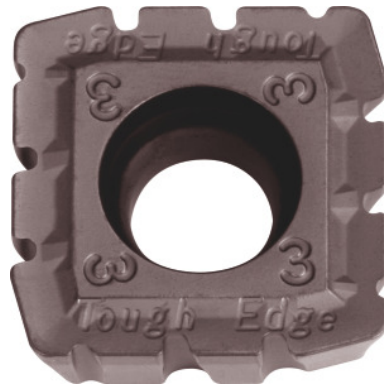



SPMT 1806 EDSR-NB3T, PR1835, Type: ST1400

Order data

| | |
|--------------|---------------|
| Order number | 224019 ST1400 |
| GTIN | 4960664030132 |
| 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:

NB2T / NB3T: Ideal for **interrupted cutting**, high cutting speeds and high feed rates.

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 – 0.25 mm |
| Insert thickness E | 6.35 mm |
| Corner radius | 1.2 mm |
| Type | ST1400 |
| ISO code indexable insert | SPMT 1806 EDSR-NB3T |

| | |
|---------------------------|------------------------------|
| Grade | PR1835 |
| Tool material | Carbide |
| Application | Roughing |
| 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 | | |