


**APPT 100308 PDSR, HBM020, Type: UNI**

**Order data**

Order number	215888 UNI
GTIN	4067263002055
Item class	22A

**Description**
**Version:**

PVD-coated carbide indexable inserts for machining various materials. The universal tool material enables reliable working under changing operating conditions. These indexable inserts are characterised by a high degree of wear resistance and tensile strength as well as the possibility for use for wet and dry machining.

**Note:**

Standard application values for  $a_e = 0.3 \times D$ .

$a_{p_{max}} = 4.8 \text{ mm}$ .

**Technical description**

Corner radius	0.4 mm
Grade	UNI
Feed $f_z$ per tooth	0.12 – 0.27 mm
ISO code indexable insert	APPT 100308 PDSR
Grade	HBM020

Tool material	Carbide
Insert thickness	3.56 mm
Type of product	Indexable insert for milling

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	290 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	250 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	130 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	180 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	120 m/min	M
GG(G)	suitable	180 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		