

# THREAD TURNING PROMO

**BUY 20**

**THREAD TURNING INSERTS**

(Size 11 mm / 16 mm / 22 mm)

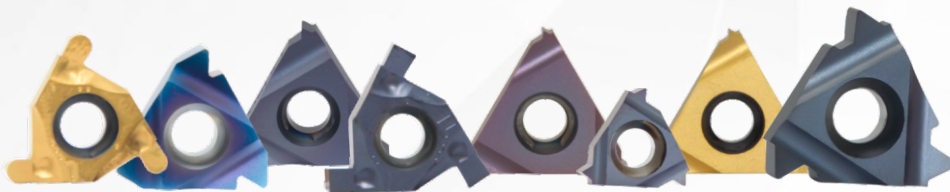
**OR GROOVING INSERTS**

(Size 11 mm / 16 mm)

**AND 1 SUITABLE HOLDER**

**AND GET**

**25 % ADDITIONAL  
DISCOUNT**



When ordering 20 thread turning inserts and/or grooving inserts (PU = 10 pieces) and a suitable holder, you will receive an additional discount of 25 %.

(10 x thread turning inserts +  
10 x grooving inserts are also possible.)

**Valid for all Standard Thread Turning Inserts,  
Ground / Type B / Type K  
for all profiles and coatings  
or Grooving Inserts, size 11, 16 and 22 mm.**

Excluded from the promotion are:  
V-Type / Z-Type / Multitooth Inserts

## Recommended cutting speed (m/min) for thread turning inserts

ISO Standard	Material		Condition				
				HBA	BLU	BMA	MXC
<b>P</b>	Non-Alloy Steel and Cast Steel, Free Cutting Steel	<0.25%C	Annealed		110-210	120-180	100-180
		≥0.25%C	Annealed				
		<0.55%C	Quenched & Tempered				
		≥0.55%C	Annealed				
	Low Alloy Steel and Cast Steel (less than 5% alloying elements)		Quenched & Tempered		90-140	80-130	70-120
	High Alloy Steel, Cast Steel, and Tool Steel		Annealed		70-90	60-80	55-70
<b>M</b>	Stainless Steel and Cast Steel		Ferritic / Martensitic		110-160	90-130	60-90
			Martensitic				
			Austenitic				
<b>K</b>	Cast Iron Nodular (GGG)		Ferritic / Pearlitic		120-150	100-130	80-110
			Pearlitic				
	Grey Cast Iron (GG)		Ferritic		140-150	120-130	90-100
			Pearlitic				
Malleable Cast Iron		Ferritic		110-140	100-130	80-100	
		Pearlitic					
<b>N</b>	Aluminum-Wrought Alloy		Not Cureable		250-500		200-400
			Cured				
	Aluminum-Cast, Alloyed	<=12% Si	Not Cureable		280-500		200-500
			Cured				
	Copper Alloys	>12% Si	High Temperature		190-350		150-250
			>1% Pb				
			Brass				
Non Metallic		Electrolytic Copper				200-300	
		Duroplastics, Fiber Plastics					
<b>S</b>	High Temp. Alloys, Super Alloys	Fe based	Annealed	20-80	30-65	25-60	
			Cured				
		Ni or Co based	Annealed				
			Cured				
	Titanium Alloys		Cast				
		Alpha +Beta Alloys Cured	30-60	40-50	35-45		
<b>H</b>	Hardened Steel		Hardened 45-50 HRc	30-60	40-50	35-45	
			Hardened 51-55 HRc				
			Hardened 56-62 HRc				
	Chilled Cast Iron		Cast	20-50	30-40	25-35	
Cast Iron		Hardened	20-40	20-30	15-25		