


**KOMET® UniTurn® copying boring bar, right-hand, L<sub>2</sub> = 25 mm, Ø D<sub>min</sub>: 4mm**

**Order data**

Order number	240122 4
GTIN	4047109071117
Item class	24S

**Description**
**Version:**

Tool material = BK 82.

From size 5 with internal coolant supply; for smaller diameters, the coolant supply takes place through the toolholder.

**Technical description**

f	1.75 mm
max. groove depth t <sub>max</sub>	0.8 mm
a	3.7 mm
Suitable toolholder No. 240100	12/4; 16/4
Shank Ø d	4 mm
for bores from Ø D <sub>min</sub>	4 mm
Radius R	0.1 mm
maximum cutting depth a <sub>p,max</sub>	0.3 mm
Feed f in steel < 500 N/mm <sup>2</sup>	0.02 mm/rev.
Usable length	25 mm
Product name attribute	L <sub>2</sub> = 25 mm
Type of product	Cutter insert for turning

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	180 m/min	N
Aluminium (short chipping)	suitable	180 m/min	N
Alu > 10% Si	suitable	160 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	70 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	50 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	50 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	30 m/min	S
GG(G)	suitable	55 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		

## Accessories

KOMET UniTurn® turning toolholder for stationary use  
(without boring bar) Shank Ø d / Bore Ø d1 12/4 mm

240100 12/4

KOMET UniTurn® turning toolholder for stationary use  
(without boring bar) Shank Ø d / Bore Ø d1 16/4 mm

240100 16/4