


APKT 1003 PDER, HBM025, Type: UNI

Order data

Order number	215886 UNI
GTIN	4067263982067
Item class	22A

Description
Version:

Inserts with highly positive geometry and helical cutting edges.

Note:

Standard application values apply for indexable milling cutters No. 215800, 215803, 215850, 215853 and 215870.

For $a_e = 0.3 \times D$ / $a_p \text{ max} = 4.8 \text{ mm}$.

Insert thickness: 3.5 mm

Corner radius: 0.5 mm

Technical description

Corner radius	0.5 mm
Type	UNI
ISO code indexable insert	APKT 1003 PDER
Grade	HBM025
Tool material	Carbide

Insert thickness	3.5 mm
Coating	coated
Type of product	Indexable insert for milling

User data

	Suitability	V_c	ISO code
Alu > 10% Si	suitable only under restricted conditions	220 m/min	N
Steel < 500 N/mm ²	suitable	330 m/min	P
Steel < 750 N/mm ²	suitable	255 m/min	P
Steel < 900 N/mm ²	suitable	205 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	175 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	70 m/min	P
INOX < 900 N/mm ²	suitable	160 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	155 m/min	M
GG(G)	suitable	150 m/min	K
Uni	suitable		
dry	suitable		