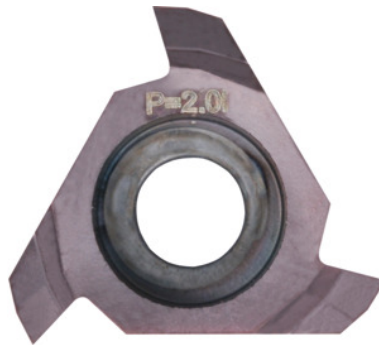


Garant**Milling insert 60°, HB7720, Pitch: 1mm****Order data**

| | |
|--------------|---------------|
| Order number | 217279 1 |
| GTIN | 4045197542984 |
| 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

| | |
|--------------------------|--------------|
| for threads \geq | M12×1 |
| Depth t | 0.57 mm |
| Insert geometry | Full profile |
| External \varnothing D | 9.6 mm |
| Number of clamping slots | 3 |
| Thread pitch | 1 mm |
| Application | Internal |
| Grade | HB7720 |

| | |
|---------------------------|------------------------------------|
| Tool material | Carbide |
| Thread type | MF |
| Thread type | M |
| Thread type | MF-LH |
| Thread type | M-LH |
| Flank angle | 60 degrees |
| Type | P12 |
| Number of cutting edges Z | 3 |
| 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 | | |