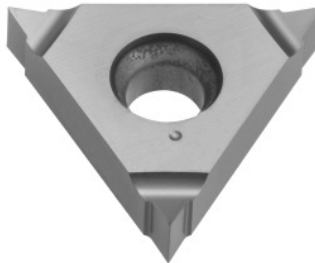


**Garant**
**Thread milling insert for internal threads 60°, HB7720, Pitch: 1,5-2,0mm**

**Order data**

Order number	218124 1,5-2,0
GTIN	4062406245313
Item class	21D

**Description**
**Version:**

Insert size 16.

**Application:**

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

**Technical description**

Internal/external application	Internal
Full profile	no
Thread pitch	1.5 - 2 mm
Coating	TiCN
suitable for threads	M39×1.5; M39×2
Number of cutting edges Z	1
Grade	HB7720
Tool material	Carbide
Flank angle	60 degrees

Insert size	16 mm
Feed $f_z$ in steel < 1100 N/mm <sup>2</sup>	0.1 mm
Feed $f_z$ in INOX < 900 N/mm <sup>2</sup>	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 <sup>2</sup>	suitable	120 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	100 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	80 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	70 m/min	M
Ti > 850 N/mm <sup>2</sup>	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		

