

Garant**Carbide inserts for axial grooving right-hand, Ø Dmin groove D1/D2: 8/12mm**

Order data

Order number	274054 8/12
GTIN	4062406236007
Item class	21L

Description

Version:

With through-coolant and additional flank face cooling.

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

Tip centre offset L_3	1.7 mm
Feed f	0.01 - 0.03 mm
maximum cutting depth $t_{\max}$	15 mm
Groove width w	2 mm
Overall length L	64 mm
Shank Ø D_s	6 mm
Through-coolant	yes
Type of product	Cutter insert for turning

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	50 m/min	N
Aluminium (short chipping)	suitable	90 m/min	N
Alu > 10% Si	suitable	70 m/min	N
Steel < 500 N/mm ²	suitable	55 m/min	P
Steel < 750 N/mm ²	suitable	55 m/min	P
Steel < 900 N/mm ²	suitable	50 m/min	P
Steel < 1100 N/mm ²	suitable	40 m/min	P
Steel < 1400 N/mm ²	suitable	35 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	45 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	45 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	25 m/min	S
GG(G)	suitable only under restricted conditions	55 m/min	K
CuZn	suitable only under restricted conditions	50 m/min	N
continuous	suitable		
wet maximum	suitable		