


**X.LW...SR-S, SC6525, Indexable insert size: 09mm**

**Order data**

Order number	221926 09
GTIN	2050001735188
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**

Type	ST1400
Indexable insert size	09
ISO code indexable insert	XDLW090408-SR-D
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 - 3 mm

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

### User data

	Suitability	V <sub>c</sub>	ISO code
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		