

**Full profile insert 55°, internal, right-hand, HBX820, TPI: 14****Order data**

Order number	270817 14
GTIN	4045197982582
Item class	22B

Technical description

Tool material	Carbide
Thread pitch	14 mm
Internal/external application	inner
Application type	right-hand
Indexable insert profile	Full profile
Grade	HBX820
Thread type	BSP
Thread type	BSW
Thread type	G
Flank angle	55 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		