

Garant
Round profile cutter insert, HB720, \varnothing Dmin groove D1/D2: 8/12Lmm

Order data

Order number	273975 8/12L
GTIN	4062406127978
Item class	21H

Description
Attention:

Ordering size = minimum groove \varnothing .

Capable of cutting larger groove \varnothing without modification.

$D_1 = D_{\min}$ internal \varnothing .

$D_2 = D_{\min}$ external \varnothing .

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

Technical description

Feed f	0.01 - 0.02 mm/rev.
Radius R	1 mm
Tip centre offset L_3	9 mm
maximum cutting depth t_{\max}	5 mm
Insert thickness T	10.7 mm
Groove width w	2 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		