VAN CUTSEM tools
Quality tools for metalworking

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Topkwaliteit aan een lage snijkost!



Palbit vlakfrees PLUS 90845

- Superlichtsnijdende vlakfrees
- Keuze tussen vierkante en achtkantige freesplaten:

- ON..X freesplaten: 8-kantig - **16 snijkanten** - max.Ap: 3,5mm
- SN..X freesplaten: 4-kantig - **8 snijkanten** - max.Ap: 6,0mm

- Toepassingsgebied: P M K N S
- Levertijd: 24/48h

Palbit koppelverkoop!

Bestelref.	D_c		+	Set €
90845-050	50	4	1x 050A90845-04-06-022040 + 10x ONKX05…*	
90845-063	63	6	1x 063A90845-06-06-022040 + 10x ONKX05…*	
90845-080	80	7	1x 080A90845-07-09-027050 + 10x ONKX05…*	
90845-100	100	8	1x 100A90845-08-06-032050 + 10x ONKX05…*	
90845-125	125	10	1x 125A90845-10-06-040063 + 10x ONKX05…*	
90845-160	160	12	1x 160A90845-12-06-U040063 + 10x ONKX05…*	

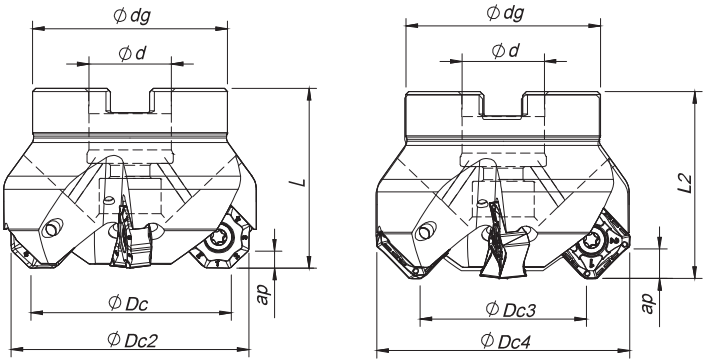
*ONKX050505ANEN-LP PH7930

U wenst een koppelaankoop met een andere snijplaat? Contacteer ons!

Bij afname van:	Freesplaten (16 snijkanten) - max Ap: 3,5mm -	€/snijpl. *bruto*	korting	€/snijpl. *netto*	€/snijkant *netto*
10 stks	ONKX050505ANEN-LP PH7930				
≥ 30 stks	ONKX050505ANEN-LP PH7930				

