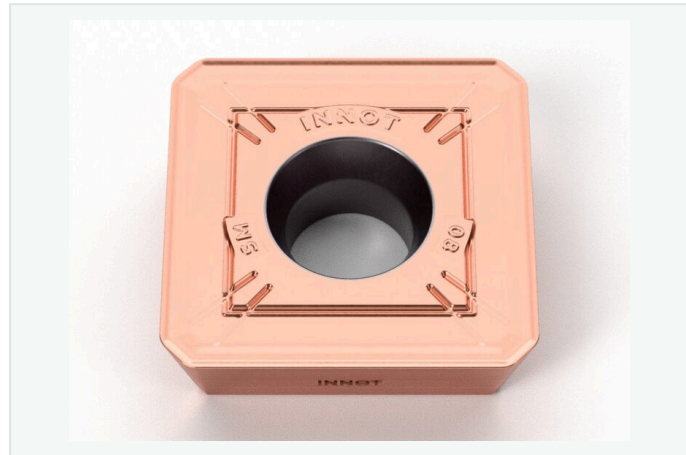


MILLING INSERTS · HIGH FEED

SDKT-SM

High-feed insert for stainless steels and superalloys, with SM chipbreaker and positive cutting edge.



KEY DATA

Product type	Milling Inserts
ISO materials	P steel M stainless K cast iron S superalloys
Operation	Roughing
INNOT grades	IT5120 · IT5130 ★ · IT7140 ★ · IT7240 ★ ★ recommended
Nose radii	R1.2 · R2
Online page	innot-it.com/en/prodotto/sdkt-sm

Specifications

Code	IC	S	D1	RE	APMX
SDKT09T312ZDER-SM	9.525	3.97	4.16	1.2	1.2
SDKT120520ZDER-SM	12.788	5	4.45	2	1.4

Dimensions in mm. IC = inscribed circle, S = thickness, D1 = hole, BS = wiper flat, RE = corner radius, AN = clearance angle, APMX = maximum depth of cut.

Technical data

Operation	Milling - High feed
Shape	Square
ISO material	P (steels), M (stainless steels), K (cast irons), S (superalloys and titanium)
Features	Positive version for difficult materials: stainless steels, titanium and superalloys in high-feed milling and ramping.
Compatible cutters	Indexable cutters with SDKT-SM seat: send us your cutter code and we will check compatibility.

Available INNOT grades

Grade	ISO	Coating	Composition	Application
IT5130 ★	P · M	PVD	AlTiN	High-efficiency milling of steels and stainless steels below 30 HRC. Specially formulated substrate that reduces the risk of chipping, with a latest-generation nano coating.
IT7140 ★	M · S	PVD	AlCrN	Milling of stainless steels, titanium alloys and superalloys. Substrate with special micro-elements: excellent toughness and high-temperature performance.
IT7240 ★	M · S	PVD	AlCrN	Milling of difficult materials: stainless steels, superalloys and titanium. High hot hardness, high toughness and resistance to fatigue fracture.
IT5120	P · M · K	PVD	TiAlN + CrAlN + TiSiN	Universal grade for steels, stainless steels and cast irons, also ideal on materials of 35-50 HRC. Excellent wear resistance and toughness, high hot hardness.

★ Recommended grade. Other grades are available on request.

Parametri e consigli d'uso

Guide values on mild steel with IT5120/IT5130: Vc 180 m/min (140-220), ap 1.2 mm (SDKT09) / 1.4 mm (SDKT12), fz 0.8 (0.6-1.5) / 1.2 (0.8-2.0) mm/tooth. When ramping the maximum angle ranges from 3° (Ø25) to 0.4° (Ø125).

INNOT · CUTTING TOOLS FOR CNC MACHINE SHOPS

Quote within 30 minutes

Send us the code or the drawing: we reply with price and availability. Free test inserts on request, 24/48h shipping.

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Scan to open the online page

Cutting data are indicative starting values: adjust them to machine, clamping, tool overhang and workpiece material. Data and images may change without notice.