



Full profile insert 60°, internal, right-hand, HBX820, Pitch: 1,5mm

Order data

Order number	270784 1,5
GTIN	4045197982506
Item class	22B

Technical description

Tool material	Carbide
Thread pitch	15 mm
Internal/external application	inner
Application type	right-hand
Indexable insert profile	Full profile
Grade	HBX820
Tolerance class	DIN 13 6H
Thread type	MF
Thread type	M
Flank angle	60 degrees
Thickness	3.6 mm
Insert size L	16 mm
Type of product	Indexable insert for thread turning

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable	220 m/min	N

Alu > 10% Si	suitable	150 m/min	N
Steel < 500 N/mm ²	suitable	130 m/min	P
Steel < 750 N/mm ²	suitable	130 m/min	P
Steel < 900 N/mm ²	suitable	110 m/min	P
Steel < 1100 N/mm ²	suitable	85 m/min	P
Steel < 1400 N/mm ²	suitable	75 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	35 m/min	H
INOX < 900 N/mm ²	suitable only under restricted conditions	85 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	85 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG(G)	suitable	110 m/min	K
CuZn	suitable only under restricted conditions	130 m/min	N
continuous	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		