



# TGPLUS

## 90390 | LNXT 1506..

High performance  
tangential shoulder milling



## Cutters

- Excellent machining stability.
- Available in regular and fine pitch cutters.
- Internal coolant supply up to 125 mm.

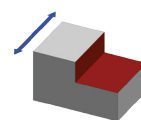
## Specifications

- Geometry: 90° tangential milling.
- Cutter diameter:
  - Arbor Mounting (A): Ø50 till Ø160.
- Workpiece materials: Steel, stainless steel, cast iron and HRSA.

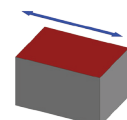
## Inserts

- Robust geometry.
- Tangential insert with 4 corners available.
- High rake angle insert reduces cutting force.
- Improved pocket configuration.

## Applications



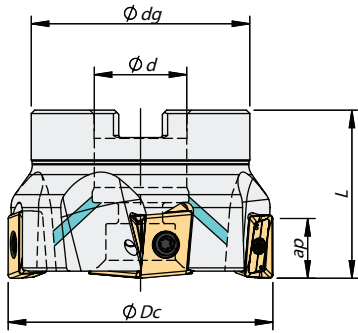
Shouldering



Facing

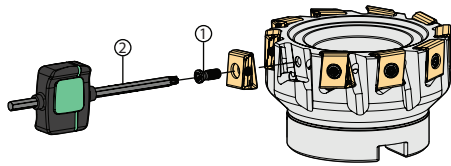
$K_r = 90^\circ$   
 $\gamma_p = -5^\circ$

## Arbor Mounting



Order Code	Reference		Dimensions (mm)				Arbor Style	$a_p$ Max.	Stock
			$\phi Dc$	$\phi d$	$\phi dg$	L			
181069200	050A90390-05-05-022040	5	050	22	42	40	A	14,00	
181066400	063A90390-05-05-022040	5	063	22	52	40	A		
181051000	063A90390-08-05-022040	8	063	22	52	40	A		
181066500	080A90390-07-05-027050	7	080	27	60	50	B		
181052000	080A90390-10-05-032050	10	080	27	60	50	B		
181066600	100A90390-08-05-032050	8	100	32	80	50	B		
181051100	100A90390-12-05-032050	12	100	32	80	50	B		
181066700	125A90390-09-05-040063	9	125	40	90	63	B		
181051200	125A90390-15-05-040063	15	125	40	90	63	B		
181051300	160A90390-10-05-U040063	10	160	40	110	63	C		
181066800	160A90390-20-05-U040063	20	160	40	110	63	C		

## Screws & Keys



Item	1	2
Cutter $\phi Dc$	Insert Screw	Key (Torx)
A90390 - 50 - 160	P0401200	XT15
		Torque Value
		3,0

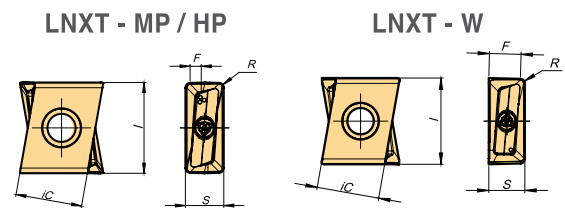
## LNXT 1506..

(1) Geometry	(2) Grade Code	P		M		K			S			Dimensions (mm)						
		54	68	I5	78	68	I5	54	68	I5	54	68	78	IC	S	I	R	F
		PH6910	PH6920	PH6740	PH6125	PH6920	PH6740	PH6910	PH6920	PH6740	PH6910	PH6920	PH6125					
1111313	LNXT 150608 PNER-MP												11,00	6,35	15,0	0,8	1,8	
1111591	LNXT 150608 PNSR-HP												11,00	6,35	15,0	0,8	1,8	
1111524	LNXT 150608 PNER-W												11,00	6,35	15,2	0,8	5,5	
1111590	LNXT 150612 PNER-MP												11,00	6,35	15,0	1,2	1,8	

Stock items / Itens de stock Available under request / Disponibilidade sob consulta / Disponible bajo consulta  
Order code = (1) Geometry Code + (2) Grade Code

## Chip Breaker

Chip Breaker	Features
Geometry <b>MP</b> Gen. machining of steels	Chip-breaker with a reinforced chanfer for general applications on steels.
Geometry <b>HP</b> Heavy machining of steels	Chip-breaker with a reinforced chanfer for medium to heavy cutting conditions.
Geometry <b>W</b> Wiper	Chip-breaker wiper for the best finishing solutions.



## Rec. Cutting Conditions

ISO	HB (Brinell)	Vc (m/min)				fz (mm/t)	
		PH6910	PH6920	PH6740	PH6125		
P	Unalloyed Steel	125 - 220	160 - 220	150 - 210	100 - 170	140 - 200	0,10 - 0,30
	Low-Alloyed Steel	220 - 280	150 - 210	140 - 200	90 - 160	130 - 180	0,10 - 0,30
	High-Alloyed Steel	280 - 380	140 - 190	130 - 180	80 - 140	100 - 170	0,10 - 0,30
M	Stainless Steel	200 - 330	-	100 - 190	80 - 150	-	0,10 - 0,35
K	Malleable Cast Iron	130 - 230	160 - 260	150 - 250	100 - 200	-	0,10 - 0,40
	Grey Cast Iron	180 - 245	130 - 220	120 - 200	110 - 210	-	0,10 - 0,40
	Nodular Cast Iron	160 - 250	90 - 180	80 - 170	80 - 140	-	0,10 - 0,40
S	Heat Resistant Super Alloys	200 - 320	20 - 90	20 - 80	-	20 - 70	0,10 - 0,20