P M S





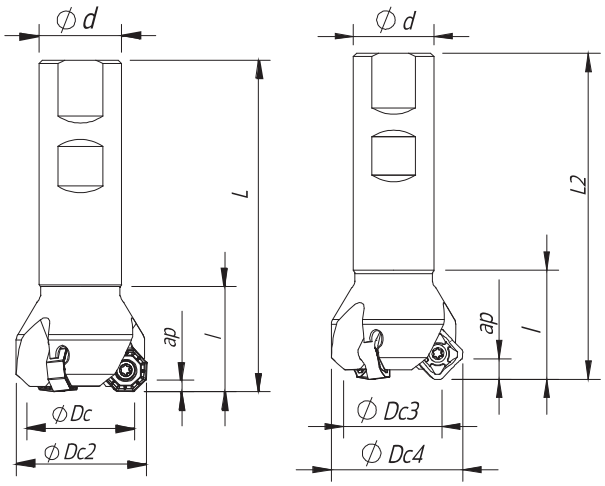
Arbor Mounting

K_r=45° | γ_p=-6°

Order code Código	Reference Referência Referencia		Dimensions | Dimensões | Dimensiones (mm)								Kg	Specifications		Insert Pastilha Inserto	Stock
			ØDc	ØDc2	ØDc3	ØDc4	Ød	Ødg	L	L2		Arbor Type	Ap (mm)		
181111400	050A90845-04-06-022040	4	50	57,6	47,1	62	22	48	40	41,5	0,383	A	3,5 | 6,0	ON...05 | SN...12	●
181117400	050A90845-06-06-022040	6	50	57,6	47,1	62	22	48	40	41,5	0,374	A	3,5 | 6,0	ON...05 | SN...12	○
181117500	063A90845-06-06-022040	6	63	70,6	60,1	75	22	52	40	41,5	0,525	A	3,5 | 6,0	ON...05 | SN...12	●
181117600	063A90845-08-06-022040	8	6	13,6	3,1	18	22	52	40	41,5	0,517	A	3,5 | 6,0	ON...05 | SN...12	●
181117700	080A90845-07-06-027050	7	80	87,6	77,1	92	27	60	50	51,5	0,846	B	3,5 | 6,0	ON...05 | SN...12	●
181117800	080A90845-10-06-027050	10	80	87,6	77,1	92	27	60	50	51,5	0,842	B	3,5 | 6,0	ON...05 | SN...12	●
181117900	100A90845-08-06-032050	8	100	107,6	97,1	112	32	80	50	51,5	1,559	B	3,5 | 6,0	ON...05 | SN...12	●
181120900	100A90845-12-06-032050	12	100	107,6	97,1	112	32	80	50	51,5	1,540	B	3,5 | 6,0	ON...05 | SN...12	●
181121000	125A90845-10-06-040063	10	125	132,6	122,1	137	40	90	63	64,5	2,890	B	3,5 | 6,0	ON...05 | SN...12	●
181121100	160A90845-12-06-U040063	12	160	167,6	157,1	172	40	110	63	64,5	4,360	C	3,5 | 6,0	ON...05 | SN...12	○
181121200	200A90845-14-06-U060063	14	200	207,6	197,1	212	60	172	63	64,5	8,890	C	3,5 | 6,0	ON...05 | SN...12	●
181121300	250A90845-16-06-U060063	16	250	257,6	247,1	262	60	172	63	64,5	11,490	C	3,5 | 6,0	ON...05 | SN...12	○

● Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta





Weldon Shank

K_r=45° | γ_p=-6°

Order code Código	Reference Referência Referencia		Dimensions | Dimensões | Dimensiones (mm)							Kg	Specifications	Insert Pastilha Inserto	Stock
			ØDc	ØDc2	ØDc3	ØDc4	Ød	L	L2		Ap (mm)		
181118000	032W90845-03-06-025100	3	32	39,6	29,1	44	25	100	101,5	0,375	3,5 | 6,0	ON...05 | SN...12	●
181118100	040W90845-04-06-032110	4	40	47,6	37,1	52	32	110	111,5	0,653	3,5 | 6,0	ON...05 | SN...12	●

● Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Facing | Slanted Shoulder & Chamfer

ONH(K)X 05 | SNH(K)X 12 | Inserts | Pastilhas | Plaquitas

ONH(K)X-LP (PHS grade) NEW



ONH(K)X-MP (PHS grade) NEW

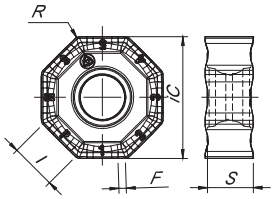


ONH(K)X-MK





ONH(K)X-LP | MP | MK



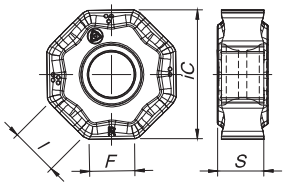
ONHX-W
8 Cutting Edges (8R)



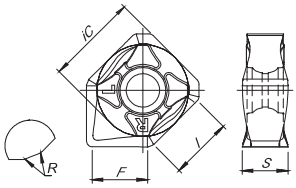
SNHX-W
4 Cutting edges (2R + 2L)



