

Garant
Thread milling insert, HB7720, Threads per inch: 11-7

Order data

Order number	218131 11-7
GTIN	4062406245375
Item class	21D

Description
Version:

Insert size 11.

Application:

For internal and external threads with 55° flank to standard BS 84: 1956, DIN 259, ISO 228/1: 1982.

Cutting direction: right-hand and left-hand

Feed f_z in INOX < 900 N/mm²: 0.03 mm

Technical description

Coating	TiCN
Threads per inch	7 - 11
Internal/external application	External
Internal/external application	Internal
Thread pitch	2,309 mm
suitable for threads	7/8-11; 3/4-10; 7/8-9; 1-8
Number of cutting edges Z	1

Grade	HB7720
Tool material	Carbide
Flank angle	55 °
Insert size	11 mm
Feed f_z in steel < 1100 N/mm ²	0.05 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	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	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