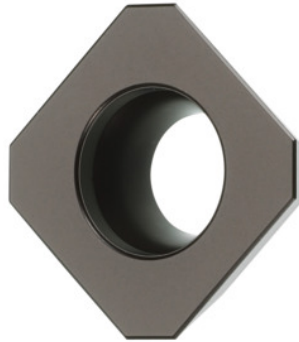


Garant**Indexable insert for milling SEKW 1204 AFTN, for face mills, HB7515****Order data**

Order number	214292 ST1400
GTIN	4045197553898
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	ST1400
Insert thickness E	4.76 mm
ISO code indexable insert	SEKW1204-AFTN
Type	HB7515
Tool material	Carbide
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 only under restricted conditions	320 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	230 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	190 m/min	P
Steel < 1100 N/mm ²	suitable	180 m/min	P
Steel < 1400 N/mm ²	suitable	170 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	230 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	150 m/min	M
GG(G)	suitable only under restricted conditions	150 m/min	K
Oil	suitable		
wet maximum	suitable only under restricted conditions		
wet minimum	suitable only under restricted conditions		
dry	suitable		
Air	suitable		