

THREAD TURNING PROMO

BUY **20**

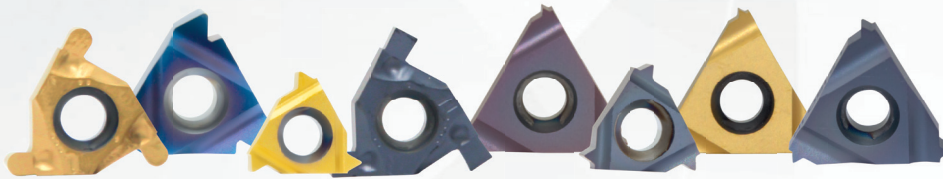
**THREAD TURNING INSERTS
or GROOVING INSERTS**

(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).**

Excluded from the promotion are:
Type-K / V-Type / Z-Type / U-Type / Multitooth Inserts / Left-Hand Inserts

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



Supervised by:

Please specify in your order the chosen
Thread Turning Inserts/Grooving Inserts,
the chosen Toolholder
and the promotion code:

TTH-24.

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					
	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	
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		280-500		200-500	
								Cured
			>12% Si					High Temperature
	Copper Alloys		>1% Pb		190-350		150-250	
								Brass
			Electrolytic Copper					
Non Metallic		Duroplastics, Fiber Plastics				200-300		
		Hard Rubber						
S	High Temp. Alloys, Super Alloys		Fe based	20-80	30-65	25-60		
								Annealed
								Cured
								Annealed
	Titanium Alloys		Ni or Co based					
			Cured					
		Cast						
		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			