

# THREAD TURNING PROMO

**BUY 20**

**THREAD TURNING INSERTS**

(Size 11 mm / 16 mm / 22 mm)

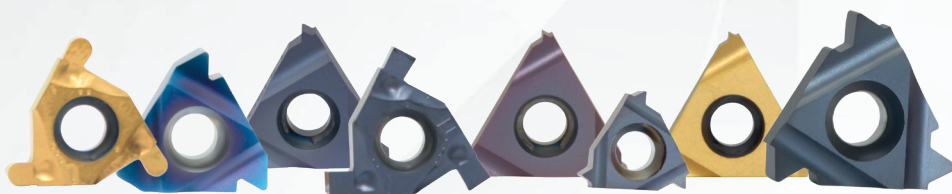
**OR GROOVING INSERTS**

(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	Insert				
				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				
			>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						
<b>S</b>	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		
<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		