


KOMET® indexable insert, BK8425, Designation type W83: 13-010

Order data

Order number	236520 13-010
GTIN	4047109103399
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 050204

Feed f in steel $< 900 \text{ N/mm}^2$: 0.12 mm/rev.

Technical description

Designation	13-010
Feed f in steel $< 900 \text{ N/mm}^2$	0.12 mm/rev.
ISO code indexable insert	SOEX 050204
maximum cutting depth $a_{p\text{max}}$ when side milling	0.67 mm
maximum cutting depth $a_{p\text{max}}$ when slot milling from solid	0.67 mm
Series	KUB Quatron®

Number of changes/inserts	4
Grade	BK8425
Type	Uni
Tool material	Carbide
Type of product	Indexable insert for drilling

User data

	Suitability	V _c	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 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 only under restricted conditions	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
GG(G)	suitable only under restricted conditions	200 m/min	K
Uni	suitable		
wet maximum	suitable		

