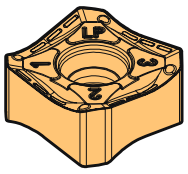
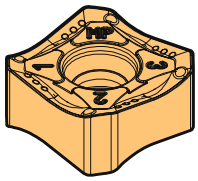
SNHX 1206 Inserts | Pastilhas | Plaquitas

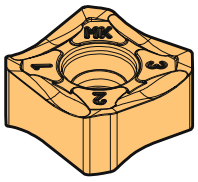
SNHX - LP



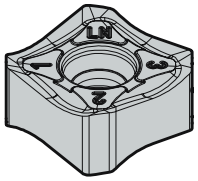
SNHX - MP

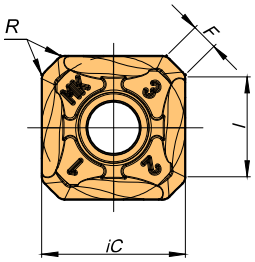


SNHX - MK

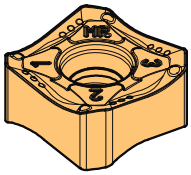


SNHX - LN

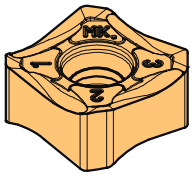




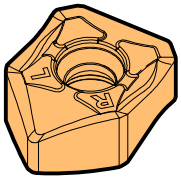
New **SNKX - MP**

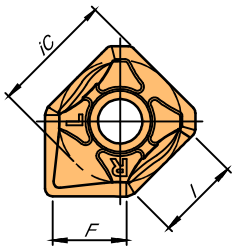


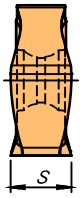
New **SNKX - MK**



SNHX - Wiper







		Grades																												
		P								M			K								N		S			Dimensions (mm)				
	(2) Grade Code	G1	54	G4	68	P3	66	G6	I5	P3	66	I5	L5	G1	G4	68	P3	66	D2	L9	10	D6	P3	G6	I5					
(1) Geometry Code	ISO Ref.	PH7910	PH6910	PH7920	PH6920	PH7930	PH6930	PH7740	PH6740	PH7930	PH6930	PH6740	PH5705	PH7910	PH7920	PH6920	PH7930	PH6930	PH6705	PH5740	PH0910	PDP410	PH7930	PH7740	PH6740	iC	S	I	R	F
New 1112293	SNKX 1206 ANSN-MP			◈				◈																		12,70	4,76	9,3	0,8	2,0
New 1112249	SNKX 1206 ANEN-MK																		◈	◈						12,70	4,76	9,3	0,8	2,0
1111452	SNHX 1206 ANEN-LP			◈	◇	◈	◇			◈	◇				◈	◇	◈	◇					◈			12,70	6,35	9,3	0,8	2,0
1111502	SNHX 1206 ANSN-MP	◈	◇	◈	◇	◈	◇																			12,70	6,35	9,3	0,8	2,0
1111503	SNHX 1206 ANEN-MK												◈	◈	◈	◇	◈	◇		◈						12,70	6,35	9,3	0,8	2,0
1111504	SNHX 1206 ANFN-LN																				◈					12,70	6,35	9,3	0,8	2,0
1111899	SNHX 1206 ANFN-W*	◈		◈	◇									◈	◈	◇										12,70	6,30	9,3	0,4	7,6

* Wiper inserts with 2 rights and 2 left-hand cutting edges.

◈ 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 → PH0910 ●	PH5705 ●	PH7(6)910 ●	PH7(6)920 ◕	PH7(6)930 ◔	PH5740 ◔	PH7740 ◔
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		✓				✓	
N	Aluminium and Non Ferrous	30-130	✓						
S	Heat Resistant Super Alloys	200-320					✓		

● Good Conditions
◕ Average Conditions
◔ Difficult Conditions

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Rec. Cutting Conditions

ISO	PSM	Material	HB (Brinell) / Grade	V_c (m/min) ← Wear Resistance					
				PH0910	PH5705	PH7910	PH6910	PH7920	PH6920
P	1	Unalloyed steel	125-220	-	-	190-280	180-250	180-250	150-230
	2	Low-alloyed steel	220-280	-	-	180-240	170-210	170-210	140-220
	3	High-alloy steel	280-380	-	-	170-220	160-200	160-200	130-180
M	4	SS - Ferritic/martensitic	200-330	-	-	-	-	-	-
	5	SS - Austenitic	200-330	-	-	-	-	-	-
	6	SS - Austetenitic-ferretic (Duplex)	230-260	-	-	-	-	-	-
K	7	Malleable cast iron	130-230	-	190-340	180-320	170-300	170-300	150-280
	8	Grey cast iron	180-245	-	180-300	170-280	150-250	150-250	130-230
	9	Nodular cast iron	160-250	-	140-250	100-240	90-210	90-210	80-190
N	10	Aluminium and Non Ferrous	30-130	350-1200	-	-	-	-	-
S	11	Heat Resistant Super Alloys	200-320	-	-	-	-	-	-

(Note 1) Cutting conditions a_e/Dc=70%.