ONHX-W



SNHX-W



SNH(K)X-LP



SNH(K)X-MP (PHS grade) NEW



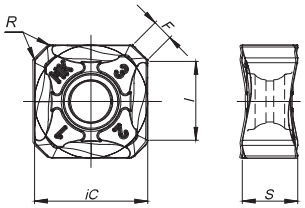
SNH(K)X-MK



SNHX-LN



SNH(K)X-LP | MP | MK | LN



		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	P3	G6	L5	L6	L9	G1	G4	G6	10	D6	P3	G6	P7					
(1) Geometry code	ISO Reference	PH5740	PH7603	PH7910	PH7920	PH7930	PH7740	PHM740	PH7930	PH7740	PH5705	PH5320	PH5740	PH7910	PH7920	PH7740	PH0910	PDP410	PH7930	PH7740	PH7603	iC	S	l	R	F
1112302	ONHX 050505 ANEN-LP				●	●	●		●	●									●	●		12,70	5,20	5,30	0,50	-
1112304	ONHX 050505 ANSN-MP				○	○																12,70	5,20	5,30	0,50	-
1112306	ONHX 050500 ANEN-MK											○	○									12,70	5,20	5,30	-	-
NEW 1112301	ONKX 050505 ANEN-LP	●			●	●			●										●			12,70	5,20	5,30	0,50	-
NEW 1112303	ONKX 050505 ANSN-MP	●			●	●																12,70	5,20	5,30	0,50	-
1112305	ONKX 050500 ANEN-MK											●	●									12,70	5,20	5,30	-	-
1112307	ONHX 050500 ANER-W				●						●											12,70	5,20	5,30	-	4,30
1111452	SNHX 1206 ANEN-LP				●	●			●										●			12,70	6,35	9,30	0,80	2,00
NEW 1111502	SNHX 1206 ANSN-MP	●		●	●	●																12,70	6,35	9,30	0,80	2,00
1111503	SNHX 1206 ANEN-MK										●		●	●	●							12,70	6,35	9,30	0,80	2,00
1111504	SNHX 1206 ANFN-LN																●					12,70	6,35	9,30	0,80	2,00
NEW 1112293	SNKX 1206 ANSN-MP	●			●		●															12,70	6,35	9,30	0,80	2,00
1112249	SNKX 1206 ANEN-MK										●	●	●									12,70	6,35	9,30	0,80	2,00
1111899	SNHX 1206 ANFN-W*			●	●									●	●							12,70	6,35	9,30	0,40	7,60

● First choice | Primeira opção | 1ª opción
● Stock item | Produto de stock | Itens de stock
○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

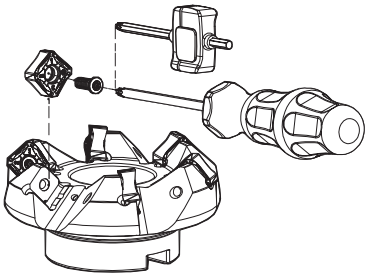
* Wiper insert with 2 rights and 2 left-hand cutting edges.

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PLUS 90845

SPARE PARTS | Complementos | Repuestos

Cutter ØDc	Insert Screw	Key (Torx)	Order separately Key (Torx - Nm)	Torque Value	Order separately Screw	DIN 6368 Wrench
A90845 – 50 - 63	P0401200	XT15	DT1530	3,0	-	-
A90845 – 80	P0401200	XT15	DT1530	3,0	J0123510	SD6368-12
A90845 – 100	P0401200	PT15	DT1530	3,0	J0164110	SD6368-16
A90845 – 125	P0401200	PT15	DT1530	3,0	J0204610	SD6368-20
A90845 – 160 - 250	P0401200	PT15	DT1530	3,0	-	-
W90845 - 32 - 40	P0401200	XT15	DT1530	3,0	-	-



GRADES SELECTION GUIDE | Guia para selecção de graus | Tabla para selección de calidades

ISO	PSM	Material	HB (Brinell)	Grades ← Wear Resistance … Toughness → PH0910	PH5705	PH5320	PH7910	PH7920	PH7930	PH5740	PHS740	PH7740
P	1	Unalloyed Steel	125-220				✓	✓	✓		✓	✓
	2	Low-Alloyed Steel	220-280				✓	✓	✓		✓	✓
	3	High-Alloyed Steel	280-380				✓	✓	✓		✓	✓
M	4	SS - Ferritic / Martensitic	200-330						✓			✓
	5	SS - Austenitic	200-330						✓			✓
	6	SS - Austenitic-ferritic (Duplex)	230-260						✓			✓
K	7	Malleable Cast Iron	130-230		✓	✓	✓	✓		✓		
	8	Grey Cast Iron	180-245		✓	✓	✓	✓		✓		
	9	Nodular Cast iron	160-250		✓	✓	✓	✓		✓		
N	10	Aluminium and Non Ferrous	30-130	✓								
S	11	Heat Resistant Super Alloys	200-320						✓			✓

