

Garant
APMT 100308 TR, HB7515, Type: ST1400

Order data

Order number	215885 ST1400
GTIN	4045197601780
Item class	21A

Description
Version:

Inserts with highly positive geometry and helical cutting edges.

Note:

Standard application values apply for indexable milling cutters No. 215800, 215803, 215850, 215853 and 215870.

For $a_e = 0.3 \times D$ / $a_p \text{ max} = 4.8 \text{ mm}$.

Insert thickness: 3.5 mm

Corner radius: 0.8 mm

Feed f_z per tooth: 0.1 mm

Technical description

Type	ST1400
Feed f_z per tooth	0.1 mm
Corner radius	0.8 mm
ISO code indexable insert	APMT 100308 TR
Grade	HB7515

Tool material	Carbide
Insert thickness	3.5 mm
Type of product	Indexable insert for milling

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	440 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	310 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	260 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	250 m/min	P
Steel < 1400 N/mm ²	suitable	230 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	320 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	210 m/min	M
GG(G)	suitable only under restricted conditions	210 m/min	K
Oil	suitable		
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		