(Note 2) It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:

- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

(Note 3) PH5... can be used wet or dry. PH7... use only air.

Chip-Breaker Application

ISO	PSM	Material	HB (Brinell)	Chip Breaker Application	
				1st choice	Difficult Operations
P	1	Unalloyed steel	125-220	SNHX 12... LP	SNH(K)X 12... MP
	2	Low-alloyed steel	220-280	SNHX 12... LP	SNH(K)X 12... MP
	3	High-alloy steel	280-380	SNH(K)X 12... MP	-
M	4	SS - Ferritic/martensitic	200-330	SNHX 12... LP	-
	5	SS - Austenitic	200-330	SNHX 12... LP	-
	6	SS - Austetenitic-ferretic (Duplex)	230-260	SNHX 12... LP	-
K	7	Malleable cast iron	130-230	SNH(K)X 12... MK	-
	8	Grey cast iron	180-245	SNH(K)X 12... MK	-
	9	Nodular cast iron	160-250	SNH(K)X 12... MK	-
N	10	Aluminium and Non Ferrous	30-130	SNHX 12... LN	-
S	11	Heat Resistant Super Alloys	200-320	SNHX 12... LP	-

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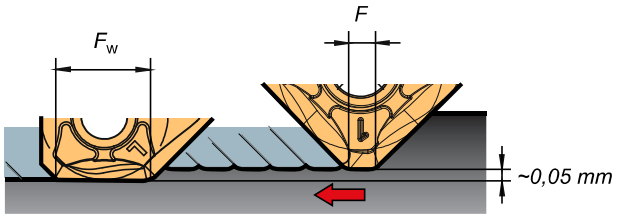
V_C (m/min) Toughness →				Feed f_Z (mm/t)				
PH7930	PH6930	PH5740	PH7740	SNHX 12... LP	SNH(K)X 12... MP	SNH(K)X 12... MK	SNHX 12... LN	SNHX 12... W
160-220 150-180 130-160	150-180 140-170 120-150	- - -	140-170 130-160 110-140	0,10-0,35 0,10-0,35 0,10-0,30	0,10-0,35 0,10-0,35 0,10-0,30	- - -	- - -	0,10-0,35 0,10-0,35 0,10-0,30
120-180 100-160 70-140	90-150 80-130 70-100	- - -	- - -	0,10-0,30 0,10-0,30 0,10-0,25	- - -	- - -	- - -	- - -
160-280 140-240 90-200	80-230 120-225 80-180	170-300 150-260 130-220	130-250 110-220 80-170	0,10-0,35 0,10-0,35 0,10-0,30	- - -	0,10-0,35 0,10-0,35 0,10-0,30	- - -	0,10-0,40 0,10-0,40 0,10-0,40
-	-	-	-	-	-	-	0,10-0,35	-
30-75	25-60	-	-	0,07-0,20	-	-	-	-

Wiper Inserts

Rec. Cutting Conditions
- F_W at least 40% larger than f_n (f_n-f_ZxZ);
- Axial deepth of cut 0,5 - 0,8 mm.



Example:
- The width of the parallel land (F) of the insert is 2,0mm.
- With a cutter of 10 inserts and using a feed per tooth (f_Z) of 0,3mm, the feed perrevolution (f_n) will be 3mm, i.e. 33% bigger than the parallel land.
- To obtain a good surface finish, the feed per revolution should be a maximum of 80% of 2mm = 1,6mm.
- The wiper insert will have a parallel land (F_W) with a width of approximately 7,6mm.
- Result: Feed per revolution (f_n) could be increased from 1,6mm to 60% of 7,6mm = 4,56mm.

Note: Other limitations, such as machine power, must be taken into consideration.

How to use a wiper insert
- Since wiper is one corner use for standard cutters, please attach the insert with the parallel land down to the workpiece cutting surface.

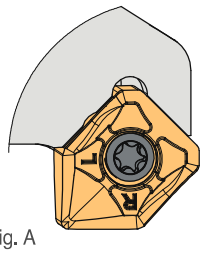


Fig. A

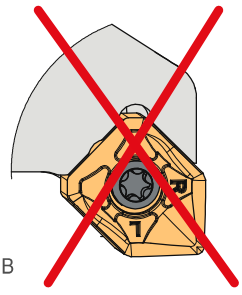
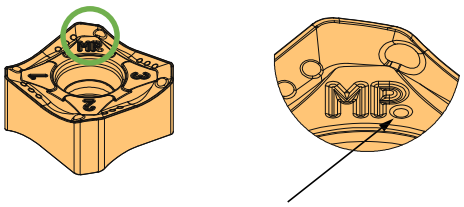
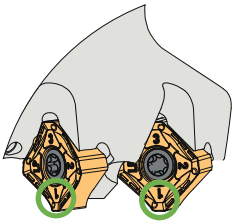


Fig. B

When using wiper insert, install the insert as shown on Fig. A.
If the insert is installed as shown on Fig. B breakage of the insert is inevitable and normal surface finish can not been obtained.



This point shows the SNKX insert difference to SNHX.


Put the same side of insert in each pocket for best radial and axial runout when using SNKX.