

**Garant**
**Round profile cutter insert, HB720, Ø Dmin groove D1/D2: 12/14mm**

**Order data**

Order number	273979 12/14
GTIN	4062406127763
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**

maximum cutting depth $t_{\max}$	1.5 mm
Radius R	0.5 mm
Feed f	0.01 - 0.02 mm/rev.
Tip centre offset $L_3$	9 mm
Insert thickness T	7.7 mm
Groove width w	1 mm
Minimum pre-drill Ø $D_{\min}$	14 mm
Coating	TiCN

Grade	HB720
Type of product	Mini indexable insert

## User data

	Suitability	V <sub>c</sub>	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 <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	90 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	60 m/min	M
Ti > 850 N/mm <sup>2</sup>	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		