


SPMT 1806 EDER-NB2P, PR1835, Type: ST1400

Order data

Order number	224024 ST1400
GTIN	4960664030088
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

Corner radius	1.2 mm
Feed f_z per tooth	0.06 – 0.3 mm
Insert thickness E	6.35 mm
Type	ST1400
ISO code indexable insert	SPMT 1806 EDER-NB2P

Grade	PR1835
Tool material	Carbide
Application	soft-cutting
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	200 m/min	P
Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	180 m/min	P
Steel < 1100 N/mm ²	suitable	160 m/min	P
Steel < 1400 N/mm ²	suitable	160 m/min	P
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		