

**X.LT...ER-D411, SP6519, Indexable insert size: 09mm****Order data**

Order number	221928 09
GTIN	2050002058637
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	INOX; Ti
ISO code indexable insert	XDLT090412-ER-D411
Programming radius at $a_{p\max}$	2.27 mm
Corner radius	1.2 mm
Grade	SP6519
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

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	280 m/min	P
Steel < 750 N/mm ²	suitable	250 m/min	P
Steel < 900 N/mm ²	suitable	185 m/min	P
Steel < 1100 N/mm ²	suitable	150 m/min	P
Steel < 1400 N/mm ²	suitable	130 m/min	P
INOX < 900 N/mm ²	suitable	210 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	160 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	50 m/min	S
GG(G)	suitable only under restricted conditions	220 m/min	K
Uni	suitable		
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		