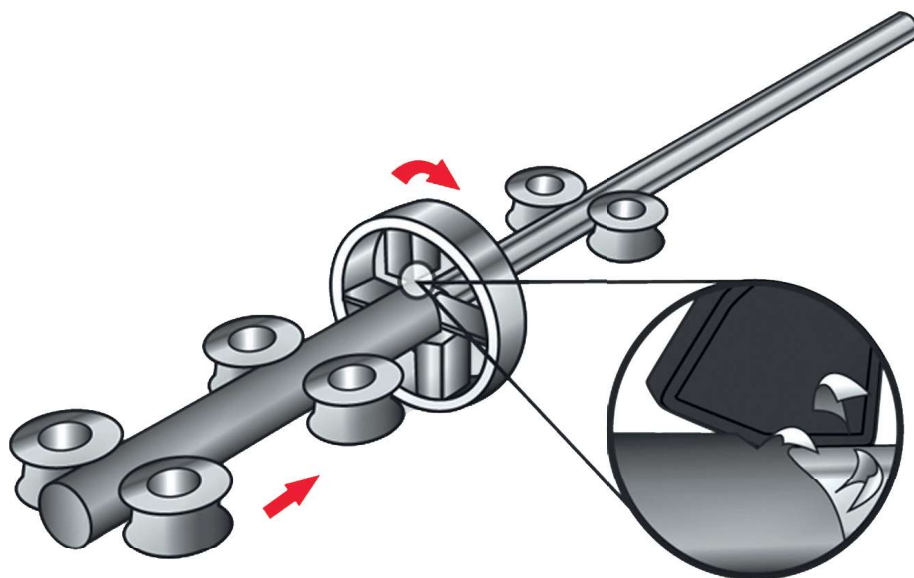


BAR PEELING INSERTS

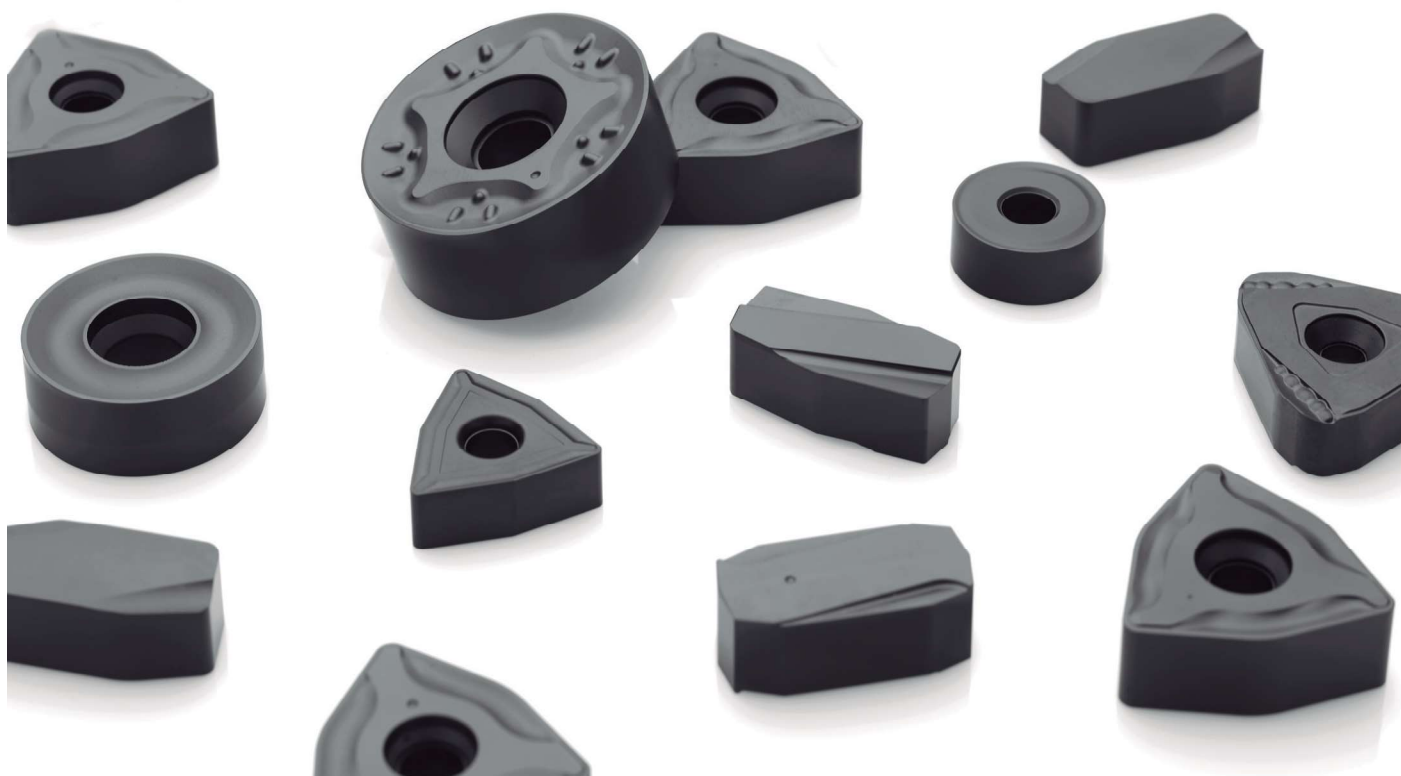
Bar Peeling is the machining process by which a raw forged blank is converted into a polished bar. During this peeling process, surface cracks and oxide layers are removed giving a perfect roundness with good surface and dimensional accuracy to the bar. The range of materials that can be machined with these tools is vast and goes from all kind of Steels to Cast Iron parts.



