

**X.LT..ER-D41, SC6525, Indexable insert size: 09mm****Order data**

Order number	221927 09
GTIN	2050002058620
Item class	28E

**Description****Version:**

Particularly thick indexable inserts with ground wiper chamfer.

**Note:**

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

**Technical description**

Indexable insert size	09
Type	ST1400
ISO code indexable insert	XDLT090408-ER-D41
Programming radius at $a_{p\max}$	2.01 mm
Corner radius	0.8 mm
Grade	SC6525
Tool material	Carbide
Feed $f_z$ per tooth	0.2 - 2.5 mm

Number of changes/inserts	4
Type of product	Indexable insert for milling

## User data

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
Steel < 500 N/mm <sup>2</sup>	suitable	340 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	260 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	210 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	155 m/min	P
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		