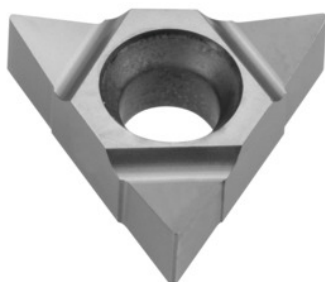


Garant**Thread milling insert for internal threads 60°, HB7720, Pitch: 2,5-4,0mm**

Order data

Order number	218122 2,5-4,0
GTIN	4062406245306
Item class	21D

Description

Version:

Insert size 11.

Application:

For metric internal threads with 60° flank to DIN / ISO R 262 (DIN 13).

Technical description

Thread pitch	2.5 - 4 mm
Full profile	no
Internal/external application	Internal
Coating	TiCN
suitable for threads	M30×2.5; M30×3
Number of cutting edges Z	1
Grade	HB7720
Tool material	Carbide
Flank angle	60 degrees

Insert size	11 mm
Feed f_z in steel < 1100 N/mm ²	0.1 mm
Feed f_z in INOX < 900 N/mm ²	0.03 mm
Cutting direction	right-hand and left-hand
Type of product	Cutter insert for milling

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	140 m/min	N
Aluminium (short chipping)	suitable	120 m/min	N
Alu > 10% Si	suitable	80 m/min	N
Steel < 500 N/mm ²	suitable	120 m/min	P
Steel < 750 N/mm ²	suitable	110 m/min	P
Steel < 900 N/mm ²	suitable	100 m/min	P
Steel < 1100 N/mm ²	suitable	80 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	60 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	80 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	70 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG(G)	suitable only under restricted conditions	70 m/min	K
CuZn	suitable	120 m/min	N
Uni	suitable		
wet maximum	suitable		