The size of blank bar can go from 4 mm (157 inch) to over 400 mm (15.75 inch) in diameter.

The surface quality and dimensional tolerances are also high, which leads to less machining at later stages.

Our aim is at the same time improving your productivity (by removing maximal chips volume) and, at the same time, matching or surpassing your surface quality requirements. This is why our Bar Peeling program is vast, comprising both standard tools and also special custom-made solutions to every customer needs. Please don't hesitate to contact us regarding other possible geometries that we may have although not presented in this catalogue.



BAR PEELING INSERTS IDENTIFICATION SYSTEM

Sistema de identificação para pastilhas de torneamento de barra | Codificación para plaquitas de torneado de barra

L	N	G	F	20	10	35	-	MP
1	2	3	4	5	6	7		8

1 - Insert Shape				
I	J	L	R	S
T	U	W	X	

2 - Clearance Angle

5 - Length of Cutting Edge (LE)	
The length of the secondary cutting edge is indicated in mm	
13 mm	25 mm
14 mm	27 mm
15 mm	28 mm
17 mm	38 mm
20 mm	44 mm
22 mm	50 mm

3 - Tolerances			
symbol	m (mm)	d (mm)	s (mm)
A	±0.005	±0.025	±0.025
F	±0.005	±0.013	±0.025
C	±0.013	±0.025	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
J	±0.005	±0.05~±0.13	±0.025
K*	±0.013	±0.05~±0.13	±0.025
L*	±0.025	±0.05~±0.13	±0.025
M*	±0.08~±0.20	±0.05~±0.13	±0.13
N*	±0.08~±0.20	±0.05~±0.13	±0.025
U*	±0.13~±0.38	±0.08~0.25	±0.13

* As a rule, the sides of these inserts are as sintered.
Tolerance differs with insert size, for the accuracy of Class M, refer to the table on the right.

8 - Chip Breaker	
Chip breaker according to Palbit geometries	
FP	MH
ST	RP
MP	LH

4 - Insert type				
symbol	Type	Type of hole	Chip breaker	Shape
W	with hole	Round hole / one countersink (40°~60°)	Without chip breaker	
T	with hole		Chip breaker on one side	
Q	with hole	Round hole / one countersink (40°~60°)	Without chip breaker	
U	with hole		Chip breaker on both sides	
B	with hole	Round hole / one countersink (70°~90°)	Without chip breaker	
H	with hole		Chip breaker on one side	
C	with hole	Round hole / double countersink (70°~90°)	Without chip breaker	
J	with hole		Chip breaker on both sides	
A	with hole	Round hole	Without chip breaker	
M	with hole		Chip breaker on one side	
G	with hole		Chip breaker on both sides	
N	without hole	--	Without chip breaker	
R	without hole	--	Chip breaker on one side	
F	without hole	--	Chip breaker on both sides	
X	-	-	--	On request

6 - Thickness (S)
The length of the secondary cutting edge is indicated in mm
08 = 8,00 mm
09 = 9,52 mm
10 = 10,00 mm
12 = 12,00 mm
12 = 12,70 mm
13 = 13,00 mm
14 = 14,00 mm
18 = 18,00 mm

7 - Depth of Cut (AP)
Maximum depth of cut
20 = 2,00 mm
25 = 2,50 mm
35 = 3,50 mm
40 = 4,00 mm
80 = 8,00 mm

