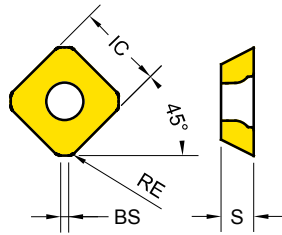


# Milling - Face Milling - Inserts

## SEKT - Face Milling Positive (4 Corners)



Series	IC	S
SEKT 1204	12.7	4.9
SEKT 12T3	13.4	4

### EDP 1200..

●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30				M35		
K30	K30			S30	H15	
S20						

SEKT 1204		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
SEKT 1204 General		SEKT 1204 AFTN	1.1	0.20 ~ 0.35	1.18	● 0055	● 0416					
		SEKT 1204 - ST	1.1	0.08 ~ 0.30	2.00	● 0257						
-ST Stainless Steel Super Alloy												

SEKT 12T3		Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
SEKT 12T3 General		SEKT 12T3 AGTN	1.5	0.15 ~ 0.30	1.30	● 0056						
		SEKT 12T3 - ST	1.5	0.08 ~ 0.30	2.00	● 0271						
-ST Stainless Steel Super Alloy												

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300	150	280	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	130	235	70	210	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	90	130	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	20	40	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	50	100	-	-	50	90	-	-