

**Garant**
**RPKW 1204MOT, HB7515, Type: ST1400**


## Order data

Order number	212054 ST1400
GTIN	4062406390372
Item class	21A

## Description

### Version:

**All indexable inserts are suitable for use with carriers that are 0° negative and also with carriers that are 7° positive.**

### Note:

Standard application values for  $a_e = 0.3 \times D$  /  $a_p = 1.2$  mm.

In order to use all six cutting edges, an  $a_p$  of 3 mm must not be exceeded.

Feed  $f_z$  per tooth: 0.35 mm

ISO code indexable insert: RPKW 1204MOT

Type: ST1400

## Technical description

Tool material	Carbide
Type	ST1400
ISO code indexable insert	RPKW 1204MOT
Grade	HB7515
Feed $f_z$ per tooth	0.35 mm

Number of changes/inserts	6
Type of product	Indexable insert for milling

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 750 N/mm <sup>2</sup>	suitable	330 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	260 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	230 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	180 m/min	P
GG(G)	suitable	220 m/min	K
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		
Air	suitable		