

Garant
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.

Feed f_z per tooth: 0.19 mm

Technical description

Feed f_z per tooth	0.19 mm
Type	ST1400
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

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	290 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	210 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	170 m/min	P
Steel < 1100 N/mm ²	suitable	160 m/min	P
Steel < 1400 N/mm ²	suitable	150 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	210 m/min	M
INOX > 900 N/mm ²	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		