

 KOMET

**KOMET® UniTurn® grooving boring bar, right-hand, L<sub>2</sub> = 10 mm, Ø D<sub>min</sub>/groove width w: 3/1mm**



## Order data

|              |               |
|--------------|---------------|
| Order number | 240150 3/1    |
| GTIN         | 4047109071469 |
| 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                                       | 1.25 mm                   |
| for bores from Ø D <sub>min</sub>       | 3 mm                      |
| max. groove depth t <sub>max</sub>      | 0.7 mm                    |
| Shank Ø d                               | 4 mm                      |
| Groove width w                          | 1 mm                      |
| a                                       | 2.7 mm                    |
| Suitable toolholder No. 240100          | 12/4; 16/4                |
| Through-coolant                         | yes                       |
| Feed f in steel < 500 N/mm <sup>2</sup> | 0.02 mm/rev.              |
| Usable length                           | 10 mm                     |
| Product name attribute                  | L <sub>2</sub> = 10 mm    |
| Type of product                         | Cutter insert for turning |

## User data

|                                | Suitability                               | V <sub>c</sub> | 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/mm <sup>2</sup>  | suitable                                  | 80 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 70 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 65 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 55 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 55 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 40 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 40 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | 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 Ø d / Bore Ø d1 16/4 mm

240100 16/4

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

240100 12/4