)									
		CVD	PVD					CVD	PVD			CVD		PVD		UNC	PCD	PVD		PVD								
(2) Grade code		T9	P7	G1	G4	P3	G6	R1	G4	P3	G6	L5	L6	L9	G1	G4	P3	G6	10	D6	P3	G6	P7	IC	S	I	R	F
1111424	WNHU 060410	⊗	⊗	⊗																			⊗	9,53	4,76	3,40	1,00	-

⊗ First choice | Primeira opção | 1ª opción      ⊗ Stock item | Produto de stock | Itens de stock      ○ Available under request (see page A-7) | Disponível sobre consulta (consulte a página A-7) | Disponible bajo consulta (mire página A-7)      Insert order code = (1) Geometry Code + (2) Grade Code

**SPARE PARTS** | Complementos | Repuestos

Cutter ØDc	Order separately			
	Insert Screw	Key (Torx)	Key (Torx - Nm)	Torque Value
R45095 - 25-42	P0350902	XT10	DT1020	2,0



Note: The toolholder is supplied with the XT/PT key. To order the DT key please check the page A-243. Check the procedures for the clamping screws on the page A-243.

**GRADES SELECTION GUIDE** | Guia para seleção de graus | Tabla para selección de calidades

ISO	PSM	Material	HB (Brinell)	Grades		
				← Wear Resistance	Toughness →	
				PH6103	PH7910	PH7920
P	1	Unalloyed Steel	125-220	●	●	●
	2	Low-Alloyed Steel	220-280	✓	✓	✓
	3	High-Alloyed Steel	280-380	✓	✓	✓
K	7	Malleable Cast Iron	130-230		✓	✓
	8	Grey Cast Iron	180-245		✓	✓
	9	Nodular Cast iron	160-250		✓	✓
H	12	Hardened Steels	40-55 HRC	✓		

● Good Conditions  
● Average Conditions  
● Difficult Conditions

(Note 1) Grade PH6103 must be used only on finishing operations.

**RECOMMENDED CUTTING CONDITIONS** | Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min)		
				← Wear Resistance	Toughness →	
				PH6103	PH7910	PH7920
P	1	Unalloyed Steel	125-220	180-300	190-280	160-250
	2	Low-Alloyed Steel	220-280	180-250	180-240	150-230
	3	High-Alloyed Steel	280-380	180-230	170-220	140-220
K	7	Malleable Cast Iron	130-230	-	180-320	170-290
	8	Grey Cast Iron	180-245	-	170-280	140-250
	9	Nodular Cast iron	160-250	-	100-240	90-220
H	12	Hardened Steels	40-55 HRC	140-220	-	-

(Note 1) Grade PH6103 must be used only on finishing operations.

Insert	Feed fz (mm/t)		ap Rec.
	Roughing	Finishing	
WNHU 060410	0.15-0.30	0.10-0.25	0.10-0.50

(Note 1) Cutting conditions should be adjusted according to the machine and work rigidity. (Note 2) If chattering occurs, reduce ap and Vc by 30% and keep the same fz per tooth.