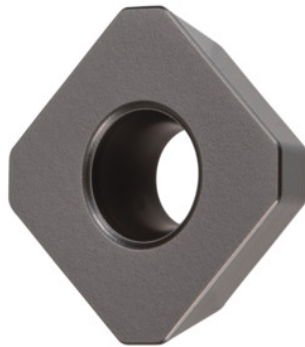


**Garant**
**SDHX 0903 AFTN, HB7515, Type: ST1400**


## Order data

Order number	214439 ST1400
GTIN	4045197554413
Item class	21A

## Description

### Version:

- **Indexable inserts for higher cutting speeds and feed rates.**
- **Precision sintered and ground for best surface finish quality.**
- **Micro-grain structure gives high strength and wear resistance.**

### Note:

Standard application values for  $a_e = 0.5 \dots 1 \times D$  /  $a_{p \max} = 3$  mm.

Feed  $f_z$  per tooth: 0.14 mm

## Technical description

Feed $f_z$ per tooth	0.14 mm
Type	ST1400
ISO code indexable insert	SDHX 0903 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	410 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	290 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	240 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	220 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	190 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	300 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	190 m/min	M
GG(G)	suitable only under restricted conditions	190 m/min	K
Oil	suitable		
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		