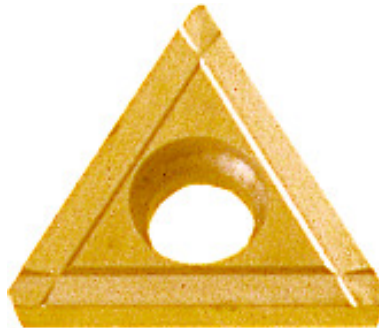


 KOMET**KOMET® indexable insert, BK8425, Designation: 14-6603****Order data**

Order number	216770 14-6603
GTIN	4047109180086
Item class	24T

Description**Version:**

With all-round chip breaker groove. With additional rake for free cutting. Clearance angle 15°.

Suitable for :

Countersinking mill No. 216600 and 216620.

Corner radius: 0.4 mm

ISO code indexable insert: TOHX 090204 EN

Technical description

ISO code indexable insert	TOHX 090204 EN
Corner radius	0.4 mm
Number of changes/inserts	1
Grade	BK8425
Tool material	Carbide
Type of product	Indexable insert for milling

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	250 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	250 m/min	N
Alu > 10% Si	suitable only under restricted conditions	120 m/min	N
Steel < 500 N/mm ²	suitable	250 m/min	P
Steel < 750 N/mm ²	suitable	200 m/min	P
Steel < 900 N/mm ²	suitable	200 m/min	P
Steel < 1100 N/mm ²	suitable	150 m/min	P
Steel < 1400 N/mm ²	suitable	120 m/min	P
INOX < 900 N/mm ²	suitable	120 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	100 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	100 m/min	S
GG(G)	suitable only under restricted conditions	150 m/min	K
wet maximum	suitable		
dry	suitable only under restricted conditions		