


simturn AX axial grooving insert, right-hand, Ø range Groove D1 / D2: 3/4mm

Order data

| | |
|--------------|---------------|
| Order number | 270639 3/4 |
| GTIN | 2050002067073 |
| Item class | 24U |

Description
Version:

Coating: X800 (successor to coating GN39)

Attention:

Larger groove diameters can be achieved without modifications.

$D_1 = D_{\min}$ internal diameter.

$D_2 = D_{\min}$ external diameter.

Technical description

| | |
|------------------------------|---------------------------|
| Ø D | 4 mm |
| f | 2.2 mm |
| Groove width w | 0.5 mm |
| max. groove depth t_{\max} | 1.6 mm |
| Through-coolant | no |
| Ø D ₁ | 3 mm |
| Ø D ₂ | 4 mm |
| Manufacturer's designation | A2U4X800 |
| Type of product | Cutter insert for turning |

User data

Data sheet

| | Suitability | V_c | ISO code |
|-------------------------------|--------------------|----------------------|-----------------|
| Aluminium (short chipping) | suitable | 400 m/min | N |
| Alu > 10% Si | suitable | 240 m/min | N |
| Steel < 500 N/mm ² | suitable | 180 m/min | P |
| Steel < 900 N/mm ² | suitable | 130 m/min | P |
| INOX < 900 N/mm ² | suitable | 100 m/min | M |
| INOX > 900 N/mm ² | suitable | 70 m/min | M |
| Ti > 850 N/mm ² | suitable | 40 m/min | S |
| GG(G) | suitable | 110 m/min | K |
| CuZn | suitable | 210 m/min | N |
| continuous | suitable | | |
| irregular | suitable | | |
| wet maximum | suitable | | |