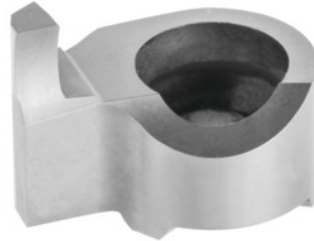


Garant
Rectangular profile cutter insert, HB720, Ø Dmin groove D1/D2: 8/14Lmm

Order data

Order number	273977 8/14L
GTIN	4062406127756
Item class	21H

Description
Attention:

Ordering size = minimum groove Ø.

Capable of cutting larger groove Ø without modification.

$D_1 = D_{\min}$ internal Ø.

$D_2 = D_{\min}$ external Ø.

L type with larger groove depth t_{\max} .

Technical description

Radius R	0.2 mm
Feed f	0.01 - 0.02 mm/rev.
Insert thickness T	10.7 mm
Tip centre offset L_3	9 mm
maximum cutting depth t_{\max}	5 mm
Groove width w	3 mm
Minimum pre-drill Ø D_{\min}	14 mm
Coating	TiCN

Grade	HB720
Type of product	Mini indexable insert

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	200 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	120 m/min	N
Alu > 10% Si	suitable only under restricted conditions	120 m/min	N
Steel < 500 N/mm ²	suitable	110 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	90 m/min	P
Steel < 1100 N/mm ²	suitable	90 m/min	P
Steel < 1400 N/mm ²	suitable	90 m/min	P
INOX < 900 N/mm ²	suitable	80 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	25 m/min	S
GG(G)	suitable	60 m/min	K
CuZn	suitable	100 m/min	N
continuous	suitable		
irregular	suitable only under restricted conditions		
interrupted	suitable only under restricted conditions		
wet maximum	suitable		