			P										M						K			
			CVD										CVD						CVD			
		⁽²⁾ Grade code	L7	R2	L8	R3	U5	P1	V8	N2	S9	L9	U4	L8	U5	N2	P1	V8	V6	L5	L6	L9
Inserts Pastilhas Plaquetas	⁽¹⁾ Geometry code	ISO / ANSI Reference	PH5115	PHG115	PH5125	PHG125	PHS225	PH5228	PHS228	PH5135	PHG135	PH5740	PHS215	PH5125	PHS225	PH5135	PH5228	PHS228	PHS240	PH5705	PH5320	PH5740
 INGR-MP Rectangular 90°	1123828	INGR 221240-MP	⊗	○	○									○								
 JNGF-MP Rectangular 90°	1123830	JNGF 201220-MP	○		⊗	○					○			⊗								
	1123996	JNGF 201220-MP SP1			○									○								
	1123997	JNGF 201220-MP SP2	⊗		⊗									⊗							○	
	1124043	JNGF 271220-MP			⊗							○		⊗								○
 JNGF-PM Rectangular 90°	1124452	JNGF 201220-PM		○									⊗									
	1124567	JNGF 201220-PM SP		○																		
 LNGF-MP Rectangular 90°	1123826	LNGF 201035-MP	○	⊗	○			○						○			○				⊗	
	1123827	LNGF 201235-MP	○	○	○									○								
 UNGF-MP Rectangular 90°	1123829	UNGF 171240-MP	○		○	⊗								○								
 TNMJ-MP Triangular 60°	1123838	TNMJ 201025-MP	⊗	⊗	⊗	⊗	⊗							⊗	⊗							
	1123843	TNMJ 201425-MP			⊗	○								⊗								
 TNGM-MP Triangular 60°	1124104	TNGM 220812-MP			⊗					⊗				⊗		⊗						
 TNMM-LH Triangular 60°	1124102	TNMM 441116-LH								○	⊗					○						

⊗ First choice | 1ª Escolha | 1ª Opción

○ Available under request | Disponível sob consulta | Disponible bajo consulta

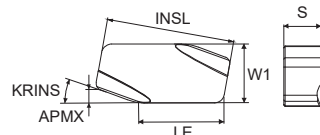
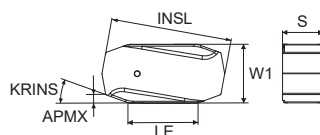
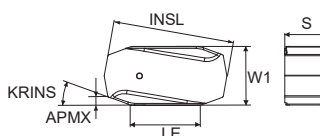
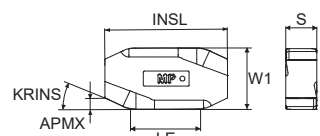
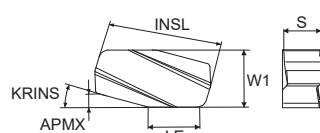
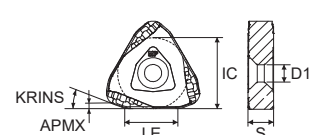
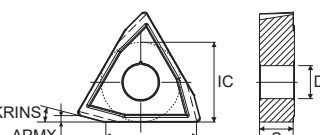
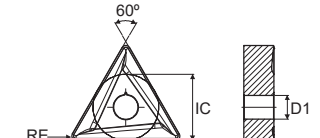
Insert Order Code: (1) Geometry code + (2) Grade code

⊗ Stock Items | Itens de stock

⊗ Stock available until sold out | Stock disponível até acabar o stock | Stock disponible hasta acabar el stock

