

**Garant**
**Boring-out insert, internal, right-hand, L1 = 21 mm, Ø Dmin: 4,2mm**

**Order data**

Order number	270516 4,2
GTIN	4045197802231
Item class	21I

**Description**
**Application:**

For cutter holder No. 270200 – 270204.

Shank Ø d: 4 mm

Tip centre offset  $L_3$ : 1.95 mm

maximum cutting depth  $t_{max}$ : 0.3 mm

Radius R: 0.15 mm

**Technical description**

Shank Ø d	4 mm
maximum cutting depth $t_{max}$	0.3 mm
Minimum Ø $D_{min}$	4.2 mm
Tip centre offset $L_3$	1.95 mm
Radius R	0.15 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.020 mm/rev.
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0,015 mm/rev.
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0,015 mm/rev.
Overhang $L_1$	21 mm
Product name attribute	$L_1 = 21$ mm
Type of product	Cutter insert for turning

## User data

	Suitability	V <sub>c</sub>	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 <sup>2</sup>	suitable	160 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	150 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	30 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	90 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	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		