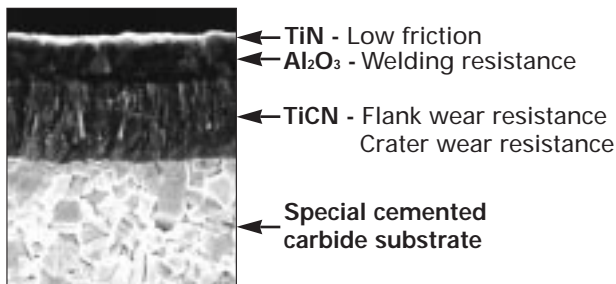


## *Coated carbide for cast iron milling* **F5010**

- A coating consisting of a crystal fiber layer of TiCN and a micro-grain layer of Al<sub>2</sub>O<sub>3</sub>.
- Special micro-grain cemented carbide with high hardness offers the ultimate in wear resistance and is best suited to high cutting rates.
- High cutting performance that displays excellent thermal shock resistance for wet cutting.



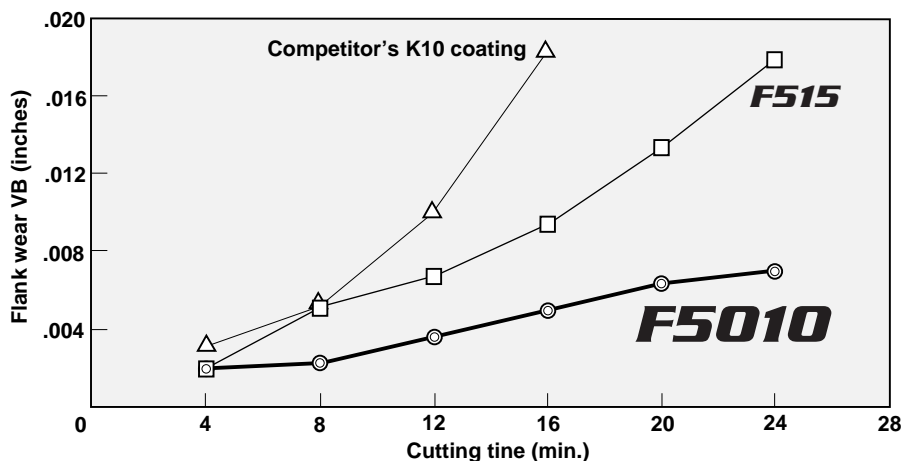
# COATED GRADE **F5010**



## RECOMMENDED CUTTING CONDITIONS

Workpiece		Cutting speed (SPM)
Grey cast iron		900 (600-1200)
Ductile Cast iron	<50kg/mm <sup>2</sup>	900 (600-1200)
	>50kg/mm <sup>2</sup>	490 (330-660)

## CUTTING PERFORMANCE



Workpiece : ANSI No.45B (HB140)  
 Insert : SEEN42AFTN1  
 Cutting speed : 820 (SFM)  
 Feed : .008 (IPT)  
 Depth of cut .10 (inches)  
 Wet cutting

USA	ISO	Application range
C4	K01	
C3	K10	
C2	K20	
C1	K30	

## STANDARD INSERTS

Shape	Class	Order Number	Stocked	Dimensions (inch)		
				I.C.	T	a
	M	SEEN42AFEN1	+	1/2	1/8	.055
		42AFSN1	+			
		53AFEN1	+	5/8	3/16	.055
		53AFSN1	+			
	M	SEER42AFEN-JS	+	1/2	1/8	.055
		53AFEN-JS	+	5/8	3/16	.055
	M	TEEN32PETR1	+	3/8	1/8	.055
		43PETR1	+	1/2	3/16	.055
	M	SPEN42EEER1		1/2	1/8	.055
		SPEN42EESR1	+			
	M	SPER42EEER-JS	+	1/2	1/8	.055

⊕ : Stock.

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