


**KOMET® indexable insert, BK8425, Designation type W83: 32-010**

**Order data**

Order number	236520 32-010
GTIN	4047109103481
Item class	24Q

**Description**
**Version:**

Ground on the circumference, with rounded cutting edge and sintered chip breaker.

**Note:**

**Application values refer to the KUB Quatron® 235500 – 235505.**

Type: Uni

ISO code indexable insert: SOEX 090408

Feed  $f$  in steel < 900 N/mm<sup>2</sup>: 0.2 mm/rev.

**Technical description**

Designation	32-010
Feed $f$ in steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
ISO code indexable insert	SOEX 090408
maximum cutting depth $a_{p,max}$ when slot milling from solid	1.1 mm
maximum cutting depth $a_{p,max}$ when side milling	1.1 mm
Number of changes/inserts	4

Grade	BK8425
Type	Uni
Tool material	Carbide
Type of product	Indexable insert for drilling

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable only under restricted conditions	600 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	300 m/min	N
Alu > 10% Si	suitable only under restricted conditions	250 m/min	N
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 only under restricted conditions	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
GG(G)	suitable only under restricted conditions	200 m/min	K
Uni	suitable		
wet maximum	suitable		