

Garant
Micro boring-out insert, internal, right-hand, L1 = 6 mm, Ø Dmin: 1 mm


Order data

Order number	270510 1
GTIN	4045197802118
Item class	21I

Description

Application:

For cutter holder No. 270200 – 270204.

Technical description

Radius R	0.1 mm
Shank Ø d	4 mm
maximum cutting depth $t_{\max}$	0.15 mm
Tip centre offset L_3	0.49 mm
Minimum Ø $D_{\min}$	1 mm
Feed f in steel < 1100 N/mm ²	0,015 mm/rev.
Feed f in stainless steel < 900 N/mm ²	0,015 mm/rev.
Feed f in stainless steel > 900 N/mm ²	0,015 mm/rev.
Series	Micro
Overhang L_1	6 mm
Product name attribute	$L_1 = 6$ mm
Type of product	Cutter insert for turning

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	250 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	200 m/min	N
Steel < 500 N/mm ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	150 m/min	P
Steel < 900 N/mm ²	suitable	150 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable	60 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	30 m/min	H
INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	30 m/min	S
GG(G)	suitable	90 m/min	K
CuZn	suitable	150 m/min	N
continuous	suitable		
irregular	suitable only under restricted conditions		
interrupted	suitable only under restricted conditions		
wet maximum	suitable		