

 KOMET**KOMET® indexable insert, BK7935, Designation type W83: 32-010****Order data**

Order number	236541 32-010
GTIN	4047109229594
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: ST900; Ti

ISO code indexable insert: SOEX 090408

Feed f in steel < 900 N/mm²: 0.2 mm/rev.

Technical description

Designation	32-010
Feed f in steel < 900 N/mm ²	0.2 mm/rev.
ISO code indexable insert	SOEX 090408
Number of changes/inserts	4
Grade	BK7935
Type	ST900; Ti

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 only under restricted conditions	160 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	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	80 m/min	S
Uni	suitable		
wet maximum	suitable		