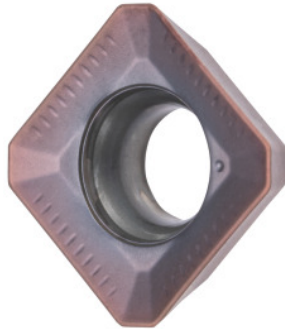


Garant**SEKT 1204 AFTN, HB725, Type: UNI****Order data**

Order number	214312 UNI
GTIN	4067263095286
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

Type	UNI
Insert thickness E	4.76 mm
ISO code indexable insert	SEKT 1204 AFTN
Grade	HB725
Tool material	Carbide
Number of changes/inserts	4
Type of product	Indexable insert for milling

User data

Data sheet

	Suitability	V_c	ISO code
Alu > 10% Si	suitable only under restricted conditions	450 m/min	N
Steel < 500 N/mm ²	suitable	280 m/min	P
Steel < 750 N/mm ²	suitable	260 m/min	P
Steel < 900 N/mm ²	suitable	240 m/min	P
Steel < 1100 N/mm ²	suitable	160 m/min	P
Steel < 1400 N/mm ²	suitable	120 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	30 m/min	H
INOX < 900 N/mm ²	suitable	190 m/min	M
INOX > 900 N/mm ²	suitable	130 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	45 m/min	S
GG(G)	suitable only under restricted conditions	170 m/min	K
wet maximum	suitable only under restricted conditions		
dry	suitable		