

**SEKN 1203 AFTN, HB7515, Type: ST1400****Order data**

Order number	213951 ST1400
GTIN	4045197553867
Item class	21A

**Description****Note:**

Standard application values for  $a_e = 0.5 \dots 1 \times D$  /  $a_{p \max} = 3.5$  mm.

**Technical description**

Feed $f_z$ per tooth	0.19 mm
Type	ST1400
Insert thickness E	3.18 mm
ISO code indexable insert	SEKN 1203 AFTN
Grade	HB7515
Tool material	Carbide
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 only under restricted conditions	290 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	210 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	170 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	150 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	210 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	140 m/min	M
GG(G)	suitable only under restricted conditions	130 m/min	K
Oil	suitable		
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		