BAR PEELING INSERTS RANGE

Negative inserts | Pastilhas negativas | Plaquetas negativas

Dimensions (mm) Dimensões (mm) Dimensiones (mm)									Cutting Conditions Condições de Corte Condiciones de Corte						Technical Drawing Desenho Técnico Diseño Técnico	
INSL	IC	LE	W1	S1	D1	RE	APMX	KRINS	AP (mm)	MIN	MAX	FN (mm/r)	MIN	MAX		
38,25	-	22,00	17,50	12,00	-	-	4,00	20	2,00	0,40	4,00	3,50	1,00	8,00		
36,90	-	20,00	18,00	12,35	-	-	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00		
36,30	-	20,00	18,00	12,45	-	-	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00		
36,50	-	20,00	18,00	12,45	-	-	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00		
36,90	-	27,00	18,00	12,45	-	-	2,00	20	1,50	1,00	2,00	3,50	1,50	6,00		
37,52	-	21,00	18,00	12,45	-	-	3,00	20	1,50	1,00	2,00	4,00	2,00	6,00		
37,52	-	21,00	18,00	12,45	-	-	3,00	20	1,50	1,00	2,00	4,00	2,00	6,00		
40,00	-	20,00	20,00	10,00	-	-	3,50	25	2,00	0,80	3,50	2,50	1,00	6,50		
40,00	-	20,00	20,00	12,00	-	-	3,50	25	2,00	0,80	3,50	2,50	1,00	6,50		
36,50	-	17,00	18,00	12,00	-	-	4,00	15	1,50	0,35	4,00	2,00	1,00	5,00		
-	28,60	20,00	-	10,00	7,00	-	2,50	20	1,00	0,70	2,50	3,00	1,00	5,50		
-	28,60	20,00	-	14,00	7,00	-	2,50	20	1,00	0,70	2,50	3,00	1,00	5,50		
-	19,05	22,00	-	8,00	7,96	-	1,20	15	0,70	0,20	1,30	14,00	5,00	18,00		
-	25,40	41,70	-	11,50	9,20	1,60	-	-	12,00	2,00	25,00	0,80	0,50	1,60		

			P										M							K		
			CVD										CVD							CVD		
		⁽²⁾ Grade code	L7	R2	L8	R3	U5	P1	V8	N2	S9	L9	U4	L8	U5	N2	P1	V8	V6	L5	L6	L9
Inserts Pastilhas Plaquitas	⁽¹⁾ Geometry code	ISO / ANSI Reference	PH5115	PHG115	PH5125	PHG125	PHS225	PH5228	PHS228	PH5135	PHG135	PH5740	PHS215	PH5125	PHS225	PH5135	PH5228	PHS228	PHS240	PH5705	PH5320	PH5740
XNMJ-MP																						
	1123835	XNMJ 151380-MP	○		⊗			⊗		○				⊗		○	⊗					
Special 85°																						
XNMJ-MH																						
	1123836	XNMJ 151380-MH	○	○	⊗			⊗				○		⊗			⊗					○
Special 85°																						
XNGF-FP																						
	1123837	XNGF 150980-FP			○					○				○		○	⊗					
Special 85°																						
XNGJ-RP																						
	1123834	XNGJ 151380-RP			○									○			⊗					
Special 85°																						
WNGJ-MP																						
	1124041	WNGJ 130950-MP			⊗	○		⊗						⊗			⊗			○	⊗	
Special 75°																						
RNMX-MP																						
	1123831	RNMX 381200-MP	○		○	⊗			○					○			⊗		○			
Round R°	1123832	RNMX 5018M0-MP	○		○				⊗					○			○	⊗				
RNMX-RP																						
	1123833	RNMX 5018M0-RP	○		○				○					○			⊗		○			
Round R°																						

⊗ First choice | 1ª Escolha | 1ª Opción

○ Available under request | Disponível sob consulta | Disponible bajo consulta

Insert Order Code: (1) Geometry code + (2) Grade code

⊗ Stock Items | Itens de stock

⊗ Stock available until sold out | Stock disponível até acabar o stock | Stock disponible hasta acabar el stock

BAR PEELING INSERTS RANGE

Negative inserts | Pastilhas negativas | Plaquitas negativas

Dimensions (mm) Dimensões (mm) Dimensiones (mm)									Cutting Conditions Condições de Corte Condiciones de Corte						Technical Drawing Desenho Técnico Diseño Técnico
INSL	IC	LE	W1	S1	D1	RE	APMX	KRINS	AP (mm)	MIN	MAX	FN (mm/r)	MIN	MAX	
-	31,75	15,00	-	13,00	9,00	-	8,00	25,00	3,00	1,00	6,50	6,00	4,00	12,00	
-	31,75	15,00	-	13,00	9,00	-	8,00	25,00	3,00	1,00	6,50	6,00	4,00	12,00	
-	28,58	15,00	-	8,88	-	-	8,00	30,00	3,00	1,00	4,50	6,00	4,00	12,00	
-	31,75	15,00	-	13,00	9,00	-	8,00	25,00	3,00	1,00	6,50	6,00	4,00	12,00	
-	22,23	13,00	-	9,56	7,93	-	5,00	15,00	3,00	0,50	5,00	6,00	3,00	11,00	
-	38,10	-	-	12,70	13,00	-	-	-	4,00	2,00	8,00	2,00	1,00	4,00	
-	50,00	-	-	18,00	12,70	-	-	-	6,00	2,00	12,00	3,50	2,50	6,50	
-	50,00	-	-	18,00	12,70	-	-	-	6,00	2,00	12,00	6,00	4,00	10,50	