

**Full profile insert 55°, internal, right-hand, HBF20, TPI: 14****Order data**

|              |               |
|--------------|---------------|
| Order number | 271980 14     |
| GTIN         | 4062406593056 |
| Item class   | 22B           |

**Description****Version:**

Fully sintered.

**Technical description**

|                 |                                     |
|-----------------|-------------------------------------|
| Thread pitch    | 14 mm                               |
| Tool material   | Carbide                             |
| Type            | HBF20                               |
| Thread type     | BSW                                 |
| Thread type     | BSP                                 |
| Thread type     | G                                   |
| Flank angle     | 55 degrees                          |
| Thickness       | 3.68 mm                             |
| Insert size L   | 16 mm                               |
| Type of product | Indexable insert for thread turning |

## User data

|                                | Suitability                               | $V_c$     | 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 |           |          |