

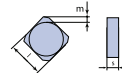
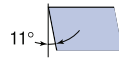


S

P

K

N



Shape
Square 90°

Clearance Angle
20°

Tolerance
l ± 0.08 m ± 0.013
s ± 0.025

Insert Type
Clamping
chip breaker

Insert designation	Grade	l	s	P/r	D	Direction	Catalog Nr.	Page
SPKN 1203 EDTR LT 30	12	3,18	75°	15°	Right	M0000046	201	
SPKN 1204 EDTR LT 30	12	4,76	75°	15°	Right	M0000047	201	
SPKN 1504 EDTR LT 30	15	4,76	75°	15°	Right	M0001673	202	

Surfacing Insert Lead angle 75°

Application Guide **Surfacing**



SPKN


Square inserts with 75° lead angle, designed for high depths of cut. Suitable for Roughing to Finishing Face milling operations.

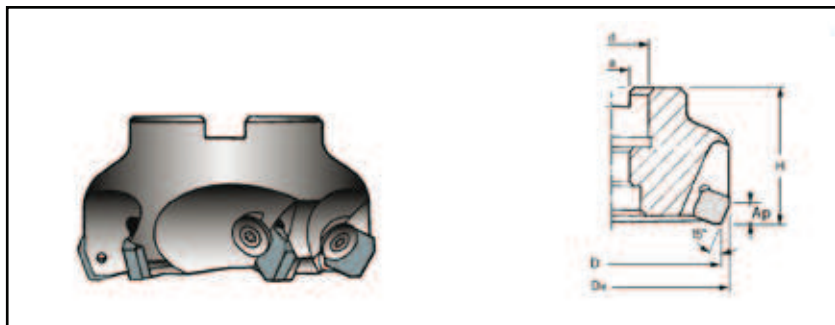


Machining Recommendation Guide - Please see Pg. 8



Catalog Nr.	Description	D	De	d	H	Ap	z
M2000571	LT 750 M-D63	63	69	22	40	9	4
M2000572	LT 750 M-D80	80	86	27	50	9	5
M2000574	LT 750 M-D100	100	106	32	50	9	7
M2000575	LT 750 M-D125	125	131	40	63	9	8
M2000576	LT 750 M-D160	160	166	40	63	9	10
M2000577	LT 750 M-D200	200	206	60	63	9	12
M2000578	LT 750 M-D250	250	256	60	63	9	14

Screw set: CVB 55 Key set: ET 4 



SPKN 1203 EDTR & SPKN 1204 EDTR

Machining conditions **Milling**

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	7	0.18	0.38	190	350
			180		7		0.38		300
			210		7		0.38		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	7	0.15	0.35	150	240
			230		7		0.35		210
			280	0.5	7	0.15	0.32	130	190
			320		7		0.32		170
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	7	0.12	0.32	90	150
			280		7		0.32		130
			320	0.5	7	0.12	0.28	60	110
			350		7		0.28		90
			400	0.5	5	0.1	0.22	40	80
			480		3		0.2		70
			550		1.5		0.28		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	SPKN inserts are not recommended for Stainless Steel					
	5	X2 CrNiMo 17 2 2 316	230 to 270						
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----						
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed						
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed Treated						
Grey Cast Iron	9	GG 20	140 to 230						
		GG 25		250					
		GG 30		210					
Nodular Cast Iron	10	GGG 40	210	0.5	7	0.12	0.3	120	210
		GGG 50	260						170
		GGG 70	310						150
		G-X260NiCr42	450						0.5
Nickel Based Alloys	11	Inconel 625	-----	SPKN inserts are not recommended for Exotic materials					
		Inconel 718							
		Hastelloy C							
Titanium Based Alloys	12	TiAl 6 V4	-----						
		T40							

SPKN



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Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	9	0.15	0.35	150	240
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			320	0.5	9	0.12	0.28	60	110
			350		9		0.28		90
			400	0.5	6	0.1	0.22	40	80
			480		3		0.2		70
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Grey Cast Iron	9	GG 20	140 to 230	0.5	9	0.15	0.38	170	300
		GG 25							250
		GG 30							210
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