

THREAD TURNING PROMO

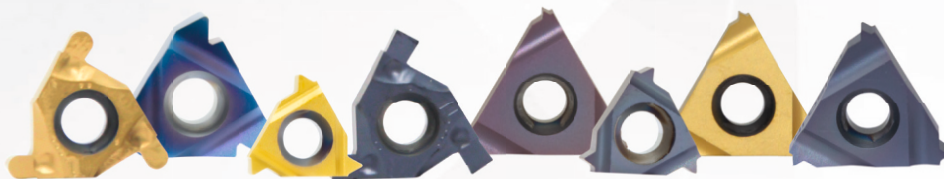
BUY **20**
THREAD TURNING INSERTS
or GROOVING INSERTS

(Size 11mm/16mm)

AND GET

**1 HOLDER
FOR FREE**

(SER 0808 – 3232/SIR 0010 – 0032)



When ordering 20 Thread Turning Inserts and/or 20 Grooving Inserts at the standard price,
you will receive a matching steel holder for free.

(10 x Thread Turning Inserts + 10 x Grooving Inserts are also possible.)

**Ground and coated Standard / Type B Thread Turning Inserts
as partial profile / ISO / UN / W / TR or
Grooving Inserts size 11 and 16 mm (pack size 10 pieces).**

**Valid for the following holder:
Standard External Steel Toolholder SER up to 3232 mm/
Standard Internal Steel Toolholder SIR up to 32 mm**

Excluded from the promotion are:

Type-K / V-Type / Z-Type / U-Type / Multitooth Inserts / Left-Hand Inserts



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

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