


**SPMT 1806 EDER-NB3P, PR1835, Type: ST1400**

**Order data**

Order number	224025 ST1400
GTIN	4960664030101
Item class	25A

**Description**
**Version:**

Special indexable insert geometry ensures reduced cutting forces and improved chip breaking. All types with **wiper cutters** for high feed rates.

**Application:**

**NB2P / NB3P:** For **reduced cutting forces**. Specially for large overhangs and thin workpieces.

**Note:**

**The milling cutters are alternately equipped with equal numbers of indexable inserts of forms NB2 and NB3.** Comply with the assignment instructions on the cutter.

Standard application values for  $a_e = 1 \times D$ .

**Technical description**

Feed $f_z$ per tooth	0.06 – 0.15 mm
Insert thickness E	6.35 mm
Type	ST1400
Corner radius	1.2 mm
ISO code indexable insert	SPMT 1806 EDER-NB3P

Grade	PR1835
Tool material	Carbide
Application	soft-cutting
Number of changes/inserts	4
Type of product	Indexable insert for milling

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	180 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	160 m/min	P
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		