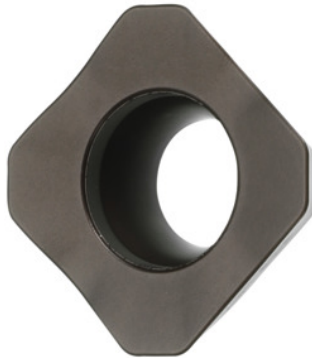


**Garant****Indexable insert for milling SEKT 1204 AFTN, for face mills, HB7525****Order data**

Order number	214242 ST900
GTIN	4045197553881
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**

Feed $f_z$ per tooth	0.19 mm
Type	ST900
Insert thickness E	4.76 mm
ISO code indexable insert	SEKT 1204 AFTN
Type	HB7525
Tool material	Carbide
Number of changes/inserts	4
Type of product	Indexable insert for milling

## User data

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
Steel < 500 N/mm <sup>2</sup>	suitable	290 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	170 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	160 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	150 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	190 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	120 m/min	M
GG(G)	suitable only under restricted conditions	130 m/min	K
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
wet minimum	suitable		
dry	suitable		
Air	suitable		