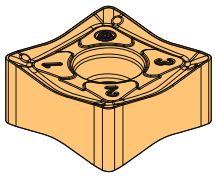
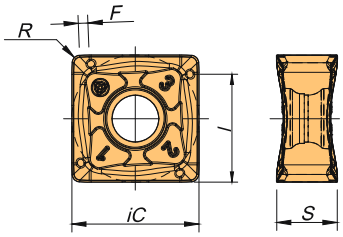
# SNHU 1206 Inserts | Pastilhas | Plaquitas






| | | Grades | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | P | | | | | | | | M | | | K | | | | | | | | N | | S | | | Dimensions (mm) | | | | |
| | (2) Grade Code | G1 | 54 | G4 | 68 | P3 | 66 | G6 | I5 | P3 | G6 | I5 | L5 | 54 | G4 | 68 | P3 | L9 | G6 | I5 | 10 | D6 | P3 | G6 | I5 | | | | | |
| (1) Geometry Code | ISO Ref. | PH7910 | PH6910 | PH7920 | PH6920 | PH7930 | PH6930 | PH7740 | PH6740 | PH7930 | PH7740 | PH6740 | PH5705 | PH6910 | PH7920 | PH6920 | PH7930 | PH5740 | PH7740 | PH6740 | PH0910 | PDP410 | PH7930 | PH7740 | PH6740 | iC | S | I | F | R |
| 1112020 | SNHU 120608 ZNER-LP | | | ◉ | ◇ | ⊛ | | ⊛ | ◇ | ◉ | ⊛ | ◇ | ◉ | | ⊛ | ◇ | ⊛ | ⊛ | ⊛ | ◇ | | | | | | 13,3 | 6,35 | 11,6 | 1,0 | 0,8 |

◉ First choice / 1ª escolha / 1ª opción ⊛ Stock items / Itens de stock ◯ Available under request / Disponibilidade sob consulta / Disponible bajo consulta

**Insert Order Code** = (1) Geometry Code + (2) Grade Code

◇ Inventory maintained. To be replaced by new grades. / Itens em stock. Serão substituídos por novos graus. / Itens en stock. Serán reemplezados por nuevos grados.

## Applicable Grades

| ISO | Material | HB (Brinell) / Grade | Grades ← Wear Resistance → Toughness | | | | |
|---|---|---|---|---|---|---|---|
| | | | PH5705 ● | PH7(6)920 ◐ | PH7930 ◐ | PH5740 ✱ | PH7(6)740 ✱ |
| P | Unalloyed steel | 125-220 | | ✓ | | | ✓ |
| | Low-alloyed steel | 220-280 | | ✓ | | | ✓ |
| | High-alloy steel | 280-380 | | ✓ | | | ✓ |
| M | SS - Ferritic/martensitic | 200-330 | | | ✓ | | ✓ |
| | SS - Austenitic | 200-330 | | | ✓ | | ✓ |
| | SS - Austetenitic-ferretic (Duplex) | 230-260 | | | ✓ | | ✓ |
| K | Malleable cast iron | 130-230 | ✓ | | | ✓ | |
| | Grey cast iron | 180-245 | ✓ | | | ✓ | |
| | Nodular cast iron | 160-250 | ✓ | | | ✓ | |

● Good Conditions

◐ Average Conditions

✱ Difficult Conditions

PAG A - 179 PAG A - 204 PAG A - 68

# PLUS 28088 Milling Tool | Ferramenta | Herramienta



## Rec. Cutting Conditions

| ISO | PSM | Material | HB (Brinell) / Grade | Vc (m/min) ← Wear Resistance | | | |
|---|---|---|---|---|---|---|---|
| | | | | PH5705 | PH7920 | PH6920 | PH7930 |
| P | 1 | Unalloyed steel | 125-220 | - | 180 (**250**) 320 | 170 (**240**) 290 | - |
| | 2 | Low-alloyed steel | 220-280 | - | 140 (**180**) 250 | 130 (**170**) 210 | - |
| | 3 | High-alloy steel | 280-380 | - | 130 (**180**) 220 | 120 (**140**) 170 | - |
| M | 4 | SS - Ferritic/martensitic | 200-330 | - | - | - | 140 (**170**) 190 |
| | 5 | SS - Austenitic | 200-330 | - | - | - | 120 (**140**) 170 |
| | 6 | SS - Austetenitic-ferretic (Duplex) | 230-2600 | - | - | - | 100 (**120**) 150 |
| K | 7 | Malleable cast iron | 130-230 | 160 (**180**) 295 | - | - | - |
| | 8 | Grey cast iron | 180-245 | 170 (**270**) 340 | - | - | - |
| | 9 | Nodular cast iron | 160-250 | 120 (**150**) 200 | - | - | - |

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

(Note 2) With low workpiece 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... can be used wet or dry. PH7... use only air.

**Selection Example:**

| ISO | PSM | Material | HB (Brinell) / Grade | Vc (mm/min) ← Wear Resistance Toughness → | | | | Feed fz (mm/t) |
|---|---|---|---|---|---|---|---|---|
| | | | | PH5705 | PH6920 | PH5740 | PH6740 | SNHU 1206... |
| K | 7 | Malleable cast iron | 130-230 | 160 (**180**) 295 | - | 140 (**160**) 250 | - | 0,10 (**0,25**) 0,35 |
| | 8 | Grey cast iron | 180-245 | 170 (**270**) 340 | - | 145 (**180**) 280 | - | 0,10 (**0,25**) 0,35 |
| | 9 | Nodular cast iron | 160-250 | 120 (**150**) 200 | - | 105 (**150**) 170 | - | 0,10 (**0,25**) 0,35 |

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

# PLUS 28088 Milling Tool | Ferramenta | Herramienta

| $V_c$ (m/min) Toughness → | | | Feed $f_z$ (mm/t) |
|---|---|---|---|
| PH5740 | PH7740 | PH6740 | SNHU 1206... |
| 140 (**170**) 190<br>120 (**140**) 170<br>100 (**120**) 150 | 150 (**180**) 200<br>130 (**150**) 180<br>110 (**130**) 160 | 140 (**170**) 190<br>120 (**140**) 170<br>100 (**120**) 150 | 0,10 (**0,25**) 0,35<br>0,10 (**0,25**) 0,35<br>0,10 (**0,25**) 0,35 |
| -<br>-<br>- | 130 (**150**) 170<br>100 (**130**) 160<br>80 (**100**) 140 | -<br>-<br>- | 0,10 (**0,25**) 0,35<br>0,10 (**0,25**) 0,35<br>0,10 (**0,25**) 0,35 |
| 140 (**160**) 250<br>145 (**180**) 280<br>105 (**150**) 170 | -<br>-<br>- | -<br>-<br>- | 0,10 (**0,25**) 0,35<br>0,10 (**0,25**) 0,35<br>0,10 (**0,25**) 0,35 |