

**KOMET® Unisix® indexable insert, BK8425, Designation type W29: 18-010****Order data**

Order number	236840 18-010
GTIN	4047109178137
Item class	24T

Description**Suitable for :**

No. 236630; 236635; 236650; 236685; 236686

Note:

The standard application values refer to the KUB Trigon®.

Type: ST1400

ISO code indexable insert: WOEX 040304

Feed f in steel $< 900 \text{ N/mm}^2$: 0.13 mm/rev.

Technical description

Designation	18-010
Feed f in steel $< 900 \text{ N/mm}^2$	0.13 mm/rev.
ISO code indexable insert	WOEX 040304
Grade	BK8425
Type	ST1400
Tool material	Carbide
Type of product	Indexable insert for drilling

User data

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