

Garant
Carbide inserts for axial grooving left-hand, Ø Dmin groove D1/D2: 12/20mm

Order data

Order number	274056 12/20
GTIN	4062406239114
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} .

Through-coolant: yes

Shank Ø D_s : 8 mm

Groove width w : 4 mm

Tip centre offset L_3 : 1.6 mm

Overall length L : 80 mm

maximum cutting depth t_{max} : 43 mm

Feed f : 0.01 - 0.03 mm

Technical description

Tip centre offset L_3	1.6 mm
-------------------------	--------

Groove width w	4 mm
maximum cutting depth t_{\max}	43 mm
Feed f	0.01 - 0.03 mm
Overall length L	80 mm
Shank $\varnothing D_s$	8 mm
Through-coolant	yes
Type of product	Cutter insert for turning

User data

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