Good Conditions Average Conditions Difficult Conditions

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

ISO	PSM	Material	HB (Brinell)	Vc (m/min) ← Wear Resistance				Toughness →
				PH0910	PH5705	PH5320	PH7910	PH7920
P	1	Unalloyed Steel	125-220	-	-	-	190-280	180-250
	2	Low-Alloyed Steel	220-280	-	-	-	180-240	170-210
	3	High-Alloyed Steel	280-380	-	-	-	170-220	160-200
M	4	SS - Ferritic / Martensitic	200-330	-	-	-	-	-
	5	SS - Austenitic	200-330	-	-	-	-	-
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	-	-	-
K	7	Malleable Cast Iron	130-230	-	190-340	180-320	180-320	170-300
	8	Grey Cast Iron	180-245	-	180-300	170-280	170-280	150-250
	9	Nodular Cast iron	160-250	-	140-250	130-250	100-240	90-210
N	10	Aluminium and Non Ferrous	30-130	350-1200	-	-	-	-
S	11	Heat Resistant Super Alloys	200-320	-	-	-	-	-

ISO	PSM	Material	HB (Brinell)	Vc (m/min) ← Wear Resistance			Toughness →	Feed fz (mm/t)	
				PH7930	PH5740	PHS740	PH7740	SNH(K)X 12...	ONH(K)X 05...
P	1	Unalloyed Steel	125-220	160-220	-	140-170	140-170	0,10-0,35	0,10-0,35
	2	Low-Alloyed Steel	220-280	150-180	-	130-160	130-160	0,10-0,35	0,10-0,35
	3	High-Alloyed Steel	280-380	130-160	-	110-140	110-140	0,10-0,30	0,10-0,30
M	4	SS - Ferritic / Martensitic	200-330	120-180	-	-	-	0,10-0,30	0,10-0,30
	5	SS - Austenitic	200-330	100-160	-	-	-	0,10-0,30	0,10-0,30
	6	SS - Austenitic-ferritic (Duplex)	230-260	70-140	-	-	-	0,10-0,25	0,10-0,25
K	7	Malleable Cast Iron	130-230	160-280	170-300	-	130-250	0,10-0,35	0,10-0,35
	8	Grey Cast Iron	180-245	140-240	150-260	-	110-220	0,10-0,35	0,10-0,35
	9	Nodular Cast iron	160-250	90-200	130-220	-	80-170	0,10-0,30	0,10-0,30
N	10	Aluminium and Non Ferrous	30-130	-	-	-	-	0,10-0,35	-
S	11	Heat Resistant Super Alloys	200-320	30-75	-	-	-	0,07-0,20	0,07-0,18

(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... and PHS... can be used wet or dry. PH7... use only air.

CHIP-BREAKER SELECTION GUIDE | Guia para aplicações do quebra-aparas | Guía para aplicación del rompevirutas

ISO	PSM	Material	HB (Brinell)	Chip-Breaker Application	
				1st choise	Dificult Operations
P	1	Unalloyed Steel	125-220	LP	MP
	2	Low-Alloyed Steel	220-280	LP	MP
	3	High-Alloyed Steel	280-380	MP	-
M	4	SS - Ferritic / Martensitic	200-330	LP	MP
	5	SS - Austenitic	200-330	LP	-
	6	SS - Austenitic-ferritic (Duplex)	230-260	LP	-
K	7	Malleable Cast Iron	130-230	MK	-
	8	Grey Cast Iron	180-245	MK	-
	9	Nodular Cast iron	160-250	MK	-
N	10	Aluminium and Non Ferrous	30-130	LN	-
S	11	Heat Resistant Super Alloys	200-320	LP	-

VIDEO

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