

Product Brochure For L069

## TPKN 2204-PDTR - KYOCERA Carbide Inserts - Milling

Grade PR1225, General Purpose, 22mm  
 10 Inserts Per Pack

**Ex GST**  
**\$200.00**

**Inc GST**  
**\$220.00**



ORDER CODE:	L069
ISO:	TPKN 2204-PDTR
Grade:	PR1225
t (mm):	4.76
m (mm):	3.45
a (mm):	1.60
b (mm):	0.70
l (mm):	22
d (mm):	12.7
d1 (mm):	~
R (mm):	~
Quantity of Inserts (No.):	10

**KYOCERA**  
 JAPANESE CARBIDE



### Description

KYOCERA INDEXABLE MILLING INSERTS

### Features

- KYOCERA Grade PR1225 - Superior adhesion-resistant Tin base PVD coated carbide on special tough carbide substrate
- Application suitable for steel, stainless steel, cast iron and heat resistant alloys, low speed cutting
- 10 Inserts Per Pack

### PVD Coated Carbide

KYOCERA's PVD coated carbide grades are based on a ceramic thin film coating & precise cutting edge technologies. Very tough carbide substrate promoting excellent wear and strong coating adhesion for long life.

#### Features:

- Good for low to high speeds and finishing to heavy cutting
- Stable cutting with excellent toughness
- Good thermal conductivity
- Suitable for cutting non-ferrous metals and non-metals
- Stable cutting at low cutting speeds making it ideal for milling operations

### MILLING - Application Chart

RECOMMENDED CUTTING SPEEDS	COATING	PVD	UNCOATED
	Workpiece Material	PR1225 m/min	PW30 m/min
	Carbon Steel (SxxC)	120-160-200	80-150
	Alloy Steel (SCN etc.)	120-160-200	80-150
	Mild Steel (SKD/NAK etc.)	100-140-180	80-150
	Stainless Steel	~	80-120

### Specific Features



Tip

### Recommended Accessories

M503

Face Mill 90° - Positive Rake

M504

Face Mill 90° - Positive Rake

