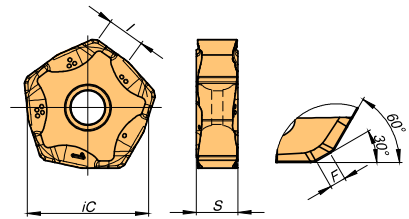
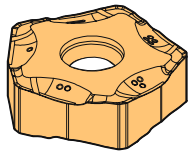


# PNHX 1105 Inserts | Pastilhas | Plaquitas



① Geometry Code	② Grade Code	Grades															Dimensions (mm)										
		P					M			K					N						S						
		G1	54	G4	68	P3	66	G6	I5	P3	G6	I5	L5	54	G4	68	P3	I9	G6	I5	10	D6	P3	G6	I5	iC	S
1111374	PNHX 1105 ZNER-MK	⊗	⊗	⊗				⊙				⊗	⊗	⊗				⊗	⊙					16,50	5,66	5,7	1,3
1111998	PNHX 1105 ZNER-HK																							16,50	5,66	5,7	1,3

**New**

⊗ First choice / 1ª escolha / 1ª opción   ⊗ Stock items / Itens de stock   ⊙ Available under request / Disponibilidade sob consulta / Disponible bajo consulta  
 ⊕ Inventory maintained. To be replaced by new grades. / Itens em stock. Serão substituídos por novos graus. / Itens en stock. Serán reemplazados por nuevos grados.

## Applicable Grades

ISO	Material	HB (Brinell)	Grades				
			← Wear Resistance			Toughness →	
		Grade	PH5705	PH7(6)910	PH7920	PH5740	PH6740
P	Unalloyed steel	125-220	●	⊗	⊗	⊗	⊗
	Low-alloyed steel	220-280		⊗	⊗		⊗
	High-alloy steel	280-380		⊗	⊗		⊗
K	Malleable cast iron	130-230	⊗			⊗	
	Grey cast iron	180-245	⊗			⊗	
	Nodular cast iron	160-250	⊗			⊗	

● Good Conditions  
 ⊗ Average Conditions  
 ⊕ Difficult Conditions

## Rec. Cutting Conditions

ISO	PSM	Material	HB (Brinell)	V <sub>c</sub> (m/min)						Feed f <sub>z</sub> (mm/t)
				← Wear Resistance			Toughness →			
			Grade	PH5705	PH7910	PH6910	PH7920	PH6740	PH5740	PNHX 11...
P	1	Unalloyed steel	125-220	-	190-280	180-250	180-250	130-160	-	0,15-0,30
	2	Low-alloyed steel	220-280	-	180-240	170-210	170-210	120-150	-	0,15-0,30
	3	High-alloy steel	280-380	-	170-220	160-200	160-200	100-130	-	0,15-0,25
K	7	Malleable cast iron	130-230	190-340	180-320	170-300	170-300	130-250	170-300	0,12-0,35
	8	Grey cast iron	180-245	180-300	170-280	150-250	150-250	110-220	150-260	0,12-0,35
	9	Nodular cast iron	160-250	140-250	100-240	90-210	90-210	80-170	130-220	0,12-0,30

(Note 1) Cutting conditions a<sub>p</sub>/D<sub>c</sub>=70%.  
 (Note 2) Cutting conditions should be adjusted according to the machine and work rigidity.  
 (Note 3) If chattering occurs, reduce a<sub>p</sub> and V<sub>c</sub> by 30% and keep the same f<sub>z</sub> per tooth.

## Chip-Breaker Application

ISO	PSM	Material	HB (Brinell)	Chip Breaker Application	
				1st choice	Difficult Operations
P	1	Unalloyed steel	125-220	PNHX 11... MK	-
	2	Low-alloyed steel	220-280	PNHX 11... MK	-
	3	High-alloy steel	280-380	PNHX 11... MK	-
K	7	Malleable cast iron	130-230	PNHX 11... MK	PNHX 11... HK
	8	Grey cast iron	180-245	PNHX 11... MK	PNHX 11... HK
	9	Nodular cast iron	160-250	PNHX 11... MK	PNHX 11... HK

A  
Milling  
Plus  
TCPPlus  
HiFeed  
AluPro  
LinePro  
Classic  
ToroMill  
W-Pro  
MultiFit  
HardMill  
Solid Carbide  
Technical Data