KOMET

KOMET® UniTurn® grooving boring bar, right-hand, L2 = 15 mm, ∅ Dmin/ groove width w: 6/1,5mm

Order data

Order number	240154 6/1,5
GTIN	4047109072039
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	2.75 mm
a	5.7 mm
max. groove depth t_{max}	1.8 mm
Suitable toolholder No. 240100	12/8; 16/8
for bores from ∅ D_{min}	6 mm
Shank ∅ d	8 mm
Groove width w	1.5 mm
Through-coolant	yes
Feed f in steel < 500 N/mm^2	0.02 mm/rev.
Usable length	15 mm
Product name attribute	L_2 = 15 mm
Type of product	Cutter insert for turning

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	145 m/min	N
Aluminium (short chipping)	suitable	145 m/min	N
Alu > 10% Si	suitable	130 m/min	N
Steel < 500 N/mm²	suitable	80 m/min	P
Steel < 750 N/mm²	suitable	70 m/min	P
Steel < 900 N/mm²	suitable	65 m/min	P
Steel < 1100 N/mm²	suitable	55 m/min	P
Steel < 1400 N/mm²	suitable	55 m/min	P
INOX < 900 N/mm²	suitable	40 m/min	M
INOX > 900 N/mm²	suitable	40 m/min	M
Ti > 850 N/mm²	suitable	25 m/min	S
GG(G)	suitable	45 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 ∅ d / Bore ∅ d1 12/8 mm	240100 12/8
KOMET UniTurn® turning toolholder for stationary use (without boring bar) Shank ∅ d / Bore ∅ d1 16/8 mm	240100 16/8