



**Full profile insert 60°, external, right-hand, HBF20, Thread pitch: 2,5mm**



## Order data

|              |               |
|--------------|---------------|
| Order number | 271970 2,5    |
| GTIN         | 4062406592943 |
| Item class   | 22B           |

## Description

### Version:

Fully sintered.

## Technical description

|                 |                                     |
|-----------------|-------------------------------------|
| Thread pitch    | 2.5 mm                              |
| Tool material   | Carbide                             |
| Type            | HBF20                               |
| Tolerance class | DIN 13 6H                           |
| Thread type     | M                                   |
| Thread type     | MF                                  |
| Flank angle     | 60 degrees                          |
| Thickness       | 3.68 mm                             |
| Insert size L   | 16 mm                               |
| Type of product | Indexable insert for thread turning |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|-------------------------------------------|----------------|----------|
| Aluminium (short chipping)     | suitable                                  | 220 m/min      | N        |
| Alu > 10% Si                   | suitable                                  | 150 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 120 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 120 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 120 m/min      | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 85 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 75 m/min       | P        |
| Steel < 55 HRC                 | suitable only under restricted conditions | 35 m/min       | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 60 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 60 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable only under restricted conditions | 40 m/min       | S        |
| GG(G)                          | suitable                                  | 110 m/min      | K        |
| CuZn                           | suitable only under restricted conditions | 130 m/min      | N        |
| continuous                     | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| dry                            | suitable only under restricted conditions |                |          |