



## Time-S4-Cut Insert

**FRANKEN**

Machining of Stainless Steel and Difficult to Cut Materials

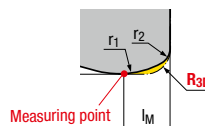
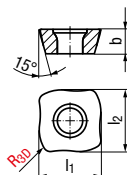
## Product advantages



- ▶ **Chip former**  
to improve chip formation and evacuation from the cutting edge
- ▶ **Optimised coating**  
to reduce built-up cutting edges and to improve chip flow
- ▶ **High-feed milling**  
of 2D and 3D contours

## Technical features

- Indexable insert with 4 cutting edges
- Special geometry for higher feed rates
- Chip former
- Carbide and ALCR-coating matched to each other



## Milling body


- Indexable screw-in end mill 9190
- Indexable milling cutter 9290

Article number	IC	R <sub>3D</sub>	r <sub>1</sub> / r <sub>2</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>M</sub>	b
<b>9592L.08515</b>	<b>8.5</b>	1.5	5 / 1	8.5	8.5	3	3.4

### Additional versions:



9584A.08515 for steel and 9583X.08515 for steel and cast iron

## Application


		V <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	
<b>M</b>	<b>Stainless steel materials</b>				
	1.1 Ferritic, martensitic	150	0.5	0.5	■
	2.1 Austenitic	150	0.5	0.5	■
	3.1 Austenitic-ferritic (Duplex)	100	0.35	0.5	■
	4.1 Austenitic-ferritic heat-resistant (Super Duplex)	100	0.35	0.5	■
<b>S</b>	<b>Special materials</b>				
	<b>Titanium alloys</b>				
	1.1 Pure titanium	70	0.5	0.5	■
	1.2 Titanium alloys	55	0.5	0.5	■
	1.3 Titanium alloys	55	0.5	0.5	■
	<b>Nickel alloys, cobalt alloys and iron alloys</b>				
	2.1 Pure nickel	45	0.3	0.5	■
	2.2 Nickel-base alloys	35	0.3	0.5	■
	2.3 Nickel-base alloys	35	0.3	0.5	■
	2.4 Cobalt-base alloys	35	0.3	0.5	■
	2.5 Cobalt-base alloys	35	0.3	0.5	■
2.6 Iron-base alloys	35	0.3	0.5	■	



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