

Garant
Milling insert 60°, HB7720, Pitch: 1-4mm

Order data

Order number	217281 1-4
GTIN	4045197216786
Item class	21C

Description
Note:

Corrected profile threading inserts eliminate the need to program a correction to the diameter. Therefore use these inserts only for the specified thread sizes.

When using the circular mill No. 217252 size 18L and 18XL, the partial profile insert No. 217281 size 1–4 can be used only up to pitch 3.0.

Technical description

Depth t	2.308 mm
for threads \geq	M20
Insert geometry	Partial profile
External \varnothing D	16 mm
Number of clamping slots	6
maximum thread pitch	4 mm
Thread pitch	1 mm
Application	Internal and external

Grade	HB7720
Tool material	Carbide
Thread type	MF
Thread type	M
Thread type	MF-LH
Thread type	M-LH
Flank angle	60 degrees
Type	P16
Number of cutting edges Z	6
Cutting direction	right-hand and left-hand
Type of product	Cutter insert for circular milling

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	500 m/min	N
Aluminium (short chipping)	suitable	400 m/min	N
Alu > 10% Si	suitable	250 m/min	N
Steel < 500 N/mm ²	suitable	250 m/min	P
Steel < 750 N/mm ²	suitable	180 m/min	P
Steel < 900 N/mm ²	suitable	120 m/min	P
Steel < 1100 N/mm ²	suitable	120 m/min	P
Steel < 1400 N/mm ²	suitable	100 m/min	P
Steel < 55 HRC	suitable	60 m/min	H
Steel < 60 HRC	suitable	45 m/min	H
Steel < 65 HRC	suitable	35 m/min	H
Steel < 67 HRC	suitable	30 m/min	H
INOX < 900 N/mm ²	suitable	120 m/min	M
INOX > 900 N/mm ²	suitable	120 m/min	M

Ti > 850 N/mm ²	suitable	80 m/min	S
GG(G)	suitable	180 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		