

**Garant**
**Carbide inserts for axial grooving left-hand,  $\varnothing$  Dmin groove D1/D2: 8/12mm**

**Order data**

Order number	274057 8/12
GTIN	4067263036555
Item class	21L

**Description**
**Version:**

With through-coolant and additional flank face cooling.

**Attention:**

Order size = minimum groove  $\varnothing$ .

Larger groove diameters can be achieved without modification.

$D_1 = D_{\min}$  internal diameter.

$D_2 = D_{\min}$  external diameter.

L version with greater grooving depth  $t_{\max}$ .

**Technical description**

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

**User data**

	<b>Suitability</b>	<b>V<sub>c</sub></b>	<b>ISO code</b>
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 <sup>2</sup>	suitable	55 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	45 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	45 m/min	M
Ti > 850 N/mm <sup>2</sup>	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		