

**KOMET Unisix® indexable insert, BK8425, Designation type W29: 42-010****Order data**

Order number	216850 42-010
GTIN	2050001102607
Item class	24T

**Description****Suitable for :**

Indexable countersinking mill No. 216660.

ISO code indexable insert: WOEX 080404

Corner radius: 0.4 mm

**Technical description**

Designation	42-010
ISO code indexable insert	WOEX 080404
Corner radius	0.4 mm
Number of changes/inserts	3
Grade	BK8425
Tool material	Carbide
Type of product	Indexable insert for milling

**User data**

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	200 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	200 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	140 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	120 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	120 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	100 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	30 m/min	S
wet maximum	suitable		
dry	suitable only under restricted conditions		