

**KOMET® Unisix® indexable insert, BK8425, Designation type W29: 42-000****Order data**

Order number	236841 42-000
GTIN	4047109186187
Item class	24T

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

No. 236650; 236660; 236685; 236686

**Note:****The standard application values refer to the KUB Trigon®.**

Type: ST1400

ISO code indexable insert: WOEX 080404

Feed f in steel < 900 N/mm<sup>2</sup>: 0.16 mm/rev.**Technical description**

Designation	42-000
Feed f in steel < 900 N/mm <sup>2</sup>	0.16 mm/rev.
ISO code indexable insert	WOEX 080404
Grade	BK8425
Type	ST1400
Tool material	Carbide
Type of product	Indexable insert for drilling

## User data

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
Steel < 500 N/mm <sup>2</sup>	suitable	300 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	250 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	200 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	160 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	130 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	160 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	160 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	80 m/min	S
wet maximum	suitable		
dry	suitable only under restricted conditions		